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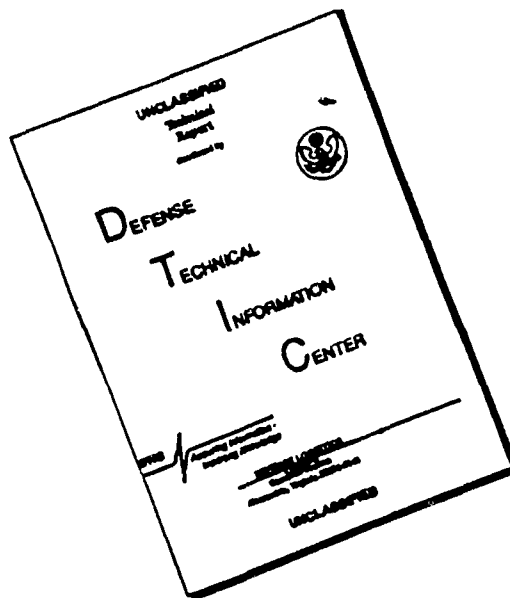
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Memo To: MASE  
MAB

11 April 1989

Subject: Technology Insertion (TI) Project

1. I attended a TI Technical Coordination meeting at McDonnell Douglas Missile System Company (MDMSC), St. Louis, Mo. from 28-30 Mar 89. The attached MAWF memo gives full details on attendees and agenda items.
2. MDMSC personnel returned to OC-ALC/Tinker AFB on 31 Mar 89 to resume gathering data for TASK Order #1 (Process Characterization). Their target completion date for this phase has been extended to Sept 89, however, MDMSC has agreed to complete the MAEPAB Sheetmetal Shop Process Characterization through experimentation by 15 Jun 89 to facilitate our planned move. MDMSC began work on the additional information for MAEPAB on 3 Apr 89. Attached is the first week status report completed by MDMSC representatives indicating a start and due date for each required profile element.
3. MDMSC Deputy Program Manager, Lou Mavros and Model Development and Experimentation Manager, Mike McCoy plan to visit Tinker AFB on 12 and 13 April. (See attached MDMSC Organization Chart). We have scheduled time on MAB calendar to meet with them at 14:00 hours 13 Apr 89. They have a program briefing and can answer questions on the simulation model.

*Earl E. Stamps*  
EARL E. STAMPS, Chief  
MISTR Planning Resources &  
Standards Unit

3 Atch

1. MAWF Memo, 3 Apr 89
2. MAEPAB Status, 7 Apr 89
3. MDMSC TI Org Chart

## **TECHNOLOGY INSERTION**

### **EARL'S WISH LIST**

- DECREASE FLOW TIMES
- DECREASE SPACE REQUIREMENT
- DECREASE LABOR HOURS
- INCREASE OUTPUT
- IMPROVE CONTROL/ORG. STRUCTURE

**E. STAMP**  
**07 JUNE 1989**

**AFLC/MDMSC**

## ***TECHNOLOGY INSERTION***

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### **PROBLEM STATEMENT:**

**HOW TO RELOCATE MABPAB (SHEETMETAL SHOP) FROM**

**ITS CURRENT 95,000sq ft. FACILITY TO A 60,000 sq ft.**

**FACILITY AND MAINTAIN FY-90 WORKLOAD & SURGE CAPACITY**

**E. STAMP**

**07 JUNE 1989**

***AFLC/MDMSC***

## EXECUTIVE SUMMARY.

### BACKGROUND

#### RELOCATION OF MABPAB SHEET-METAL SHOP

- After the Nov 84 Fire the sheet-metal shop moved to building 95.
- DS warehouse at 98% SATURATION
- CC INSTRUCTED MA to VACATE MABPAB by Sep 89.
- MA Directed establishment of a Facility Plng. Group.
- Relocation of MABPAB to building 2101
- Current space in Bldg 95 is 95,000 SF
- Available space in Bldg 2101 is 61,000 SF.

# MABPAB

## OVERVIEW

THE SHEET METAL BACK SHOP RELOCATED TO BLDG 95

AFTER THE NOV 84 FIRE. AND SHARED SPACE WITH:

MABPAB	101,634	SF
DFS SUPPLY	460	SF
SAC ENGINES	13,255	SF
(QUALITY) MAQBA	128	SF
ADMIN	1444	SF
RESTROOMS	1338	SF
UTILITY	541	SF

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118,800 SF

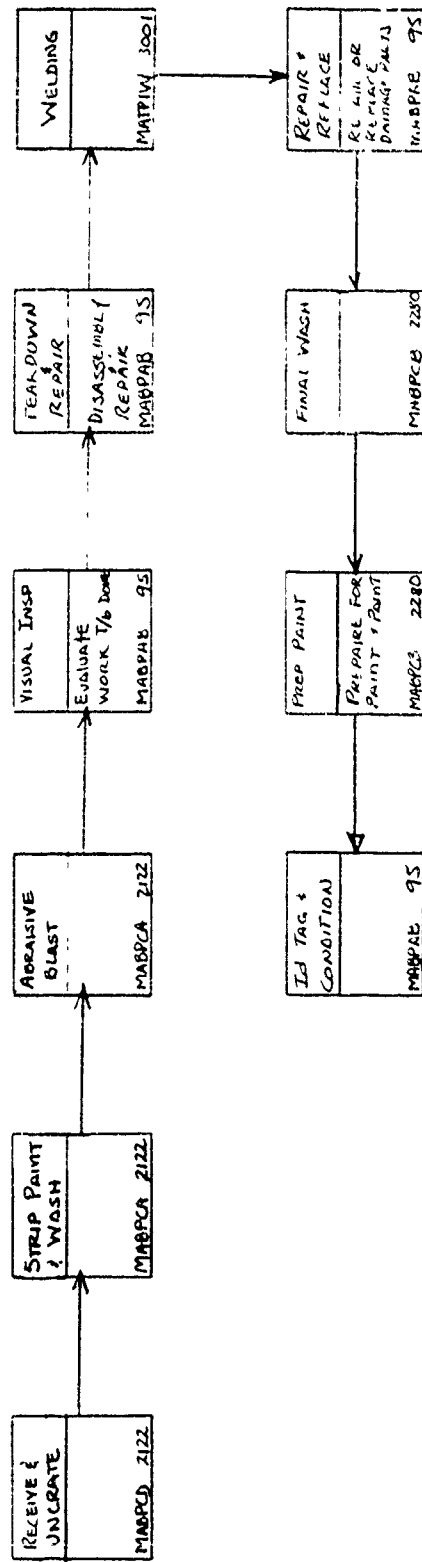
101,634 SF INCLUDES PRODUCTION AREA OF 56,753 SF  
AND PRODUCTION STORAGE 45,259 SF. (TEMPORARY STORAGE)

MABPAB RESTORE PARTS FOR KC 135 AIRCRAFT. THE  
80/20 LIST INCLUDES END ITEMS LIKE:

- COWL (RH & LH PANEL)
- NOSE COWL
- FLAPS / FORE FLAPS
- AILERONS
- DOOR (MLG)
- TAIL CONE
- SLEEVE
- FAIRINGS

# MABPAB PROCESS CHARACTERIZATION.

SIDE COWL PANEL



Equipment

# MABPAB FIXTURES

## FLIGHT CONTROLS

NAME	PART NO.	QTY	APPLICATION
FILLET FLAP	SC65-1062T1	1	E3A/135
RUDDER	590CJ1130	1	E3A/135
INBD FLAP	SC65-106311	1	E3A
LH/RH ELEVATOR	SC5-96190T1	1	E3A
LH/RH ELEVATOR	590CJ1120	1	135
INBD AILERON	590CJ1010	3	E3A/135
OTBD MAIN FLAP	590CJ1030	1	E3A/135
INBD MAIN FLAP	590CJ1020	1	135
OTBD SPOILER	590CJ1060	1	E3A/135
INBD SPOILER	590CJ1050	1	E3A/135
OTBD AILERON	590CJ1000	3	E3A/135

## DOORS

OTBD MLG	590CJ1110	4	E3A/135
INBD MLG	590CJ1100	4	E3A/135

## MISC

HOG NOSE FAIRING	65-10607-46	1	135
OTBD ENG STRUT	590CJ1150	1	135
INBD ENG STRUT	590CJ1140	1	135
BOTTOM PANEL TF33 P9	FAJ64-8327-621	1	135
TAIL CONE	762/259	1	135
KNEE CAP FAIRING	TJ5-85654	1	135
BOOM POD FAIRING		1	135
NOSE WHEEL FAIRING	2FAJ5-73139-1	1	135
NOSE WHEEL FAIRING	FRJ5-73139-1	1	135
NOSE WHEEL FAIRNG	FAJ5-73139-1	1	135

## COWLING

RH SIDE COWL	SC65-2549T	1	E3A
LH SIDE COWL	SC65-2549T1	1	E3A
RH SIDE COWL J57	3AJ5-85638	2	135
LH SIDE COWL J57	3AJ5-85637	2	135
RH SIDE COWL TF33P5	OC75-64-8327-438	1	135
LH SIDE COWL TF33P5	OC75-64-8327-487	1	135
NOSE COWL	204-70099-3ASMJ	1	E3A
NOSE COWL	204-70099-TRMJ	1	E3A
NOSE COWL J57	AJ5-85655	1	135



# MABPAB EQUIPMENT

NAME	MODEL #/TYPE	QUANTITY
BENDING MACHINE (HAND)	416	1
LARGE BAND SAWS		2
ROTEX PUNCH PRESS		1
DRILL (FLOOR MODEL)	1200-118	1
GRINDER FLOOR MODEL, 2 WHEEL ELECT.		1
PRESS BRAKE (CHICAGO STEEL CO.)	000323	1
POWER SQUARING MACHINE	002741	1
PRESS BRAKE	4560G	1
SMALL METAL SHEAR	241-C	1
SMALL DRILL PRESS		1
GRINDER 1 WHEEL, FLOOR MODEL	WG6566	1
PUNCH PRESS	P41P	1
SANDER (BELT) FLOOR MODEL		1
BENDING MACHINE (HAND)	BB-316	1

# MABPFF FIXTURES

NAME	PART NO.	QTY
ELEV/RUDDER BALANCE	RP046	1
BOMB BAY DOOR (LARGE)	FME35-30600-3	2
BOMB BAY DOOR (LARGE)	FME35-30600-1	2
BOMB BAY DOOR (LARGE)	FME35-30600-2	2
BOMB BAY DOOR (SMALL)	AJ5-46867-3	1
BOMB BAY DOOR (SMALL)	AJ5-46867-4	2
BOMB BAY DOOR (SMALL)	AJ5-46868-28	1
BOMB BAY DOOR (SMALL)	AJ5-46868-27	1
BOMB BAY DOOR (SMALL)	AJ5-46867-3	1

# MABPFF EQUIPMENT

NAME	MODEL #/TYPE	QUANTITY
DOUBLE SANDER DISK (FLOOR MODEL)		1
DRILL PRESS (FLOOR MODEL)		4
GRINDING MACHINE	WISSOTA E8M	1
WELDER	MILLER 330ST	1
BRAKE, MECH		1
BRAKE, MECH FORMING ROLLER	0617	2
BRAKE, HAND	NATIONAL	2
METAL STREACHER (FLOOR MODEL)		1
PRESS ARBOR	FAMCO	2
PUNCH, MECH	ROTEX	1
POWER SHEAR	MASPERI CM500A	1
DIMPLER	300	1
BRAKE PRESS	65M75	1
DOALL SAW	3613-2	1

# FY90

## EQUIPMENT PROFILE

CODE	DESCRIPTION	1 <sup>st</sup>	2 <sup>d</sup>	3 <sup>rd</sup> - SHIFT	END ITE.
25	BENCH/WORK STA	13	15	13	15025A
113	"	13	13	13	15113A
119	"	3	3	3	15119A/15219A
126	"	3	3	3	15126A/15300A
136	"	6	6	6	15136A/15137A
140	"	7	7	7	15140A
150	"	18	18	18	15150A
175	"	3	3	3	15175A
178	"	5	5	5	15178A
188153	"	6	6	6	→ { 15188A / 15189A 15191A / 15192A
188154	"	6	6	6	→ { 15188ASUB1 / 15189ASUB1 15191ASUB1 / 15192ASUB1
236		4	4	4	15236A
249		7	7	7	15250A/1524

Phone Conversation w/ Larry

6/1/89

# FIXTURE PROFILE

CODE	Noun	QUANTITY			END ITEM
		1 <sup>st</sup>	2 <sup>d</sup>	3 <sup>rd</sup>	
F 335-02		1	1	1	
F 135-01		1	1	1	
✓ F 335-03		2	2	2	15136A / 15137A
335-04		1	1	1	15188A / 15189A
135-02		1	1	1	15191A / 15192A
335-05		1	1	1	
✓ 335-07		1	1	1	15249A / 15250A
✓ " -08		3	3	3	15119A / 15321A
✓ " -09		3	3	3	
135-04		1	1	1	
135-05		1	1	1	
135-06		1	1	1	
135-07		1	1	1	
" -08*		1	1	1	15140A
" -09		1	1	1	
" -10		1	1	1	
" -11		1	1	1	
" -12		1	1	1	
" - <del>18</del>		3	3	3	15175A
" -13		2	2	2	15113A
" -14		2	2	2	15025A
" -15		1	1	1	
" -16		1	1	1	
✓ F 335-10		3	3	3	15188ASub1 / 15189ASub1

CODE	NOUN	1 <sup>s</sup>	2 <sup>d</sup>	3 <sup>r</sup>	FIXTURES PROFILE CONT END ITEM.
FE3A-05		1	1	1	
" -06		1	1	1	
F135-17		1	1	1	15150A

MANPOWER.

# FY 89 MANPOWER REQUIREMENTS (PE'E)

	<u>QTR 1</u>	<u>QTR 2</u>	<u>QTR 3</u>	<u>QTR 4</u>	<u>FY TOTAL</u>
MABPAB	287 <del>296</del>	296 <del>260</del>	298 <del>13</del>	298 <del>206</del>	295 <del>24</del>
MABPIF	88 <del>14</del>	83 <del>17</del>	85 <del>14</del>	85 <del>15</del>	85 <del>11</del>
MABPCA * INPUT/STRIP	24	24	25	25	24
MABPCB * PAINT	14	14	14	14	14
MABPCD * REC/UNCREAT	3	3	3	3	3

\* MISTR PE'S ONLY



# SKILL CODES

U163806 - (10)

MABPAB	AS	LEFT HAND SIDE COWL
	BS	RIGHT HAND SIDE COWL
	CS	NOSE COWL
	DS	FLAPS
	ES	FLIGHT CONTROLS
	FS	MISC
	GS	DOOR SHOP
	HS	FLIGHT CONTROL } ————— CMT PROPOSAL
MABPFF	AS	SPOILERS, HATCHES, TIP GEAR, POP-UP
		ANTENNA, SUPPLY B/B DOORS
	WS	FLAPS, RUDDERS, ELEVATORS
	YS	NOSE COWL, SIDE COWL
	3S	PDM
MABPCA	WL	EQUIPMENT CLEANERS
MABPCB	B3	PAINTERS
MABPCD	MQ	MOVERS
	CQ	CRANE OPERATORS
	EQ	CHECKERS

# FY90

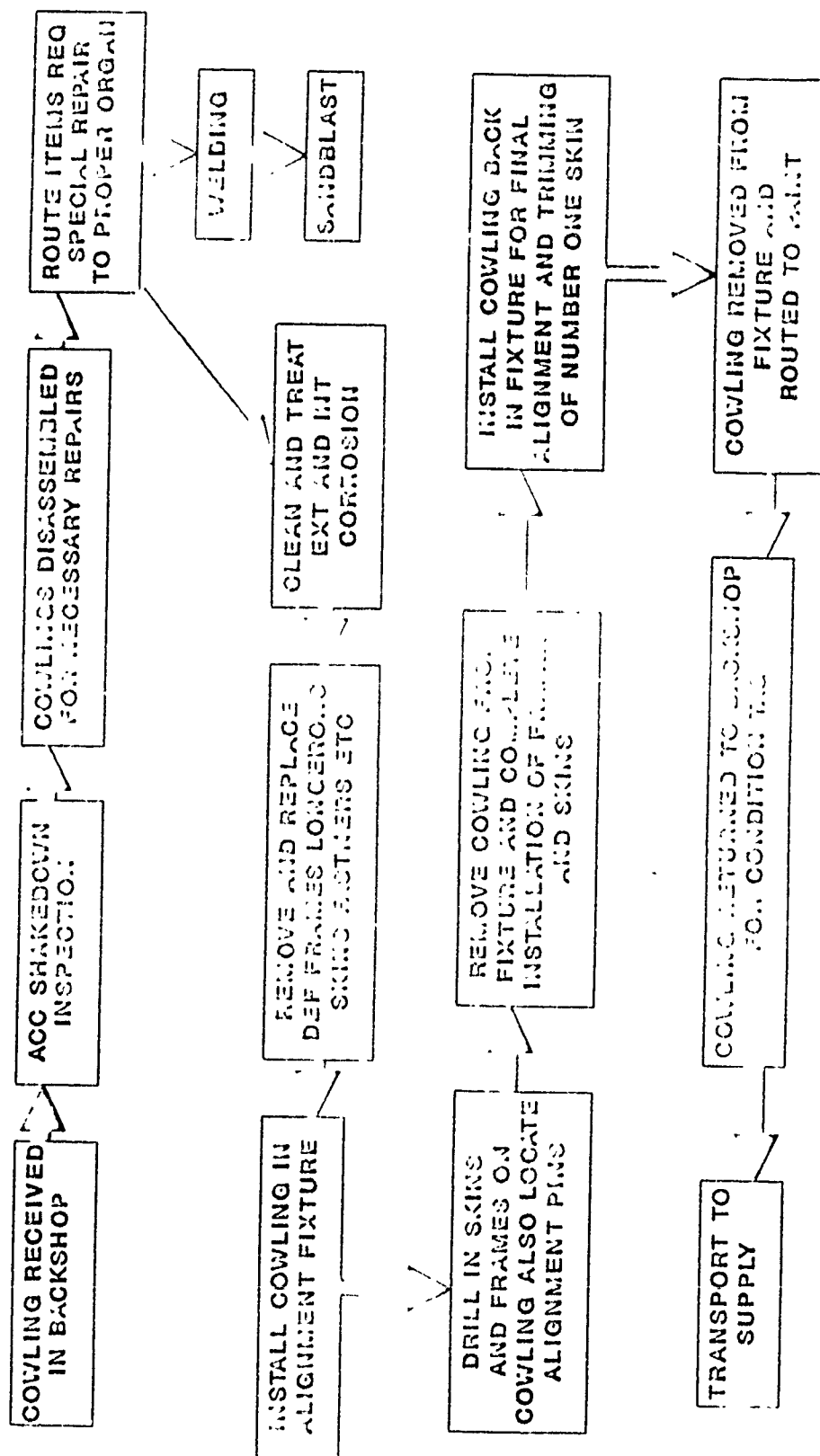
## MAN-POWER

	Quantity				FACTOR			
	1 <sup>st</sup>	2 <sup>d</sup>	3 <sup>rd</sup>	4 <sup>th</sup>	1 <sup>st</sup>	2 <sup>d</sup>	3 <sup>rd</sup>	4 <sup>th</sup>
AS	13	18	16	17	5.0	5.3	6.1	5.9
BS	14	16	15	16	"	"	"	"
CS	10	16	16	12	"	"	"	"
DS	7	9	8	8	"	"	"	"
ES	75	72	72	71	"	"	"	"
FS	78	78	78	80	"	"	"	"

Phone Conversation w/ Larry

6/1/89

# FLOW CHART SIDE COWL REPAIR SHOP



# GENERAL PRODUCT FLOW

STEP

- 1 ITEMS ARE RECEIVED & UNCRATED OUTSIDE Bldg. 2122 by MABPCD
- 2 MOVED TO INSIDE TO STRIP PAINT / BLAST /  
By MABPCA.
- 3 MOVED TO BUILDING 95 FOR SHAKEDOWN INS (3 miles)
- 4 IF NEEDED WELDING MOVED TO Bldg 3001 (2 m  
MOVE TO BLDG 95  
IF NEEDED BLAST / WASH MOVE TO 2122 (MABPCD)
- 5 DISASSEMBLY FOR REPAIR
- 6 IF NEED CLEANING OR INTERNAL BLASTING  
MOVED TO BLDG 2122
- 7 CLEAN TREAT FOR CORROSION
- 8 { INSTALL ON FIXTURE
- 9 { R/R DEFECTIVE PARTS (SKINS, LONGERONS, RIBS, PLATES
- 8 { (R/R: DRILL, FILE, ALIGNMENT, SHOT- BUCK RIVETS)
- 10 { REMOVE FROM FIXTURE . PLACE PART ON STA.
- 11 { COMPLETE ASSY.
- 9 12 ROUTE TO PAINT SHOP . BLDG 2280  
CLEAN & PAINT by MABPCB
- 10 13 MOVE TO SHEET METAL . FOR ID : TAG  
Bldg 95 . TAG : CONDITIONING by MABPAB
- 11 14 MOVE TO STORAGE / SUPPLY.

SEE FLOW

IMPROVE FLOW

DISASSY. TO THE LOWEST END ITEM

RECIEVE & UNCRATE

STRIP PAINT / BLAST / WASH

INSPECT FOR CRACKS

ROUTE IF NEED WELDING

ROUTE TO SHEET METAL SHOP

DISASSY FOR REPAIR

IN HOUSE CLEANING / BLASTING

R/R DEFECTIVE PARTS

IN HOUSE WASH / PAINT

TAG & CONDITIONING.

SEE FLOW

"MISTR" SHEETMETAL REPAIR

FY-89

SCOPE

STRUCTURAL & SHEETMETAL BACKSHOP  
OVERHAUL REPAIR OF B-52, -135, E-3A & B1  
EXCHANGEABLES INCLUDE ENGINE COMILING,  
FLIGHT CONTROL SURFACES, FAIRINGS, TABS,  
DOORS, HATCHES, ENGINE SLEEVES & ENGINE STRUTS

173 ITEMS

1328 PIECES/CTR

WORKLOAD

427,826	DPSH	(PROGRAMMED MISTR)
97,189	DPSH	(PROGRAMMED PDM)
19,787	DPSH	(UNPROGRAMMED - FAM JOBS)

544,802 TOTAL

412,099	DPSH	-135 & E3A BACKSHOP (MADPF, - BLDG 95)
132,703	DPSH	B-52 BACKSHOP (MADPF, - BLDG 2121)

MABPAB - (135)

MISTR Production Numbers - 197

	<u>MANHOURS</u>	<u>PERCENT</u>
MISTR	334,914	81
PDM	68,963	17
TEMPORARY	<u>8,222</u>	<u>2</u>
	412,099	100

MABPFF - (B52)

MISTR Production Numbers - 51

	<u>MANHOURS</u>	<u>PERCENT</u>
MISTR	92,912	70
PDM	28,226	21
TEMPORARY	<u>11,565</u>	<u>9</u>
	132,703	100



# MISTR ENGINEERED COVERAGE

48 ITEMS = 72% <sup>Total</sup> PROJECTED WORKLOAD

MABPAB    26 ITEMS  
            25 ENGINEERED    -  
            1 NON-ENGINEERED

MABPFF    22 ITEMS  
            19 ENGINEERED  
            3 NON-ENGINEERED

→ WORK SAMPLE  
Block of OPS

NAME:

ALC: OC

PLC: MABPAB

AST NAME

ITEM NUMBER	WCD #	WL TYPE	HIST F. TIME	STAND HOURS	EXPECT HOURS
15025A	15025A	4		151.0	
15113A	15113A	4		147.	
15119A	15119A	4		89.15	
15121A	15119A	4		90.24	
15126A	15126A	4		88.	
15126A	15126A	4		98.1	
15136A	15136A	4		7.18	
15137A	15136A	4		9.18	
15140A	15140A	4		51.65	
15150A	15150A	4		85.15	
15175A	15175A	4		73.86	
15178A	15178A	4		18.97	
15188A	15153A	4		120.7	
15189A	15153A	4		120.7	
15188A	15154A	4		15	
15189A	15154A	4		15	
15191A	15151A	4		118.7	
15192A	15151A	4		118.7	
15191A	15152A	4		15	
15192A	15152A	4		15	
15236A	15236A	4		121.6	
15237A	15237A	4		29.6	
15249A	15249A	4		110.5	
15250A	15249A	4		111	
15237A	15236B	4		18.6	

# FLOW DAY STUDY SUMMARY SHEET

	<u>QUEUE</u> <u>HOURS</u>	<u>STD</u> <u>HRS.</u>
RECEIVE 2122		
PROCESS SUPPORT	4	
UNCRATE 2122		
PROCESS SUPPORT	4	16
WASH/STRIP 2122		
PROCESS SUPPORT	4	
MOVE 95		
PROCESS SUPPORT	4	
SHAKEDOWN 95		
PROCESS SUPPORT	5	
OVERH UL 95		
PROCESS SUPPORT	7	
MOVE 2280	8	22
PROCESS SUPPORT	8	
WASH/PAINT 2280		10
PROCESS SUPPORT	7	
MOVE 95		
PROCESS SUPPORT	5	
TOTAL	48	

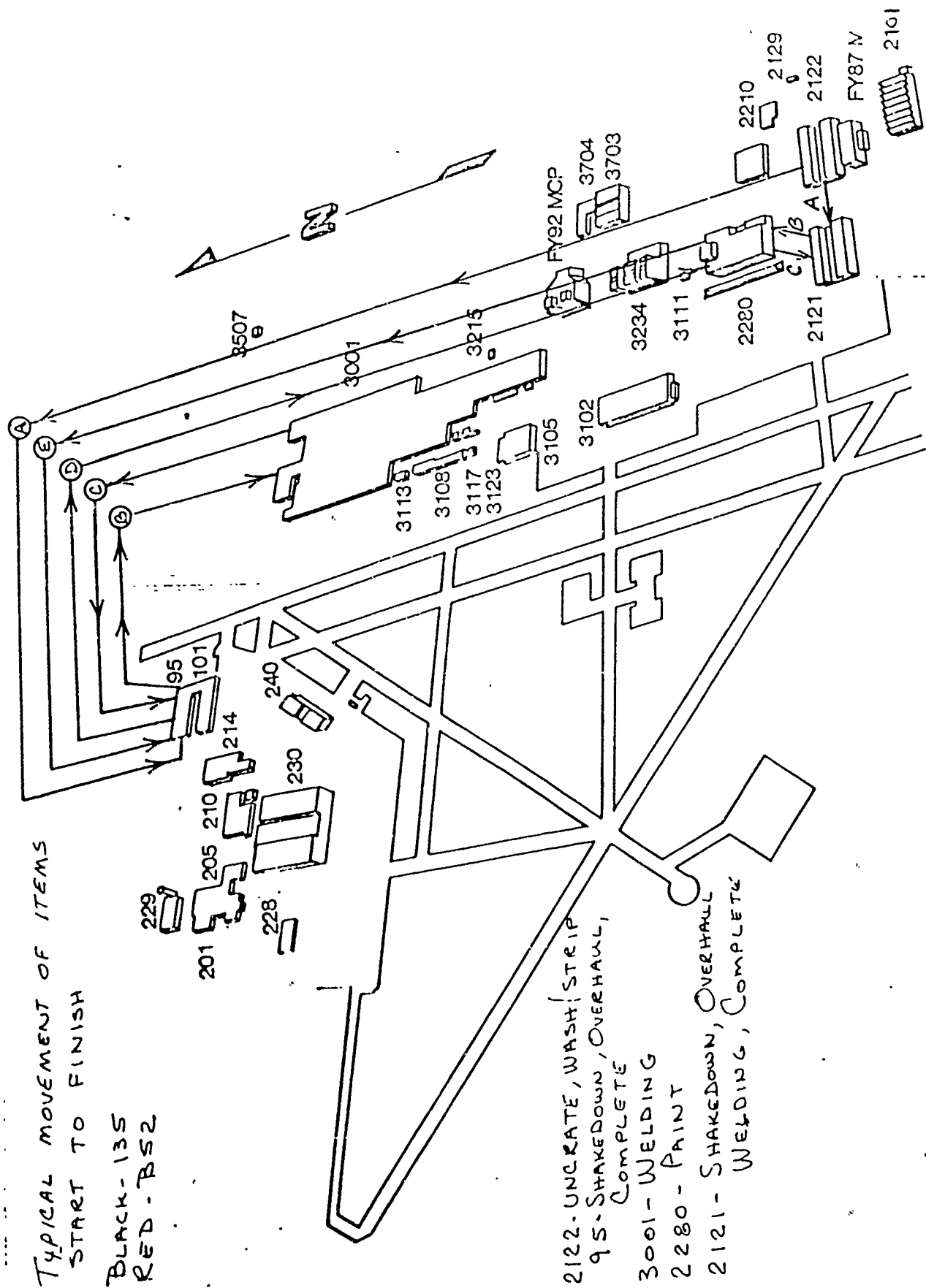
AVERAGE PROCESS SUPPORT TO OTHER DIVISIONS IS 24 HOURS\*

TIMES DETERMINED FROM SAMPLE STUDY OF TEN EACH FLAPS, LH SIDE COWL,  
OIL COOLER TABS, AND MLG DOOR.

\* MODIFY THESE HOURS BY OCCURANCE FACTOR OF ROUTED ITEM.

TYPICAL MOVEMENT OF ITEMS  
START TO FINISH

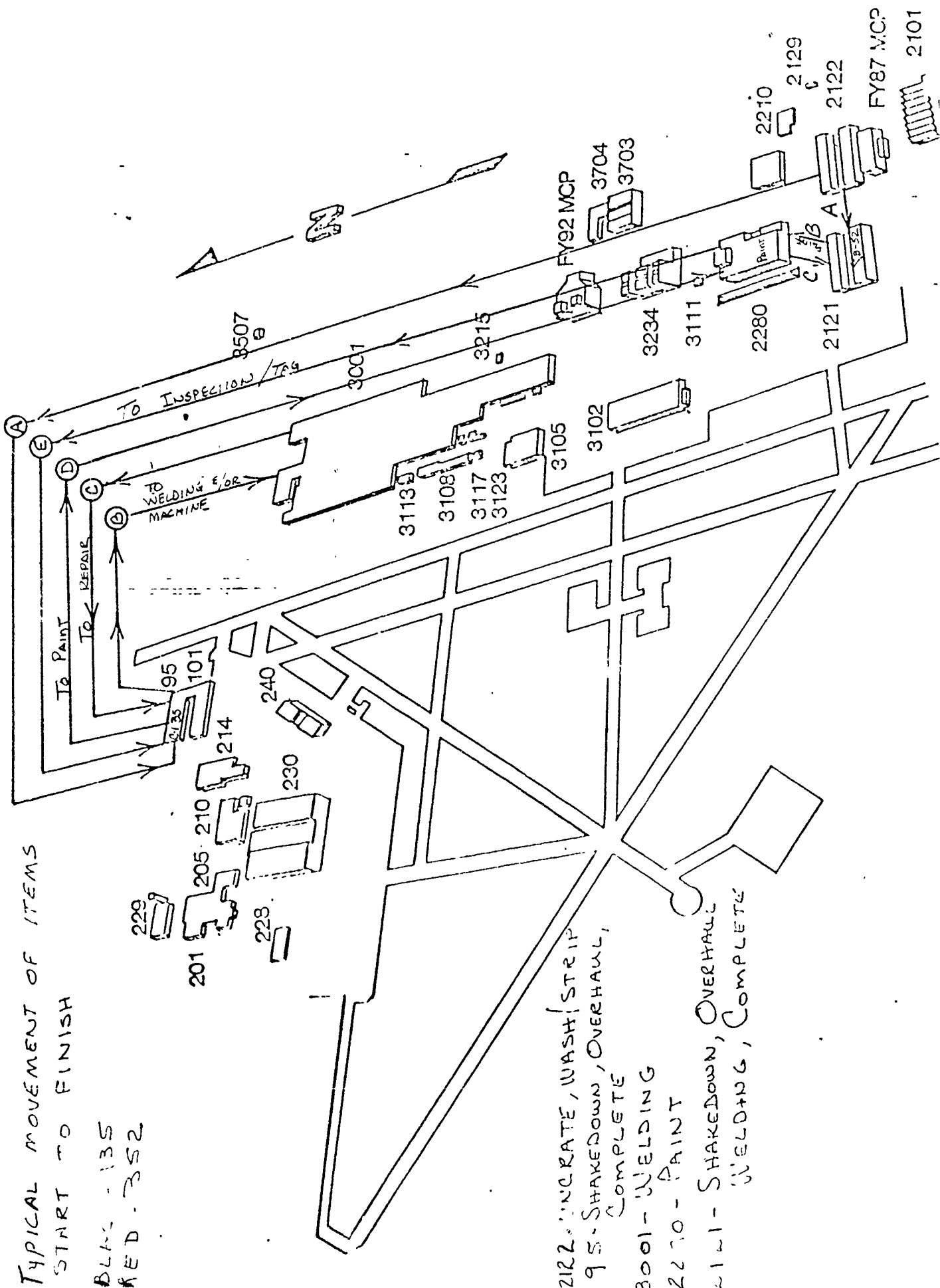
BLACK-135  
RED-B52



2122-UNCRATE, WASH, STRIP  
95-SHAKEDOWN, OVERHAUL,  
COMPLETE  
3001-WELDING  
2280-PAINT  
2121-SHAKEDOWN, OVERHAUL  
WELDING, COMPLETE

# TYPICAL MOVEMENT OF ITEMS START TO FINISH

BLK - 135  
RED - 352



OC - MABPAB

PCN	WCD
*****	*****
15025A	15025A
15113A	15113A
15119A	15119A
15126A	15126A
15136A	15136A
15137A	15136AA
15140A	15140A
15150A	15150A
15175A	15175A
15178A	15178A
15188A	15153A
15188ASUB1	15154A
15189ASUB1	15154AA
15189A	15153AA
15191A	15151A
15191ASUB1	15152A
15192A	15151AA
15192ASUB1	15152AA
15236A	15236A
15237ASUB1	15236B
15237A	15237A
15249A	15249A
15250A	15249AA
15300A	15126AA
15321A	15119AA

COMP

OC

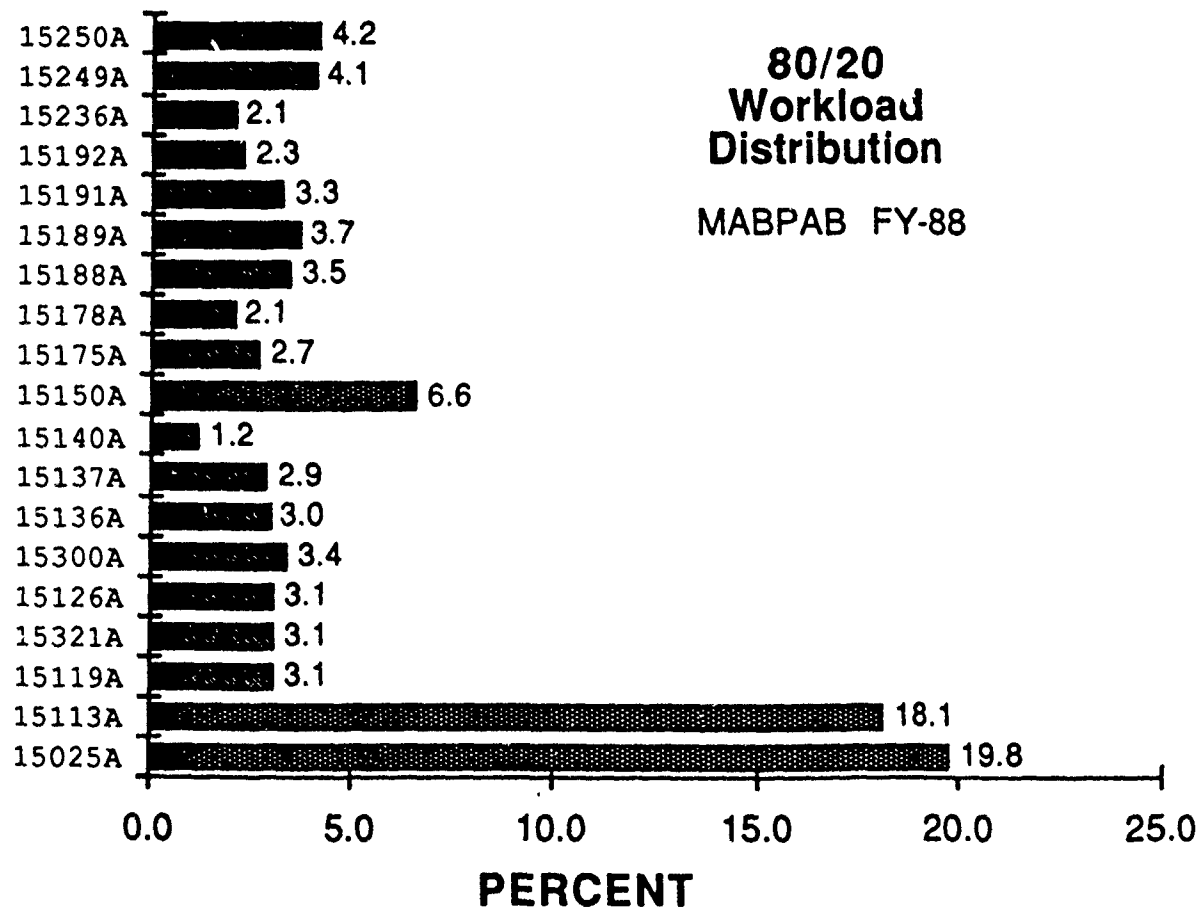
221 To 51

135

17S150ED.ALC7C.3019C.T123  
MANAGEMENT OF ITEMS SUBJECT TO  
LISTING OF STR FILE

QSS	WOD	DCN	ANSN	NOUN	WSA	UC	QDF
1	15025	✓	1560005205602FL-50	PANEL COWL	KC135	1642200	168
2	15113	✓	1550010419310FL-50	PANEL	KC135	2205400	150
3	15150	✓	156000067420FL-50	NOSE COW	KC135	005400	97
4	15151	✓	1560000506181FL-50	FLAP	KC135	4740436	194
5	15151	✓	1560000506180FL-50	FLAP	KC135	1814970	126
6	15250	✓	1560000556200FL-50	FLAP	KC135	4740500	204
7	15249	✓	1560000572240FL-50	AILERON	KC135	4313300	112
8	15192	✓	1560000572240FL-50	AILERON	KC135	5082000	112
9	15300	✓	1560000556201FL-50	FLAP	KC135	4740500	204
10	15136	✓	1560003409215FL-50	DOOR	KC135	2037855	100
11	15321	✓	1560004413621FL-50	AILERON	KC135	6474600	80
12	15128	✓	1560003404191FL-50	DOOR	KC135	2037855	80
13	15128	✓	1560003409215FL-50	DOOR	KC135	1305810	90
14	15119	✓	1560003397220FL-50	DOOR	KC135	1250412	89
15	15119	✓	1560003397220FL-50	DOOR	KC135	903200	80
16	15119	✓	1560003397220FL-50	DOOR	KC135	1057755	88
17	15119	✓	1560003397220FL-50	DOOR	KC135	2566600	1496
18	15140	✓	1560004637577FL-50	FAIRING	KC135	504200	594
19	15174	✓	1560006256548FL-50	FAIRING	KC135	1158400	318
20	15277	✓	1560007862633FL	STRUT	KC135	5942000	1908
21	15294	✓	1560006256547FL	FAIRING	KC135	745325	370
22	15104	✓	1560000555583FL	NOSEGEAR	EC-KC135	1294000	1563
23	15279	✓	1560007862635FL	STRUT	KC135	6743300	2533
24	15278	✓	1560003404202FL	HATCH	KC135	2030300	1938
25	15121	✓	1560002517056FL	RUDDER	KC135	4535700	271
26	15284	✓	1560003314843FL	DOOR	KC135	7384800	2388
27	15118	✓	1560009748817FL	COWL	KC135	8943490	363
28	15257	✓	1560003409248FL	FLAP	KC135	2441500	1563
29	15130	✓	1560008564054FL	FAIRING	KC135	1076500	765
30	15240	✓	1560006738927FL	SPILLER	EC135	450000	322
31	15213	✓	1560002499370FL	RUDDEVAT	E/KC135	803400	604
32	15115	✓	15600078701630FL	PANEL	KC135	465589	211
33	15246	✓	1560003701640FL	PANEL	KC135	5028068	1300
34	15280	✓	1560005522936FL	DOOR	C135B	3382900	1300
35	15179	✓	1560007310564FL	TAB ASSY	KC135	2336586	1444
36	15226	✓	1560003409247FL	FLAP	KC135	459600	234
37	15129	✓	1560003701606FL	ELEVATOR	KC135	835400	765
38	15245	✓	1560005577205FL	SPILLER	KC135A	2236665	1171
39	15275	✓	1560010085203AW	AILERON	C135A	489060	480
40	15350	✓	1560005603965FL	DOOR	E3A	3323200	958
41	15144	✓	1560006730065FL	SPILLER	EC135C	1083568	670
42	15276	✓	1560007539152FL	TAB	C135T	484500	384
43	15203	✓	1560005670342FL	DOOR	KC135	300600	233
44	15229	✓	1560008701667FL	DOOR	KC135	1625873	1424
45	15145	✓	1560005403966FL	DOOR ASS	EC135C	275900	97
46	15142	✓	1560007862634FL	STRUT	C135A	474958	643
47	15230	✓	1560007551350FL	TAB ASSY	KC135	5755500	2004
48	15235	✓	1560003075320FL	RING	C135B	407300	229
49	15260	✓	1560009761963FL	DOOR	KC135	902300	721
50	15314	✓	156000508274FL	SPILLER	KC135A	995230	520
51						622300	575

**80/20  
Workload  
Distribution**  
MABPAB FY-88





# ENV \_OP (For Internal Use, Not a Model Input)

ALC <u>DC</u>		RCC <u>MABPAB</u>	EQUIPMENT CODE		TOTAL VOLUME OF EQUIPMENT IN CU. FT.		
LIST OF PARTS BY ITEM NUMBER		SIZE/VOLUME CU. FT.	UNIT VALUE	MINIMUM	MAXIMUM	REMARKS/SOURCE	
PCN							
NSN							
P/N							
PCN							
NSN							
P/N							
PCN							
NSN							
P/N							
PCN							
NSN							
P/N							
PCN							
NSN							
P/N							
PCN							
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P/N							
PCN							
NSN							
P/N							
PCN							
NSN							
P/N							
PCN							
NSN							
P/N							
PCN							
NSN							
P/N							
PCN							
NSN							
P/N							

~~NOT APPLICABLE~~  
~~PROCESS~~  
~~EQUIPMENT~~

$\frac{A}{B} = \frac{C}{D}$

$\frac{A}{B} = \frac{C}{D}$

$\frac{A}{B} = \frac{C}{D}$

**(For Internal Use, Not a Model Input)**

[illegible]

# ITEM SUMMARY

(For Internal Use, Not a Model Input)

NAME <u>R. BOLANDS</u> ALC <u>OC</u> DATE <u>4/9/89</u> RCC <u>MABPA/B</u> SHEET <u>1</u> OF <u>2</u>		ITEM NUMBER	WCD	WORKLOAD TYPE	HISTORICAL FLOW TIME	STANDARD HOURS	EXPECTED HOURS
1	NSN P/N	15025A	15025A	4		163.49	
2	NSN P/N	15113A	15113A			147.72	
3	NSN P/N	15119A	15119A			89.76	
4	NSN P/N	15119A	"			90.24	
5	NSN P/N	15136A	15126A			88.73	
6	NSN P/N	15300A	"			98.31	
7	NSN P/N	15136A	15136A			79.18	
8	NSN P/N	15137A	"			79.18	
9	NSN P/N	15140A	15140A			51.65	
10	NSN P/N	15150A	15150A			85.15	
11	NSN P/N	15175A	15175A			73.86	
12	NSN P/N	15178A	15178A	✓		18.97	

NOTE: HISTORICAL FLOW TIME WILL BE GENERATED BY DATA PROCESSING. IF NO HISTORY IS COLLECTED ON WCD DATA COLLECTION SYSTEM, THIS INFORMATION MUST BE OBTAINED ON-SITE. EXPECTED HOURS WILL BE GENERATED FROM OPS. PROFILES BY DATA PROCESSING.

# ITEM SUMMARY

(For Internal Use, Not a Model Input)

NAME <u>R. BOLANOS</u> ALC <u>OC</u> DATE <u>4/9/89</u> RCC <u>MABPAB</u> SHEET <u>2</u> OF <u>2</u>					
ITEM NUMBER	WCD	WORKLOAD TYPE	HISTORICAL FLOW TIME	STANDARD HOURS	EXPECTED HOURS
13 NSN P/N 15188A	15153A	4		120.73	
14 NSN P/N 15189A	"			120.73	
15 NSN P/N 15188A	15154A			15.00	
16 NSN P/N 15189A	"			15.00	
17 NSN P/N 15191A	15151A			118.72	
18 NSN P/N 15192A	"			118.72	
19 NSN P/N 15191A	15152A			15.00	
20 NSN P/N 15192A	"			15.00	
21 NSN P/N 15236A	15236A			121.58	
22 NSN P/N 15237A	15237A			28.60	
23 NSN P/N 15249A	15249A			110.53	
24 NSN P/N 15250A	"	Y		110.99	

NOTE: HISTORICAL FLOW TIME WILL BE GENERATED BY DATA PROCESSING. IF NO HISTORY IS COLLECTED ON WCD DATA COLLECTION SYSTEM, THIS INFORMATION MUST BE OBTAINED ON-SITE. EXPECTED HOURS WILL BE GENERATED FROM OPS. PROFILES BY DATA PROCESSING.

PCN 15237A 4 28.60 15236B 15236B

## RCC CH KLST

NAME R. BOLANOS ALC α DATE 4/9/89 SHEET 1 OF 1

# MANPOWER PROFILE

NAME <u>R Bolanos</u> ALC <u>OC</u> DATE <u>4/11/89</u> RCC <u>MABPAB</u> SHEET <u>1</u> OF <u>2</u>		JOB DESCRIPTION	QUARTER	QUANTITY AVAILABLE								MANPOWER AVAILABLE (HOURS)								ALTERNATE SKILL CODE/LEVEL							
SKILL CODE/LEVEL	WORK WEEK				WEEKEND				HOLIDAYS				WORK WEEK				WEEKEND				HOLIDAYS						
	1			2	3	4	1	2	3	4	1	2	3	4	1	2	3	4	1		2	3	4	1	2	3	4
AS 10	1	15																								BS10, CS10, DS10, ES10, FS10.	
	2	7																									
	3	4																									
	4	8																									
BS 10	1	16																							AS10, CS10, DS10, ES10, FS10		
	2	15																									
	3	22																									
	4	19																									
CS 10	1	10																							AS10, BS10, DS10, ES10, FS10		
	2	11																									
	3	15																									
	4	10																									
DS 10	1	19																							AS10, BS10, CS10, ES10, FS10		
	2	10																									
	3	4																									
	4	2																									
ES 10	1	23																							AS10, BS10, CS10, DS10, FS10		
	2	26																									
	3	35																									
	4	27																									

1,50' 200001

# MANPOWER PROFILE

NAME <u>R. B. BIANOS</u> ALC <u>OC</u> DATE <u>4/11/89</u> RCC <u>MABPAB</u> SHEET <u>2</u> OF <u>2</u>																											
SKILL CODE/LEVEL	JOB DESCRIPTION	QUARTER	QUANTITY AVAILABLE												MANPOWER AVAILABLE (HOURS)												ALTERNATE SKILL CODE/LEVEL
			WORK WEEK				WEEKEND				HOLIDAYS				WORK WEEK				WEEKEND				HOLIDAYS				
			1	2	3	4	1	2	3	4	1	2	3	4	1	2	3	4	1	2	3	4	1	2	3	4	
FS 10	Misc.	1	29																								ASD, B, S, M, C, S, D, D, S, M, E, S, D
		2	28																								
		3	34																								
		4	30																								
GS 10		1	8																								ASD, B, S, M, C, S, D, D, S, M, E, S, D
		2	8																								
		3	9																								
		4	8																								
		1																									
		2																									
		3																									
		4																									
		1																									
		2																									
		3																									
		4																									
		1																									
		2																									
		3																									
		4																									

4/19 33



# MANPOWER PROFILE

FORM		ALC	DATE	RCC	LIBRARY	SHEET 1 OF 2																		
SKILL CODE/LEVEL	JOB DESCRIPTION	QUARTER	QUANTITY AVAILABLE						MANPOWER AVAILABLE (HOURS)												ALTERNATE SKILL CODE/LEVEL			
			WORK WEEK			WEEKEND			HOLIDAYS			WORK WEEK			WEEKEND			HOLIDAYS						
			1	2	3	1	2	3	1	2	3	1	2	3	1	2	3	1	2	3				
FS 08	LEFT HAND SIDE COWL	1	4														5.6							BS, CS, DS ES, FS, GS AS-10 08-10
		2	2														5.7							
		3	1														5.9							
		4	2														5.8							
ES 08	RIGHT HAND SIDE COWL	1	5														5.6							AS, CS, DS ES, FS, GS 08-10
		2	5														5.7							
		3	7														5.9							
		4	6														5.8							
CS 08	NOSE COWL	1	3														5.6							AS, BS, DS ES, FS, GS 08-10
		2	3														5.7							
		3	5														5.9							
		4	3														5.8							
DS 08	FLAPS	1	4														5.6							AS, BS, CS, ES, FS, GS 08-10
		2	3														5.7							
		3	1														5.9							
		4	1														5.8							
ES 08	FLIGHT CONTROL	1	8														5.6							AS, BS, CS DS, FS, GS 08-10
		2	8														5.7							
		3	12														5.9							
		4	9														5.2							

ALL ALTERNATE CODES  
HAVE 08-10

[illegible]

# MANPOWER PROFILE

ALL ALTERNATE  
CODES HAVE  
OS 08 + 10

FORM 2-60 ALC		DATE 11/1/50	RCC INDEPEND		SHEET 1 OF 2																			
JOB CODE/LEVEL	JOB DESCRIPTION	QUARTER	QUANTITY AVAILABLE						MANPOWER AVAILABLE (HOURS)						ALTERNATE SKILL CODE/LEVEL									
			WORK WEEK			WEEKEND			HOLIDAYS			WORK WEEK				WEEKEND			HOLIDAYS					
			1	2	3	1	2	3	1	2	3	1	2	3		1	2	3	1	2	3			
AS OS	LEFT HAND SIDE COWL	1																						BS, CS, DS ES, FS, GS
		2	6																					5.6
		3	3																					5.7
		4	3																					5.9
BS OS	RIGHT HAND SIDE COWL	1																						OS, OS + 10
		2	6																					5.6
		3	8																					5.7
		4	7																					5.9
CS OS	NOSE COWL	1																						OS, OS + 10
		2	9																					5.6
		3	9																					5.7
		4	5																					5.9
DS OS	FLAPS	1																						OS, OS + 10
		2	9																					5.6
		3	1																					5.7
		4	1																					5.9
ES OS	FLIGHT CONTROL	1																						OS, OS + 10
		2	9																					5.6
		3	10																					5.7
		4	13																					5.9
		1																						OS, OS + 10
		2	10																					5.8
		3	13																					
		4	10																					

[illegible]














157 22

15(XXI), 511

# WORKLOAD PROFILE

NAME <u>R. Bolanos</u>		ALC <u>OC</u>	DATE <u>4/7/89</u>	RCC <u>MABPAB</u>	SHEET <u>1</u> OF <u>2</u>						
ITEM NUMBER	AIRCRAFT MODEL	WCD	WORKLOAD TYPE	FLOATING STOCK <small>Avail. for use</small>	ACTUAL PRODUCTION BY QUARTER				NO. OF ENVELOPE UNITS	MAXIMUM WIP.	STANDARD HOURS
					<small>GOING GOOD</small> 1	<small>GOING GOOD</small> 2	3	<small>GOOD</small> 4			
<del>NSN</del> PIN 15025A	C-135	15025A	4		56	55	54	75		15	163.49
<del>NSN</del> PIN 15113A		15113A	4		60	60	53	70		22	147.72
<del>NSN</del> PIN 15119A		15119A	4		13	16	20	20		4	89.76
<del>NSN</del> PIN 15321A		"	4		13	16	20	20		4	90.24
<del>NSN</del> PIN 15126A		15126A	4		13	16	20	20		5	88.73
<del>NSN</del> PIN 15330A		"	4		13	16	20	20		5	98.31
<del>NSN</del> PIN 15136A		15136A	4		13	18	23	22		4	79.18
<del>NSN</del> PIN 15137A		"	4		13	16	23	21		4	79.18
<del>NSN</del> PIN 15140A		15140A	4		1	0	4	40		8	51.45
<del>NSN</del> PIN 15150A		15150A	4		25	25	38	66		17	85.15
<del>NSN</del> PIN 15175A		15175A	4		25	12	8	26		3	73.86
<del>NSN</del> PIN 15178A		15178A	4		36	50	59	75		7	18.97
<del>NSN</del> PIN 15188A		15188A	4		13	13	15	17		8	120.73

# WORKLOAD PROFILE

NAME <u>R. Bolados</u>		ALC	OC	DATE <u>4/2/89</u>	RCC	MABPAB	SHEET <u>2</u> OF <u>2</u>				
ITEM NUMBER	AIRCRAFT MODEL	WCD	WORKLOAD TYPE	FLOATING STOCK	ACTUAL PRODUCTION BY QUARTER				NO. OF ENVELOP UNITS	MAXIMUM WIP.	STANDARD HOURS
					1	2	3	4			
 15189A	C-135	15153A	4		13	15	15	17		8	120.73
 15188A		15154A	4	2							15.00
 15189A		"	4	2							15.00
 1519A		15151A	4		11	11	16	17		7	118.72
 15192A		"	4		6	6	10	17		8	118.72
 15191A		15152A	4	2							15.00
 15192A		"	4	2							15.00
 15236A		15236A	4		6	10	9	9		4	121.58
 15237A		15237A	4							1	28.60
 15249A		15249A	4		13	18	23	20		3	110.53
 15250A		"	4		13	18	23	20		3	110.53
 15236A		15236A	4	2						1	28.60
											



MAEPAB		MAEPAB		FY 1988		FY 1989		FY 1990		FY 1991	
LAEOR		LAEOR		1st		2nd		3rd		4th	
= TL		# UNITS		MAEPAB		MAEPAB		MAEPAB		MAEPAB	
1	15111	53.5	36	55	54	75					
2	15112	55.7	60	60	53	70					
3	15113	92.4	25	25		66					
4	15114	193.9	3	15	15	17					
5	15115	145.9	13	13	15	17					
6	15116	201.8	11	11	16	17					
7	15117	110.5	13	18	53	20					
8	15118	110.5	13	13							
9	15119	201.8	6	6	10	17					
10	15120	98.3	13	16	20	30					
11	15121	79.2	13	18	13	32					
12	15122	90.2	13	16	20	30					
13	15123	99.7	13	16	20	30					
14	15124	39.8	13	16	20	30					
15	15125	74.9	13	13	2	1					
16	15126	74.9	25	12	2	26					
17	15127	24.0	36	50	59	75					
18	15128	142.6	6	10	9	9					
19	15140	58.7	1	0	4	40					

★ IAW A-GØ19C - CAA-CA-MCE  
DATED 16 JUN 1988



CPK Pch  
 11-2880

MABPAB FIXTURES

TI DELVP. CODES  
 FLIGHT CONTROLS

<u>EQUIP CODE NO.</u>	<u>NAME</u>	<u>PART NO.</u>	<u>QTY.</u>	<u>APPLICA</u>
F 335-01	FILLET FLAP	SC65-1062T1	1	E3A/135
02	RUDDER	590CJ1130	1	E3A/135
FE3A 01	INBD FLAP	SC65-1063T1	1	E3A
02	L'H/RH ELEVATOR	SC5-96190T1		E3A
F135- 01	L'H/RH ELEVATOR	590CJ1120	1	135
F 335-03	INBD AILERON	590CJ1010	3	E3A/135
" 04	OTBD MAIN FLAP	590CJ1030	1	E3A/135
F 135-02	INBD MAIN FLAP	590CJ1020	1	135
F 335-05	OTBD SPOILER	590CJ1060	1	E3A/135
07	OTBD AILERON	590CJ1000	3	E3A/135

DOORS

F 335-08	OTBD MLG	590CJ1110	4	E3A/135
09	INBD MFG	590CJ1100	4	E3a/135

MISC

F 135-03	Hog Nose Fairing	65-10607-46	1	135
04	OTBD ENG STRUT	590CJ1150	1	135
05	INBD ENG STRUT	590CJ1140	1	135
06	BOTTOM PANEL TF33 P9	FAJ64-8327-621	1	135
07	TAIL CONE	7627259	1	135
08	KNCE CAP FAIRING	TJ5-85654	1	135
09	BOOM POD FAIRING		1	135
10	NOSE WHEEL FAIRING	2FAJ5-73139-1	1	135
11	NOSE WHEEL FAIRING	FRJ5-73139-1	1	135
12	NOSE WHEEL FAIRING	FAJ5-73139-1	1	135
18	BOOM TAIL CONE	600CJ809	3	135

COWLING

F33A-03	RH SIDE COWL	SC65-2549T	1	E3A
04	LH SIDE COWL	SC65-2549T1	1	E3A
F135-13	RH SIDE COWL J57	3AJ5-85638	2	135
14	LH SIDE COWL J57	3AJ5-85637	2	135
15	RH SIDE COWL TF33P5	OC75-64-8327-488	1	135
16	L'H SIDE COWL TF33P5	OC75-64-8327-487	1	135
FE3A- 05	NOSE COWL	204-70099-3ASMJ	1	E3A
06	NOSE COWL	204-70099-TRMJ	1	E3A
F135 -17	NOSE COWL J57	AJ5-85655	1	135

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OC.

TI DEVL. CODES		B-52 MABPFF FIXTURES	
<u>EQUIP. CODE NO.</u>	<u>NAME</u>	<u>PART NO.</u>	<u>QTY</u>
FB 52-01	ELEV/RUDDER BALANCE	RP04G	1
02	BOMB BAY DOOR (LARGE)	FME35-30600-3	2
03	BOMB BAY DOOR (LARGE)	FME35-30600-1	2
04	BOMB BAY DOOR (LARGE)	FME35-30600-2	2
05	BOMB BAY DOOR (SMALL)	AJ5-48467-3	1
06	BOMB BAY DOOR (SMALL)	AJ5-46867-4	2
07	BOMB BAY DOOR (SMALL)	AJ5-46868-28	1
08	BOMB BAY DOOR (SMALL)	AJ5-46868-27	1
FB 52-09	BOMB BAY DOOR (SMALL)	AJ5-46867-3	1

# MABPAB EQUIPMENT

EQUIP. CODE NO.	NAME	MODEL	QUANTITY
E 135-01	Bending MACHINE (HAND)	416	1
" 02	LARGE BAND SAWS		2
" 03	ROTEX PUNCH PRESS		1
" 04	DRILL' (FLOOR MODEL)	1200-118	1
" 05	GRINDER FLOOR MODEL, (2WHEEL ELECT)		1
" 06	PRESS BRAKE (CHICAGO STEEL CO.)	80023	1
" 07	POWER SQUARING MACHINE	002741	1
" 08	PRESS BRAKE	4560G	1
" 09	SMALL METAL SHEAR	241-C	1
" 10	SMALL DRILL PRESS		1
" 11	GRINDER 1WHEEL,(FLOOR MODEL)	WF6566	1
" 12	PUNCH PRESS	P41P	1
" 13	SANDER (BELT) FLOOR MOD.		1
" 15	BENDING MACHINE (HAND)	BB-316	1

B-52

MABPFF EQUIPMENT

<u>EQUIP. CODE NO.</u>	<u>NAME</u>	<u>MODEL #TYPE</u>	<u>QTY.</u>
EB 52-01	DOUBLE SANDER DISK (FLOOR MODEL)		1
02	DRILL PRESS (FLOOR MODEL)		4
03	GRINDING MACHINE	WISSOTA E8M	1
04	WELDER	MILLER 330ST	1
05	BRAKE, MECH		1
06	BRAKE, MECH FORMING ROLLER	0617	2
07	BRAKE, HAND	NATIONAL	2
08	METAL STREACHER (FLOOR MOD)		1
09	PRESS ARBOR	FAMCO	2
10	PUNCH, MECH	ROTEX	1
11	POWER SHEAR	MASPERI CM500A	1
12	DIMPLER	300	1
13	BRAKE PRESS	65M75	1
14	DOALL SAW	3613-2	1

# SKILL CODES

## MABPAB

_____	*AS	LEFT HAND SIDE COWL
_____	*BS	RIGHT HAND SIDE COWL
_____	*CS	NOSE COWL
_____	*DS	FLAPS
_____	*ES	FLIGHT CONTROLS
_____	*FS	MISC

## MABPFF

_____	*AS	SPOILERS, HATCHES, TIP GREAR, POP-UP
_____		ANTENNA, SUPPLY B/B DOORS
_____	*WS	FLAPS, RUDDERS, ELEVATORS.
_____	*YS	NOSE COWL, SIDE COWL
_____	*3S	PDM

## MABPCA

_____	*WL	EQUIPMENT CLEANERS
-------	-----	--------------------

## MABPCB

_____	*B3	PAINTERS
-------	-----	----------

## MABPCD

_____	*M <sub>4</sub>	MOVERS
_____	*CQ	CRANE OPERATORS
_____	*EQ	CHECKERS

## AA

SYSTEMS (ELECTRIC)

1015  
90  
EQUIPMENT PROFILE

EQUIPMENT CODE		EQUIPMENT TYPE/DESCRIPTION		QUANTITY PER SHIFT			PREVENTIVE MAINT			DOWNTIME			PERCENT USED FOR OTHER RCCs (e.g. TIME NOT AVAILABLE)		ENVELOP UNITS		ALTERNATE EQUIPMENT CODE		SOURCE	
				1st	2nd	3rd	FREQ.	SHIFT	DOWN TIME	UNSCHEDULED BREAKDOWN REPAIR TIME						MIN	MAX			
										MTBF	MTTR									
E135-01	BENDING MACHINE (HAND) MODEL 4116	1					3-0090 Days		.2				0						PERI-UTILE AF22600170 UNRELIABLE	
E135-02	LARGE BAND SAWS 1-AF20065 2-OC-2982	1					2-1000 3-0090 Day		.5				0							
E135-03	ROTEX PUNCH PRESS OC-5512	1					4-1000 HRS 3-0090 days 3-1000 HRS		.5 .5 1.0				0							
E135-04	DRILL (FLOOR MODEL) 1200-118 LET HAND CIRCULAR	1					3-1000 HRS		.5				0							
E135-05	GRINDER FLA & MODEL (2) WHEEL ELECT	1					2-0180 days 3-0090 days		.5 .5				0							
E135-06	PRESS BRAKE (CHICAGO) STEEL CO. MODEL 80023	1					2-180 days 3-090 days		.5 .5				0							
E135-07	POWER SQUARING MACHINE MODEL 002741	1					3-0060 day 3-3000 HRS 3-5000 HRS		.3 .5 1.0				0							
E135-08	PRESS BRAKE MODEL 45606 HUNTA Co	1					2-180 days 2-4000 HRS 3-1000 HRS		.5 .5 .5				0							
E135-09	SMALL METAL SHEAR MODEL 241-C	1					3-0090 days		.2				0							
E135-10	SMALL DRILL PRESS MODEL 2/75	1					3-1000 HRS		.5				0							
E135-11	GRINDER - 3 WHEEL (FLA & M) MODEL 241-C						No LONGER IN SHOP													
E135-12	PUNCH PRESS MODEL P41P VICKER	1					2-1000 HRS 3-0090 day		.5 .2				0							

ROUTING TIME (HRS)

# EQUIPMENT PROFILE

COMPONENT: ALC DC-ALC DATE 4/13 89 RCC 2 OF 2

SOURCE	EQUIPMENT TYPE/DESCRIPTION	QUANTITY PER SHIFT			DOWNTIME					PERCENT USED FOR OTHER RCCs (9. TIME NOT AVAILABLE)	ENVELOP UNITS		ALTERNATE EQUIPMENT CODE	SOURCE
		1st	2nd	3rd	PREVENTIVE MAINT.		UNSCHEDULED BREAKDOWN REPAIR TIME							
					FREQ.	SHIFT	DOWN TIME	MTBF	MTTR					
E135-13	SANDER (BELT) FLOOR MOLD OC5799	1			3-180 Days 2-180 Days	1 1	.5 .5							
E135-15	BENDING MACHINE (HAND) MODEL BB-316 OC0140	1			0090	1	.2							
E135-16	DUMPER MACHINE MODEL AT25655				2-365 Days 3-180 Days	1 1	1.0 1.0							
E135-17	HOISTING ELEVATOR - BIG JOE MODEL 1518-K5 OC6390				3-0090 Days 3-0090 Days 3-0180 Days 3-0180 Days	1 1 1 1	.5 1.0 1.5 .5							
E135-18	711R HOIST 1 Ton				Daily Visual	1	.1							
E135-19	AIR HOIST 1 Ton				Daily Visual	1	.1							
E135-20	ELECTRIC HOIST MODEL 52200 OC9614				2-365 Days	1	1.0							
	INTENTIONALLY BURNED X X X													
E135-21	METAL FORMER 735683				3-0090 Days	1	.2							
E135-22	METAL SHEAR (HAND) 107-12-78				3-0090 Days	1	.2							
E135-23	SURVIVING/SURVIVING MACHINE OC3590				3-0090 Days	1	.2							
E135-24	AREOS (HAND) OC0685	1			3-0090 Days	1	.2							

ELECTRIC = 2

# FIXTURE EQUIPMENT PROFILE

L. MULLINAX		ALC OC		DATE 4/13/84		RCC		SHEET 1 OF 3							
EQUIPMENT CODE	EQUIPMENT TYPE/DESCRIPTION	QUANTITY PER SHIFT			PREVENTIVE MAINT.			DOWNTIME			PERCENT USED FOR OTHER RCCs (i.e. TIME NOT AVAILABLE)	ENVELOPE UNITS		ALTERNATE EQUIPMENT CODE	SOURCE
		1st	2nd	3rd	FREQ.	SHIFT	DOWN TIME	MTBF	MTTR	MIN		MAX			
F335-01	FLAP FLAP E3A/135 PW SC65-1062T1	1			365	1	16hr				0				INTERVIEW: Don COLLINS/MHT PIT 12-2-84
F335-02	RUBBER E3A/135 PW 590CJ1130	1									0				
FE3A-01	INBD FLAP E-3A PW SC65-1063T1	1									0				
FE3A-02	LH-RH ELEVATOR E-3A SCS-96190T1	1									0				
F335-01	LH-RH ELEVATOR 135 590CJ1120	1									0				
F335-03	INBD AILERON E3A/135 590CJ1010	3									0				
F335-04	OTBD MAIN FLAP E3A/135 590CJ1030	1									0				
F135-02	INBD MAIN FLAP 135 590CJ1020	1									0				
F335-05	OTBD SPOILER E3A/135 590CJ1060	1									0				
F335-07	OTBD AILERON E3A/135 590CJ1000	3									0				
F335-08	OTBD MLG E3A/135 590CJ1110	4									0				
F335-09	INBD MLG E3A/135 590CJ1100	4			365	1	16hr				0				

NAME: L. MULLINAX      ALC: OC      DATE: 4/13/84      RCC:      SHEET 1 OF 3



# EQUIPMENT PROFILE

NAME <u>L. MULLENDA X</u>		ALC <u>OC - ALC</u>		DATE <u>4/13/89</u>		RCC <u>MARINE</u>		SHEET <u>2</u> OF <u>3</u>				
EQUIPMENT CODE	EQUIPMENT TYPE/DESCRIPTION	QUANTITY PER SHIFT			PREVENTIVE MAINT.		DOWNTIME		PERCENT USED FOR OTHER RCCs (if TIME NOT AVAILABLE)	ENVELOP UNITS MIN MAX	ALTERNATE EQUIPMENT CODE	SOURCE
		1st	2nd	3rd	FREQ.	SHIFT	DOWN TIME	MTBF				
F135-03	HOG NOSE FAIRING 135 65-10607-416	1			365	1	16HRS		0			
F135-04	OTBD ENG STRUT 135 590CJ1150	1							0			
F135-05	INBD ENG STRUT 135 590CJ1150	1							0			
F135-06	BOTTOM PANEL 135 FAJ 64-8327-621	1							0			
F135-07	TAIL CONE 135 7627259	1							0			
F135-08	KNEE CAP FAIRING 135 TJ5-85654	1							0			
F135-09	BOOM PUL FAIRING 135	1							0			
F135-10	Nose WHEEL FAIRING 135 2 FAJ5-73139-1	1							0			
F135-11	Nose WHEEL FAIRING 135 FRJ5-73139-1	1							0			
F135-12	Nose WHEEL FAIRING 135 FAJ5-73139-1	1							0			
F135-18	BOOM TAIL CONE 135 600CJ809	3							0			
FE3A-03	RH SIDE GULL 135 SC65-2549T	1			365	1	16HRS		0			

A  
4/11

## EQUIPMENT PROFILE

NAME <u>L. MULLINAX</u>		ALC <u>OC-ALC</u>		DATE <u>4/13/81</u>		RCC <u>MAK-PAL</u>		SHEET <u>2</u> OF <u>3</u>						
EQUIPMENT CODE	EQUIPMENT TYPE/DESCRIPTION	QUANTITY PER SHIFT			PREVENTIVE MAINT.			DOWNTIME		PERCENT USED FOR OTHER RCCs (0-100% NOT AVAILABLE)	ENVELOP UNITS		ALTERNATE EQUIPMENT CODE	SOURCE
		1st	2nd	3rd	FREQ.	SHIFT	DOWN TIME	MTBF	MTTR		MIN	MAX		
FE3A-04	LH SIDE COWL SC 65-2549T1 E3A	1			365	1	16 Hrs			0				
F135-13	RH SIDE COWL (J-57) 3AJS-85638 135	2			365	1	24 Hrs			0				
F135-14	LH SIDE COWL (J-57) 135	2			365	1	24 Hrs			0				
F135-15	R SIDE COWL (FF33PS) OC 75-64-8327-488 135	1			365	1	16 Hrs			0				
F135-16	LH SIDE COWL (FF33PS) OC 75-64-8327-487 135	1								0				
FE3A-05	Nose Cowl 204-70099-3ASMJ E3A	1								0				
FE3A-06	Nose Cowl 204-70099-TRMJ E3A	1								0				
F135-17	Nose Cowl (J57) AJ5-85655 135	1			365	1	16 Hrs			0				
	-----													
	-----													
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# WORK ACTIONS EQUIPME. PROFILE

NAME <u>R. Bolanos</u>		ALC <u>DC</u>		DATE <u>4/20/89</u>		RCC <u>MABPAB</u>		SHEET <u>1</u> OF <u>2</u>			
EQUIPMENT CODE	EQUIPMENT TYPE/DESCRIPTION	QUANTITY PER SHIFT			DOWNTIME			PERCENT USED FOR OTHER RCCs (e.g. TIME NOT AVAILABLE)	ENVELOP UNITS MIN MAX	ALTERNATE EQUIPMENT CODE	SOURCE
		1st	2nd	3rd	FREQ	SHIFT	DOWN TIME				
25	B E N C H (Work Sm)	10									T. Hall 15025A.
113	"	16									15113A.
119	"	4									15119A + 15321A
126	"	4									15126A + 15300A
136	"	4									15136A + 15137A
140	"	5									15140A
150	"	16									15150A
175	"	3									15175A
178	"	5									15178A
181/53	"	12									15153A + 15151A
188/54	"	6									15154A + 15152A
236	"	4									15236A

Work - tion.

[illegible]

# HASPAB EQUIPMENT

EQUIP. CODE NO.	NAME	MODEL	QUANTITY
-----------------	------	-------	----------

1-100-01	BENDING MACHINE (H&O)	16	1
" 02	12" FLOOR PRESS		2
" 03	12" FLOOR PRESS		1
" 04	12" FLOOR PRESS	1-116	1
" 05	12" FLOOR PRESS, (WHEEL EFFECT)		1
" 06	12" FLOOR PRESS (CHICAGO)	13	1
" 07	12" FLOOR PRESS	1-1	1
" 08	12" FLOOR PRESS	1-1-0	1
" 09	12" FLOOR PRESS	1-1-0	1
" 10	12" FLOOR PRESS	1-1-0	1
" 11	12" FLOOR PRESS, (FLOOR PRESS)	1-1-0	1

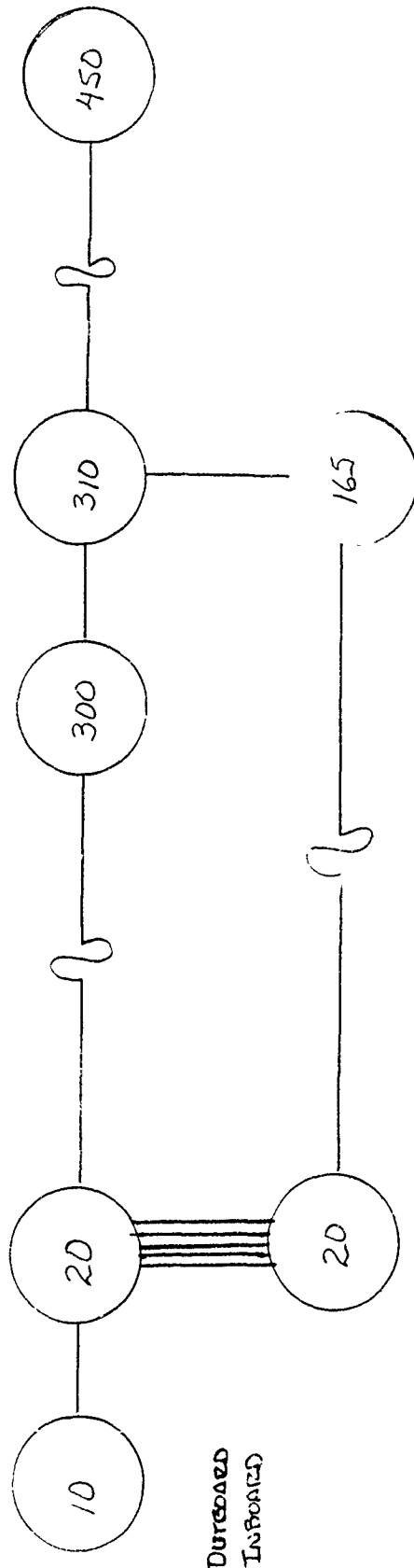
ab  
14

12	12" FLOOR PRESS	1-1-0	1
13	12" FLOOR PRESS	1-1-0	1
14	12" FLOOR PRESS	1-1-0	1

16	DIMPLING MACHINE	AT256SS	1
17	PORTABLE ELEVATOR	1518-R5	1
18	AIR HOIST 1 Ton	S2T18-20S	1
19	AIR HOIST 1 Ton	S2T18-20S	1
20	ELECTRONIC PROG	SQ 200	1
21	METAL FORMER	381D	1
22	METAL SHEAR (HAND)	107-12-78	1
23	SHRINKING/STRETCHING MACHINE	8028	1
24	ARBOR (HAND)	0685	1

# DISASSEMBLY/ASSEMBLY . ROFILE

NAME <u>R Bolanos</u>		ALC <u>OC</u>		DATE <u>4/5/89</u>		ROC <u>MABPAB</u>		SHEET <u>1</u> OF <u>2</u>	
TOP ASSEMBLY			REMOVAL OPERATION NUMBER	INSTALLATION OPERATION NUMBER	SUBASSEMBLY			SAME REMOVED ITEM INSTALLED INTO ASST. Y/N	
ITEM NUMBER	WCD	WCD DATE			ITEM NUMBER	CHLD WCD	CHLD WCD DATE		
<del>PCN</del> NSM PIN 15188A	15153A	88055	20	310	<del>PCN</del> NSM PIN 15188A	15154A	88055	N	
<del>PCN</del> NSM PIN 15189A	15153A	88055	20	310	<del>PCN</del> NSM PIN 15189A	15154A	88055	N	
<del>PCN</del> NSM PIN 15191A	15151A	88055	20	310	<del>PCN</del> NSM PIN 15191A	15152A	88055	N	
<del>PCN</del> NSM PIN 15192A	15151A	88055	20	310	<del>PCN</del> NSM PIN 15192A	15152A	88055	N	
PCN NSM PIN					PCN NSM PIN				



IN BOARDED 15151A 15152A 15153A 15154A 15188A 15189A 15191A 15192A

FIAPS FORE FIAPS RIGHT LEFT

LSC 200WISA

# DISASSEMBLY/ASSEMBLY PROFILE

NAME <u>R. Bolanos</u> ALC <u>DC</u> DATE <u>4/10/89</u> ROC <u>MAEPAB</u> SHEET <u>2</u> OF <u>2</u>		SUBASSEMBLY		INSTALLATION OPERATION NUMBER	REMOVAL OPERATION NUMBER	TOP ASSEMBLY		SAME REPORTED ITEM INSTALLED INTO ASSY. Y/N
ITEM NUMBER	WCD	WCD DATE	ITEM NUMBER			CHLD WCD	CHLD WCD DATE	
PCN NSM PIN 15236A	15236A	88054	15237A	290	50			N
PCN NSM PIN								
PCN NSM PIN								
PCN NSM PIN								
PCN NSM PIN								
<p>PARENT: 10 — 20 — 30 — 40 — 50 — 60 — 280 — 290 — 300 — 310 — 320</p> <p>CHILD: 50 — 60 — 220 — 230</p> <p>330 — 340 — 350</p>								
PCN NSM PIN								
PCN NSM PIN								
PCN NSM PIN								
PCN NSM PIN								
PCN NSM PIN								
PCN NSM PIN								
PCN NSM PIN								
PCN NSM PIN								
PCN NSM PIN								
PCN NSM PIN								

\* IF TOP ASSY (SLEEVE ASSY) IS INDICATED AS 15236A, A SUB-ASSY (FAIRING AFT) IS A 5236B  
 HOWEVER A (FAIRING AFT) CAN BE INDICATED AS 15237A ALONE. IT CAN NOT GO INTO 15236A)

MAILED - 11  
REC. 11/13

66

TURNER, AFB OF OKLAHOMA CITY, OK.

4/28/1987  
KCL - 1943-16

[illegible]



# PARALLEL PROCESS PROFILE

NAME Bolanos ALC OC DATE 4/24/84 RCC MLB/PAB SHEET 1 OF 2

ITEM NUMBER	PARENT WCD	PARENT WCD DATE	BEGINNING OPERATION NUMBER	ENDING OPERATION NUMBER	CHILD PROCESS INFORMATION		
					ITEM NUMBER	CHILD WCD	CHILD WCD DATE
<del>PCN</del> NSN PIN 15025A	15025A	88054	65	370	<del>PCN</del> NSN PIN Misc	15025A	88054
<del>PCN</del> NSN PIN 15113A	15113A	88054	65	370	<del>PCN</del> NSN PIN Misc	15113A	88054
<del>PCN</del> NSN PIN 15136A	15136A	88055	40	160	<del>PCN</del> NSN PIN Misc	15136A	88055
<del>PCN</del> NSN PIN 15137A	15136A	88055	40	160	<del>PCN</del> NSN PIN Misc	15136A	88055
<del>PCN</del> NSN PIN 15150A	15150A	88054	30	130	<del>PCN</del> NSN PIN Misc	15150A	88054
<del>PCN</del> NSN PIN 15140A	15140A	89073	30	130	<del>PCN</del> NSN PIN Misc	15140A	89073
<del>PCN</del> NSN PIN 15175A	15175A	89073	60	180	<del>PCN</del> NSN PIN Misc	15175A	89073
<del>PCN</del> NSN PIN 15178A	15178A	88054	22	90	<del>PCN</del> NSN PIN Misc	15178A	88054
<del>PCN</del> NSN PIN 15183A	15153A	88055	60	170	<del>PCN</del> NSN PIN Misc 88	15153A	88055
<del>PCN</del> NSN PIN 15189A	15153A	88055	60	170	<del>PCN</del> NSN PIN Misc 89	15153A	88055
<del>PCN</del> NSN PIN 15191A	15151A	88055	60	170	<del>PCN</del> NSN PIN Misc 91	15151A	88055
<del>PCN</del> NSN PIN 15192A	15151A	88055	60	170	<del>PCN</del> NSN PIN Misc 92	15151A	88055

# PARALLEL PROCESS PROFILE

NAME <u>Bofano</u>		ALC <u>OC</u>		DATE <u>4/24/89</u>		RCC		SHEET <u>2</u> OF <u>2</u>		
ITEM NUMBER		PARENT WCD		PARENT WCD DATE		BEGINNING OPERATION NUMBER	ENDING OPERATION NUMBER	CHILD PROCESS INFORMATION		
								ITEM NUMBER	CHILD WCD	CHILD WCD DATE
<del>PCN</del> NSN PIN	15236A	15236A	88054	80	150	<del>PCN</del> NSN PIN	Misc	15236A	88054	
<del>PCN</del> NSN PIN	15237A	15237A	88054	60	150	<del>PCN</del> NSN PIN	Misc	15237A	88054	
<del>PCN</del> NSN PIN	15249A	15249A	88055	55	70	<del>PCN</del> NSN PIN	Misc	15249A	88055	
<del>PCN</del> NSN PIN	15250A	15250A	88055	55	70	<del>PCN</del> NSN PIN	Misc	15250A	88055	
<del>PCN</del> NSN PIN	15126A	15126A	89073	30	120	<del>PCN</del> NSN PIN	Misc 26	15126A	89073	
<del>PCN</del> NSN PIN	15300A	15126A	89073	30	120	<del>PCN</del> NSN PIN	Misc. 300	15126A	89073	
<del>PCN</del> NSN PIN						<del>PCN</del> NSN PIN				
<del>PCN</del> NSN PIN						<del>PCN</del> NSN PIN				
<del>PCN</del> NSN PIN						<del>PCN</del> NSN PIN				
<del>PCN</del> NSN PIN						<del>PCN</del> NSN PIN				
<del>PCN</del> NSN PIN						<del>PCN</del> NSN PIN				
<del>PCN</del> NSN PIN						<del>PCN</del> NSN PIN				
<del>PCN</del> NSN PIN						<del>PCN</del> NSN PIN				

S13 257 7114

5/23

5/10  
19.510  
1.0837

# MANPOWER PROFILE

ALC		DATE		RCC		SHEET		OF																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																								
JOB CODE LEVEL	JOB DESCRIPTION	COUNTER	QUANTITY AVAILABLE						MANPOWER AVAILABLE (HOURS)						ALTERNATE JOB CODE LEVEL																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																	
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			1	2	3	1	2	3	1	2	3	1	2	3		1	2	3	1	2	3																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																											
AS	LEFT HAND SIDE COWL	1	24			5																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																										</

1) 1st 180 hrs  
15 swing

2) 2nd 180  
14

# MANPOWER PROFILE

JOB DESCRIPTION		COUNTER	QUANTITY AVAILABLE						MANPOWER AVAILABLE (HOURS)						ALTERNATE SHEET CODE LEVEL	
CODE LEVEL			WORK WEEK		WEEKEND		HOLIDAYS		WORK WEEK		WEEKEND		HOLIDAYS			
			1	2	3	1	2	3	1	2	3	1	2	3		
FS	Misc	1	48			10				5.6			7.24			
		2	48			7				5.7			7.24			
		3	50			15				5.9			7.24			
		4	57			11				5.8			7.24			
CS	Swing	1	15							5.6						
		2	14							5.7						
		3	16							5.9						
		4	14							5.8						
		1														
		2														
		3														
		4														
		1														
		2														
		3														
		4														
		1														
		2														
		3														
		4														

DATE \_\_\_\_\_ SHEET 05

### **5.1 PROFILE DATA FILES**

The profile data files for RCC MABPAB were previously submitted under memo number NKE-E016-6955, dated June 5, 1989.

## **5.2 MODEL INPUT FILES**

The model input files for RCC MABPAB were previously submitted under memo number NKE-E016-6955, dated June 5, 1989.

## **6.0 VALIDATION OF INPUT DATA**

All profile data was validated in accordance with paragraph 7.2 and 7.3 of the Simulation Model Definition Document (SMDD). The profile data as included in this document were validated and accurately represent this RCC.

# TI VALIDATION FORM

RCC

MABPAB

ALC

OC-ALC

TITLE SHEET METAL SHOP

## REMARKS

THE SIMULATION MODEL FOR OC-ALC MABPAB, SHEET METAL SHOP, IS AN APPROXIMATION OF THE MABPAB "AS IS" CONDITION AND ESTABLISHES A BASELINE RECOMMENDED TO BE ACCEPTED AND USED FOR EXPERIMENTATION AND RELEASE. THE FOLLOWING CONTINGENCY APPLY FOR FINAL ACCEPTANCE:

1. VERIFY THAT THE MODEL WILL LOAD AND RUN ON THE OC-ALC VAX SYSTEM.

MDMSC WILL BRING THE MODEL TO OC-ALC, LOAD AND RUN THE MODEL TO ASSURE COMPATIBILITY WITH THE OC-ALC VAX SYSTEM AS A CONDITION FOR FINAL ACCEPTANCE OF THE MODEL AND THE DATA FROM BOTH THE OC-ALC & MDMSC VAX SYSTEMS ARE COMPARABLE

2. PROVIDE TO OC-ALC AND HQ AFLC A COPY OF THE UPDATED MODEL FLAT FILES TO VERIFY THAT INPUTS MADE TO THE MANPOWER AND OPERATIONS PROFILES CHANGED THE OUTPUTS AS PREDICTED PROVIDING AN ACCEPTED BASELINE.

CHANGES

- (A) REDUCTION OF 10.87% BY EACH OPERATIONS
- (B) UPGRADE MANPOWER FACTOR BY 11.2%
- (C) REDUCTION OF 19.5% OF MANPOWER

APPROVAL RECOMMENDED

ALC

Earl E. Stamps  
5-24-89

AFLC REP.

John A. Brown  
5/24/89

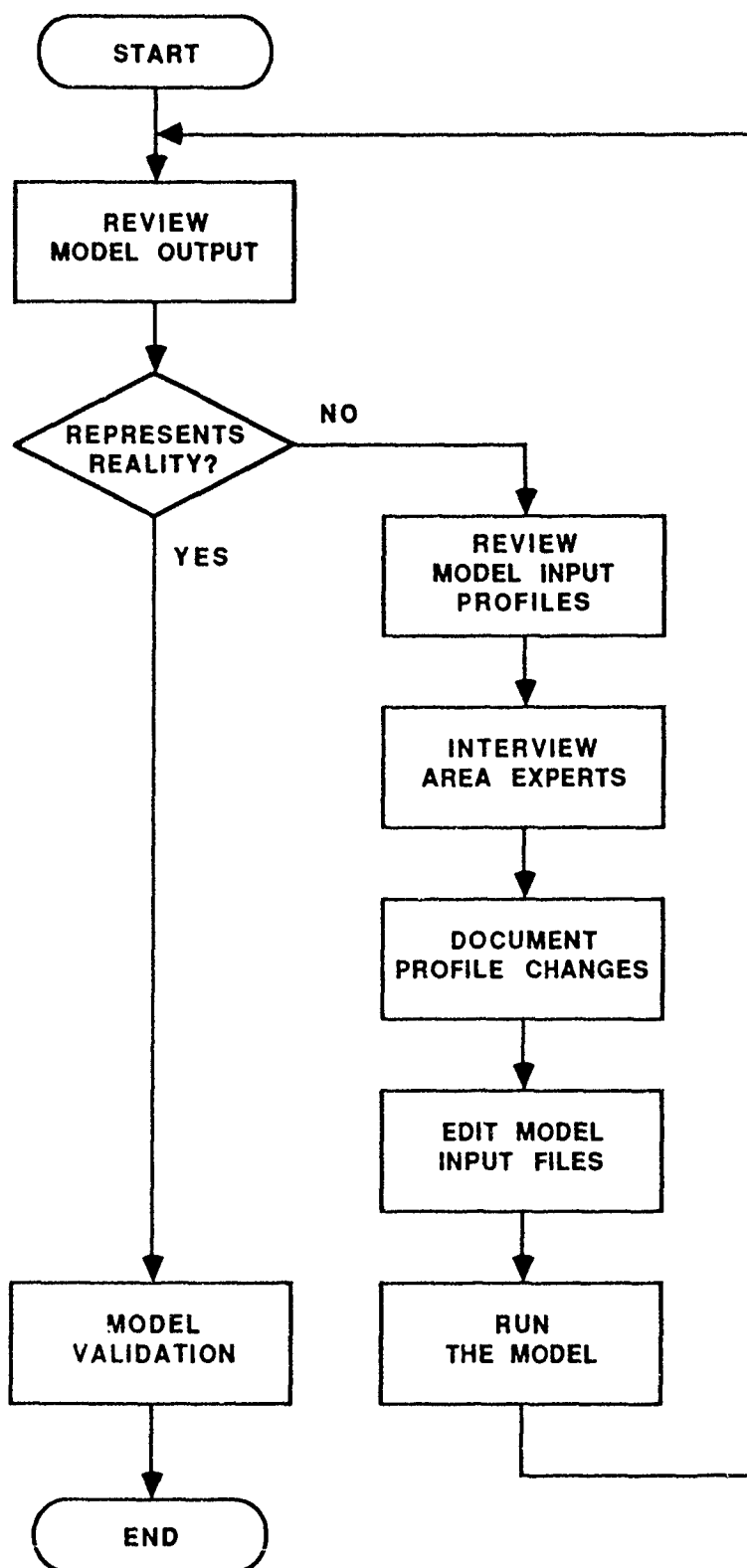
MDMSC

R. B. Brown 5/24/89

AFLC HQ..

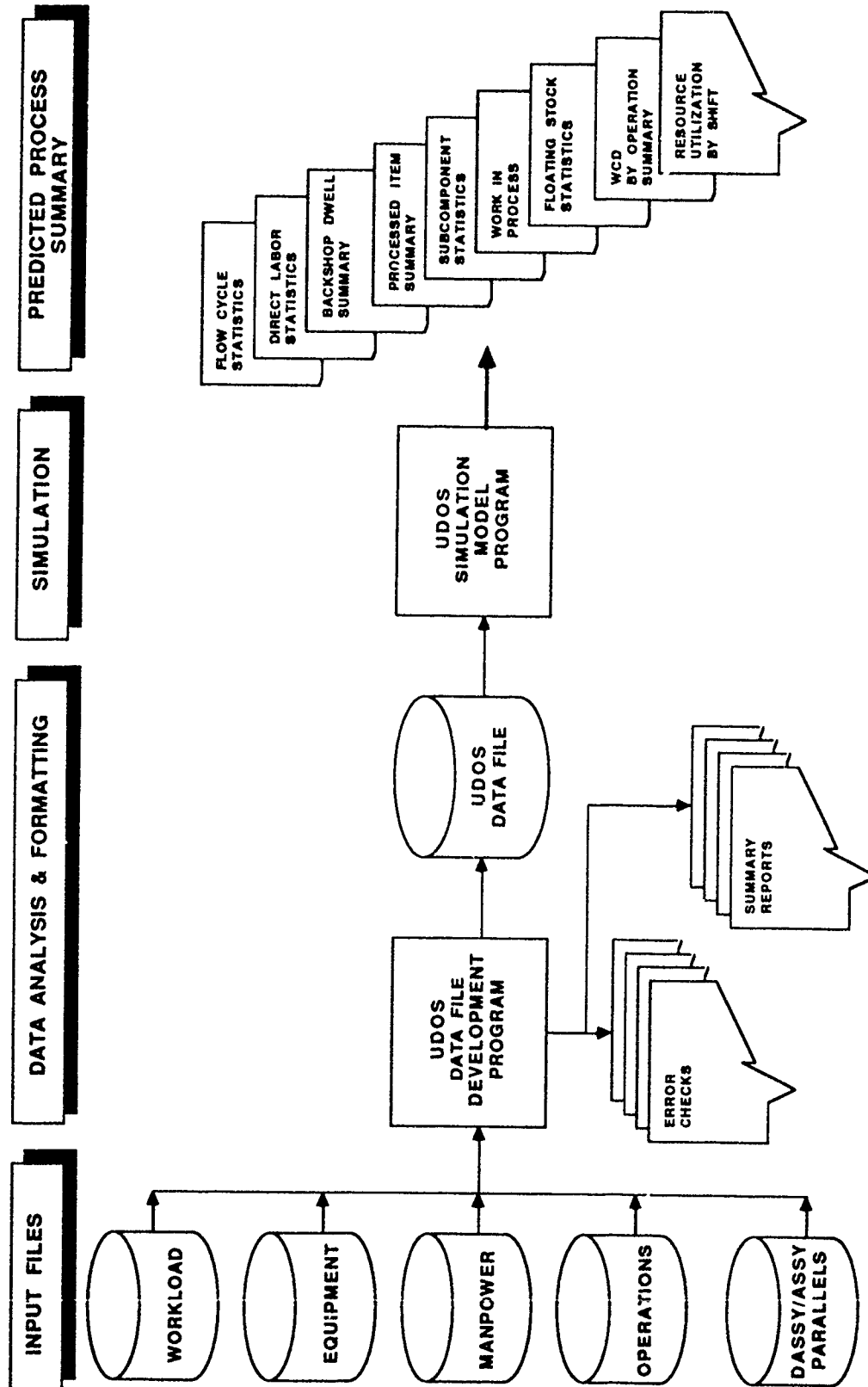
D. Cripe





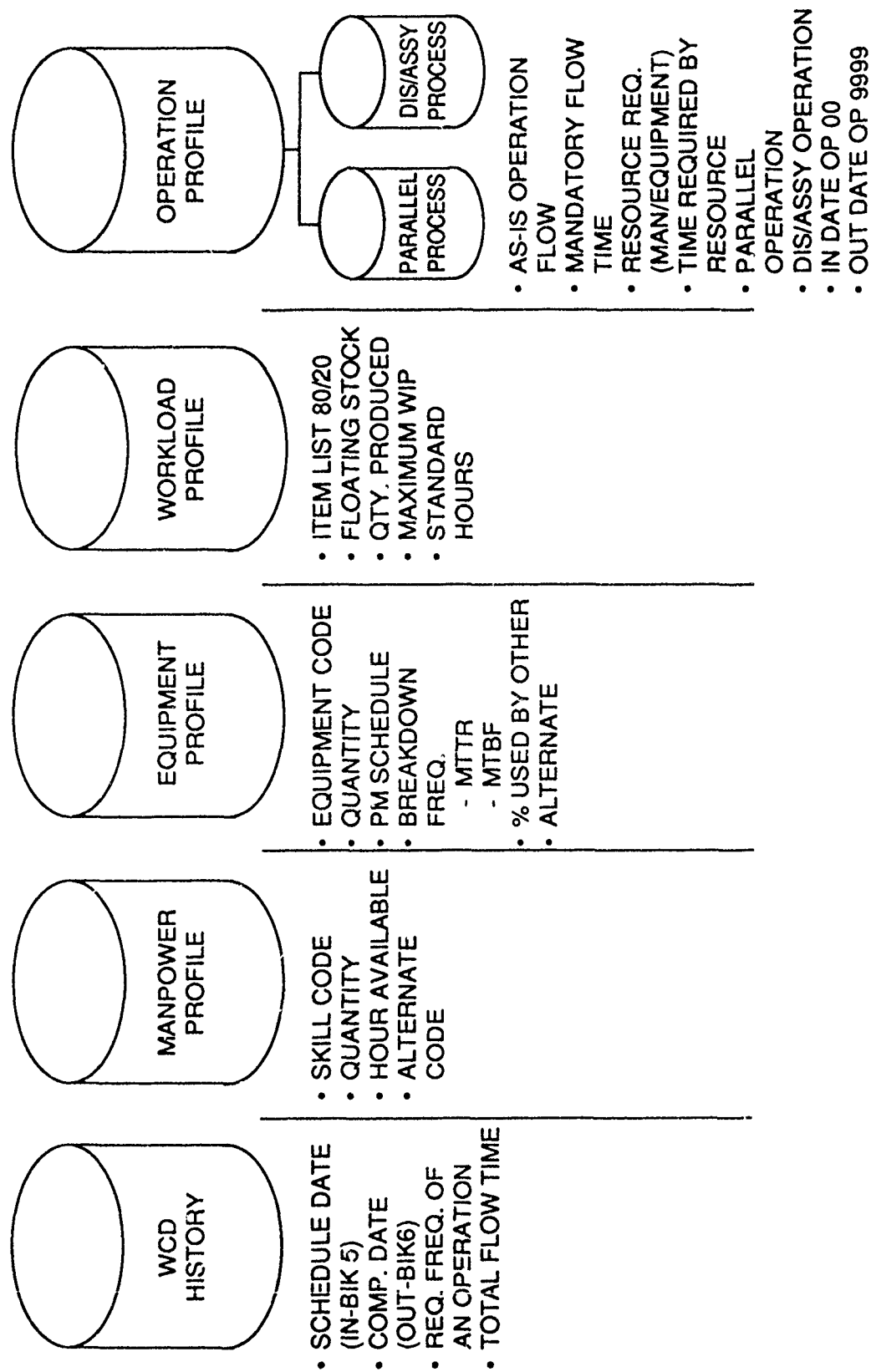
LSC-20456

**MABPAB MODEL VALIDATION PROCESS**



LSC-20462

UNIVERSAL DEPOT OVERHAUL SIMULATOR (UDOS 2.0) FUNCTIONAL FLOW DIAGRAM



## TI DATA BANK/SIMULATION MODEL

## VALIDATION PROCEDURE FOR OC-ALC

DRAFT

1. List all assumptions used during data collection
2. Determine criterion the model output must meet to be considered valid (i.e. 80% confidence level)
3. Compare historical flow time to simulated flow time and number of samples to FY89 output. Compare the two areas by calculating the variance and percent variance between the two (Atch 1). (For flow time comparison can use the statistical validation can be used if available)
4. Any comparisons not within the confidence level must be investigated further to determine reasons for not meeting this criterion (Atch 2).
  - Check inductions (are they constant or sparatic)
  - Check percent variance between merchanics estimate, standoard and history for labor hours. If large discrepancy, may need to investigate each source once again)
  - Check equipment utilization and verify with shop floor
  - Check personnel utilization and verify with shop floor
  - Check queuing on there resources and verify with shop floor
5. Once these areas have all been evaluated, does everyone feel they understand why the discrepancy is there or can it be adjusted using information obtained through the evaluation. If everyone is comfortable with the model output then we can conclude the model is valid. If there are several items that can not be explained then the model is not valid.



## DIRECT LABOR STATISTICS

ITEM	EXPECTED HOURS	STANDARD HOURS	SIMULATED AVERAGE LABOR HOURS	STANDARD DEVIATION	SIMULATED MINIMUM LABOR HOURS	SIMULATED MAXIMUM LABOR HOURS	NU SA
113A	12.49	147.70	118.22	8.66	103.36	136.29	
1025A	11.59	143.50	120.82	5.38	106.66	149.20	
119A	11.01	139.80	119.86	0.41	106.33	144.51	
121A	11.86	190.20	112.67	1.78	105.83	164.57	
120A	15.00	200.00	155.30	3.77	147.20	197.40	
137A	16.00	200.00	166.83	3.08	151.09	185.14	
140A	17.00	200.00	170.84	1.73	164.64	177.85	
145A	14.00	170.00	137.08	2.67	140.43	154.90	
1778A	12.25	159.00	122.67	1.82	114.10	167.80	
188A	19.33	200.00	192.71	3.86	164.28	228.53	
189A	18.88	200.00	185.93	3.77	161.55	215.32	
189A	14.88	200.00	145.78	2.05	130.45	175.57	
192A	17.33	200.00	173.40	2.76	158.08	190.38	
192A	14.77	200.00	143.02	1.41	138.00	150.11	
193A	10.22	150.00	108.75	1.60	106.33	116.87	
2237A	15.93	200.00	158.08	2.87	140.60	196.63	
2237A	11.30	150.00	115.75	1.85	107.22	130.84	

PCN: 15140A

DRAFT

- Simulated flow hours are 36.4% higher than standard flow hours
- Inductions 1, 0, 4, 40
  - sparatic (this will cause problems)
- Mechanic estimate 25.3% higher than standard
  - contributes to variance
- Equipment
  - 140 bench: until .06 1st
    - queue quantity = Avg= .07 , MAX=4 Time=hrs=3.26
    - operations 30-40, 100-270
  - F135 - 08: until 19% 1st
    - Queue quantity Avg=.61 Max=15 hrs=4.75
    - Operations 50-90 (large queues these operations) 25 hrs vs 105.16
- Manpower FS: Until 40% (not available 37%)
  - queue quantity Avg=18.94, Man=72, Time=1.10 hrs
- OC\_ALC feels that the 36.4% error is due to the following reasons:
  - large inductions 4th. quarter (Production worked many different hours 10hrs, 12hrs, 2nd shift 2-5 days a week and weekends when necessary. Production also assigned personnel to specifically work these items 100% of time out of GS skill level, the model does not reflect this because 90% of the time GS skill is alternate for all other skills and not specifically assigned to work one item. Due to all these different Scenarios OC-ALC feels that the model handles this PCN the best way possible since it was their decision to keep data in a business as usual form and not Taylor it to handle special cases.
- Equipment Utilization is 24%, this looks low but keep in mind utilization is based on one year and 95% of the workload for this, PCN was done in the 4th quarter.
- Bench Utilization is low because mechanic uses bench to set tools etc., but the part is not actually tying up the bench.

DRAFT

PCN: 15126A (Main Landing Gear Door)

- Simulated flow hours are 23.9% lower than STD flow hours
- Inductions 13, 16, 20, 20
  - Consistent
- Mechanic Estimate is 55.8% lower than standard
  - Contributes to variance
- Equipment
  - 126 bench utility 14%
    - queue quantity Avg = .01 MAX = 5 Hrs = .33
    - operations 30-70 and 210 -220
  - F335 - 09 util 32%
    - operations 80-200 (19.5 Hrs vs 93.89 hr)
    - queue quantity Avg=.05, MAX=7, hrs=.42
- Manpower FS util = 40% (not available 37% time)
  - queue quantity Avg=18.94 MAX=72, Time=1.10
- DC-ALC feels that the 23.9% error is due to the mechanics estimate and personnel shortage. The model basically depict the "As Is" condition for FY88.



DRAFT

PCN: 15119A (Main Landing Gear Door)

- Simulated Hrs is 25.2% higher than STD hours
- Induction 13, 16, 20, 20
  - Consistant
- Mechanic estimated flow-times 12.5% higher than std.
  - This plays in the variance
- Equipment
  - 119 bench: util 46% day
    - Operation 30-60, 190-200, 230 (53.2hrs 52.7% vs 167.47)
    - Queue quantity Avg=.51 Max=11 Hrs = 2.21
  - F335-08 - utili=40%
    - Operation 70-170, 210 (18.93Hrs vs 77.06 Hrs)
    - Queue quantity Avg=.32' Max=10 Hrs=1.91
- Manpower FS - util = 40 (unavailable 37%)
- DC-ALC feels that the 25.2% error is due to personnel shortage and mechanics estimate, since model shows basically what happens on the shop floor.

PCN: 15175A

**DRAFT**

- Simulated flow hours are 35.8% higher than standard flow hours
- Inductions 25, 12, 8, 26
  - Sparatic (most work done 1st and 4th quarter)
- Mechanic Estimate is 41.1% lower than standard
  - unusual situation the simulated flow time is higher than standard and mechanics estimate is lower
- Equipment
  - 175 bench: util 4%
    - operation 20, 40, 60, 425, 480
    - queue quantity = Avg = .01, Max=2. Time=.9 Hrs - F135 -18: 64% (91% 1st and 2nd quarter)
    - operation 70-310
    - queue quantity Avg=.66 Max=9 Time= 1.48 Hrs
- Manpower FS: Util - 40% (not available 37%)
  - Queue quantity Avg=18.94 Max=72. Time=1.10
- Bench 175 utilization so low because mechanic actual uses bench for tools and personnel items. the part does not tie up the bench it ties up the fixture.

DRAFT

PCN: 15321A (Main landing Gear Door)

- Simulated Hrs are 23.2% higher than STD hours
- Inductions 13, 16, 20, 20
  - Consistant
- Mechanic Estimates 26.2% higher than STD
  - This definitely contributes to variance
- Equipment
  - 119 bench util 46%
    - operation 30-60, 230
    - queue quantity Avg = .51, MAX=11 Hrs=2.21
  - F335-08 Util 40%
    - operations 70-220
    - queue quantity Avg=.32 MAX=10, Hrs=1.91
- Manpower FS - Util
- CC\_ALC feels that the 23.2% error is due to personnel shortage and mechanics estimate. Model basically depicts the "As Is" condition for FY82.

**DRAFT**

PCN: 15300A (Main Landing Gear Door)

- Simulated flow hours are 25.5% lower than standard flow hours
- Inductions 13, 16, 20, 20
  - consistent
- Mechanics estimate is 62.7% lower than standard
  - contributes to variance
- Equipment
  - 126 bench util=14%
    - Operation 30-70
    - queue quantity=Avg=.01, Max=5 Hrs=.33
  - F335-09 Util=32%
    - Operations 80-220
    - Queue quantity = Avg .05, Max 7, Hrs =.42
- Manpower FS utility 40% (not available 37%)
  - queue quantity Avg=4.75, Max=15, Time = .77hrs
- DC\_ALD feels that 25.5% error is due to the mechanics estimate and personnel shortage. The model basically depicts the "As Is" condition for FY88.

**TECHNOLOGY INSERTION ENGINEERING SERVICES  
UNIVERSAL DEPOT OPERATIONS SIMULATOR (UDOS)  
VERSION 2.0  
VALIDATION AND BRAINSTORMING SESSION  
FOR  
OKLAHOMA CITY AIR LOGISTICS CENTER (OC-ALC)  
RESOURCE CONTROL CENTER (RCC) MABPAB  
22-24 MAY 1989**

**VALIDATION MINUTES**

**CONTRACT NO. F33600-88-D-0567**

-----  
**TRIXIE BROWN  
AFLC/MAQF**

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**RICARDO BOLANOS  
MDMSC**

-----  
**LOU MAVROS  
MANAGER, PROCESS  
CHARACTERIZATION  
MDMSC**

**MCDONNELL DOUGLAS**  
**McDonnell Douglas Missile Systems Company**  
**St. Louis, Missouri 63166-0516 (314) 232-0232**

## **1.0 PURPOSE AND OBJECTIVE**

This validation and brainstorming session was conducted at the Oklahoma City Air Logistics Center (OC-ALC), Tinker AFB, building 95 on 22-24 May 1989 to perform validation using the Universal Depot Operations Simulator (UDOS) Version 2.0 with Resource Control Center (RCC) MABPAB Sheet Metal Shop data sets. On the afternoon of 24 May 1989, after conditional validation of the Model, a Brainstorming Session, involving the same participants, was conducted.

The objective of the UDOS 2.0 Validation was to establish the MABPAB Model as a valid baseline characterization of the RCC "As-Is" condition.

The objective of the Brainstorming Session was to identify the Taguchi factors and levels to be used in UDOS 2.0 model experimentation for MABPAB.

## **2.0 SUMMARY**

The following presentations were made during the OC-ALC/MABPAB UDOS 2.0 Validation:

- Introduction - Mr. Earl Stamps OC-ALC/MABEBS
- MABPAB Overview - Mr. Ricardo Bolanos MDMSC
- Model Input Profiles - Mr. Ricardo Bolanos MDMSC
- Model Expectations - Mr. Ricardo Bolanos MDMSC
- Model Output Profiles - Mr. Scott Vroman MDMSC
- Conclusions - Mr. Ricardo Bolanos MDMSC

No formal presentations were made during the Brainstorming Session. This session was conducted as described in paragraph 2.7.

All discussions during the Validation and Brainstorming Session are summarized in the following subordinate paragraphs. The list of attendees, revised agenda, presentation materials, validation form, action items and model input/output file printouts are included as enclosures referenced in paragraphs 3.0 through 8.0 respectively.

## **2.1 INTRODUCTION**

Mr. Earl Stamps, MABEBS Branch Manager, introduced the purpose of the session: validation of the MABPAB UDOS 2.0 Model. Subsequently, Mr. Stamps asked each participant to introduce himself/herself to the group by stating his/her name and the organization he/she represented. (Enc. 1)

## **2.2 MABPAB OVERVIEW**

Mr. Ricardo Bolanos, MDMSC representative and session chair-person, opened by stating that this was the culmination of MDMSC/ALC effort. He emphasized the fact that it was the total cooperation of all MABPAB personnel that enabled MDMSC personnel to arrive at a valid model of MABPAB. Mr. Bolanos specifically thanked Mr. Earl Stamps, Mr. Jim Dodson, Mr. Larry Mullinax and Ms. Janis Wood for their considerable contributions to the MABPAB process characterization effort. After a brief review of the MABPAB Process Characterization schedule, the Flow Process Charts utilized to depict RCC "As-Is" condition and an explanation of the process that would be used to validate the MABPAB UDOS 2.0 Model, Mr. Bolanos proceeded to review the Model input data profiles.

## **2.3 MODEL INPUT DATA PROFILES**

### **2.3.1 Workload Profile**

Mr. Bolanos explained that Mr. Stamps had provided FY88 actual production figures which enabled development of an approximation of workload percentages for MABPAB. Ricardo used Item Codes 15025A, 15113A, 15140A and 15150A as examples to explain the fluctuations in the fourth quarter workload which would require special conditions to accomplish this workload given the resources and time available. A lengthy discussion followed, during which explanations were given of the special conditions that enabled this performance.

### **2.3.2 Manpower Profile**

Next, Mr. Bolanos presented the manpower profile of MABPAB. He stated that the basis for this profile was FY88 data gathered from extensive interviews and record review. The labor profile presented was divided into Work Week (Monday - Friday, Shifts 1 - 3), Week Ends (Saturday & Sunday, Shifts 1 - 3) and Holidays (Shifts 1 - 3). Each category was further subdivided into quarters. Mr. Bolanos went on to explain the Quantity Available versus Manpower Available sections of the profile. He explained

that the 5.6 and 7.1 manpower factors presented provide an ability for the model to account for time not available by each individual due to breaks, absence, vacation, training, etc. in a given eight hour work shift.

#### **2.3.3      Equipment Profile**

The equipment profile for MABPAB was presented next. Mr. Bolanos explained that the equipment profile addresses large pieces of equipment only (not hand tools). He went on to explain that unscheduled maintenance down time (MTBF & MTTR) data was not available for MABPAB. (MTBF and MTTR data for MABPAB equipment has not been retained. Mr. Bolanos went on to explain the data pertinent to the equipment characterized, tied to the 80/20 workload of the RCC was available. In response to a question from Mr. Stamps, Ricardo explained that the 43% figure shown for some equipment under "% USED NOT AVAILABLE" represents time that the equipment is in use for tasks not defined in the 80/20 workload.

#### **2.3.4      Operation Profile**

Ricardo explained that this profile is directly related to the Flow Process Chart presented earlier in his presentation. He proceeded to describe the profile using the example Flow Process Chart. He explained that the frequency (Occurrence Factor) for each operation was obtained from shop floor interviews with mechanics. In response to Mr. Gene Leiterman's question regarding supervisory involvement in these occurrence factor assessments, Ricardo responded that both mechanics and supervisors were involved in these assessments. In addressing the lack of WCD history, Ricardo explained that the bench mark for evaluating the reality of the interview data was comparison of the model with Standard Flow Days which would be covered later in the presentation. It was also stated that the historical flow times that were available were of insufficient accuracy for meaningful comparison. The following are examples:

<u>PART NO.</u>	<u>WCD FLOW HOURS</u>	<u>SIMULATED FLOW HOURS</u>
15025A	1,628	848
15113A	1,276	810
15119A	1,178	571
15175A	4,183	716



It would not be possible to simulate FY88 production actuals using the historical WCD data for these parts.

#### **2.3.5 Disassembly & Assembly Profile**

This profile was also explained in relation to the Flow Process Chart.

### **2.4 MODEL EXPECTATIONS**

Mr. Bolanos stated that in order to validate the model three items must be established to the satisfaction of the group:

- The Model does Simulate an Approximation of Reality
- The Model Establishes a Baseline
- The Model Provides a Useful Tool For Exploring the Effect of Change.

### **2.5 MODEL OUTPUT PROFILES**

#### **2.5.1 Process Times Summary**

Ricardo presented the 80/20 work load simulation flow hours summary for one year of RCC production: waiting for resources, processing hours, back shop hours. Lengthy discussions regarding the basis for expected flow days. Due to the lack of historical WCD data for FY88, MDMSC used shop floor interview data to calculate these expected flow days and then compared these calculations to standard flow days. After much detailed discussion and lengthy explanations, it was agreed that what was actually produced in FY88 was input to the model and that this would be the key to validating model throughput. Next lengthy and detailed discussions of personnel utilization and overtime. Mr. Stamps summarized this by stating that he had no problem moving the resources around to match the real world, provided the bottom line remained the same. Ricardo introduced Mr. Scott Vroman who conducted the remainder of the discussions and presentations concerning Model output.

#### **2.5.2 Workload Distribution Profile**

Mr. Vroman explained this profile with emphasis on what MABPAB actually produced in FY88 versus what the model simulation produced.

### **2.5.3      Direct Labor Hours Profile**

After explaining the profile, Scott was asked how closely the mechanics interview times compared with the standard times. He responded that in many cases they were very close and that in some cases they varied widely. He went on to state that since the later case represented only 2 - 3% of the workload, the impact on model performance was negligible. Ricardo stated that a summary report of interviews versus standard hours, by part number, will be available and that any statistical model output data will also be available. There was consensus that the numbers, when compared to control numbers are very close.

### **2.5.4      Estimated Flow Days Vs. Simulated Flow Days Profile**

There was also concurrence that this profile made sense. Mr. Stamps emphasized that the group must be satisfied that this profile represents a good baseline. Scott suggested that this could be accomplished by comparing estimated vs. simulated columns in the profile, using the estimated flow days column as the control column.

### **2.5.5      Processing Summary**

Scott presented three summaries: back shop hours, initial waiting hours (for manpower, equipment and subcomponents) and processing hours. Mr. Stamps and Ms. Wood offered clarification that the initial waiting represents the total time waiting between operations. A lengthy discussion regarding the results presented for part numbers 15113A and 15025A.

### **2.5.6      Back Shop Hours and Occurrence Factor Profile**

This presentation resulted in lengthy discussion and explanation of the use of interview data for back shop occurrence factors. Various control documents were reviewed. It was finally agreed that historical data would be the best source of this model input. However, due to the lack of accurate history, the interview data was the best currently available and must be used. Inconsistencies similar to the examples given in paragraph 2.3.4 existed for back shop historical data.

### **2.5.7      What If Scenarios**

Scott proceeded to present three "What If?" scenarios. First, he explored the results of reducing all skill code manpower by 20%. He explained that any reduction in manpower must consider the workload. Otherwise, queues will build all over the place. Discussions regarding these effects.

The second "What If?" scenario presented involved reducing only the ES and SF skill codes by 20%. This exercise demonstrated that there was little impact on model output due to the fact that ES and FS skill codes are primarily involved with operations outside of the 80/20 workload of the RCC.

The third "What If?" scenario addressed the effects of increasing the workload for part 15113A to 90 per quarter. This resulted in an increase in flow time from 46 days to 70 days

#### **2.5.8      Trial Install of MABPAB UDOS 2.0 Model on OC-ALC VAX**

There were discussions concerning the desirability to trial install and run the model on the OC-ALC VAX computer to insure that it would run properly when delivered. Mr. Mavros, MDMSC Deputy Program Manager, agreed that this would be desirable for all concerned and directed MDMSC personnel in St. Louis to cut a tape of all required files and ship the tape to OC-ALC. Mr. Mavros emphasized that this would not constitute delivery of the software which was governed by other contractual requirements. The tape was subsequently shipped and a trial run was attempted. This attempt was unsuccessful due to problems with the tape. Mr. Vroman returned to OC-ALC 1 June 1989 with a good tape and successfully completed the trial run.

#### **2.6    VALIDATION & CONCLUSIONS**

All attendees concurred that the model of MABPAB met the expectations established for validation, and the Validation Form was signed by Mr. Stamps, Ms. Brown and Mr. Bolanos. This validation is contingent on MDMSC performance of the two action items cited on the Validation Form.

## ISSUES TO VALIDATE\*

5/24/89

- \* 1) Print-out with new numbers Down 10.87% by OP  
UP 11.2% MP EFF.  
Down 19.5%
- 2) GS ALTERNATE to all.
- 3) 15140A 4<sup>th</sup> Qtr
  - EXCEPTIONAL RISE
  - 4<sup>th</sup> Qtr high INDUCTIONS
  - CHERRY PICKED.
  - ASSIGNED SELECTED PERSONEL to that ARE
  - 2<sup>nd</sup> shift.
- 4) 19.5% MAN-POWER REDUCTION.
- 5) CHANGE STDS to update REV. on 15119A, 15321A, 15126A, 15300A, 15136A, 15137A, 15175A & 152.
- \* 6) LOAD MODEL & RUN ON VAX AT MLC.

# TI VALIDATION FORM

RCC

MABPAB

ALC

OC-ALC

TITLE SHEET METAL SHOP

## REMARKS

THE SIMULATION MODEL FOR OC-ALC MABPAB, SHEET METAL SHOP, IS AN APPROXIMATION OF THE MABPAB "AS IS" CONDITION AND ESTABLISHES A BASELINE RECOMMENDED TO BE ACCEPTED AND USED FOR EXPERIMENTATION AND RELEASE. THE FOLLOWING CONTINGENCY APPLY FOR FINAL ACCEPTANCE:

1. VERIFY THAT THE MODEL WILL LOAD AND RUN ON THE OC-ALC VAR SYSTEM.

MDMSC WILL BRING THE MODEL TO OC-ALC, LOAD AND RUN THE MODEL TO ASSURE COMPATIBILITY WITH THE OC-ALC VAR SYSTEM AS A CONDITION FOR FINAL ACCEPTANCE OF THE MODEL AND THE DATA FROM BOTH THE OC-ALC & MDMSC VAR SYSTEMS ARE COMPARABLE

2. PROVIDE TO OC-ALC AND HQAFLC A COPY OF THE UPDATED MODEL FLAT FILES TO VERIFY THAT INPUTS MADE TO THE MANPOWER AND OPERATIONS PROFILES CHANGED THE OUTPUTS AS PREDICTED PROVIDING AN ACCEPTED BASELINE.

CHANGES

(A) REDUCTION OF 10.87% BY EACH OPERATIONS

(B) UPGRADE MANPOWER FACTOR BY 11.2%

(C) REDUCTION OF 19.5% OF MANPOWER

APPROVAL RECOMMENDED

ALC

Earl E. Stamps  
5-24-89

AFLC REP.

Tracy R. Brown  
5/24/89

MDMSC

K. J. [Signature] 5/24/89.

AFLC HQ..

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D. Cripe

FLOW CYCLE TIME STATISTICS

ITEM	STAMPED WCD's		HISTORICAL FLOW TIME HOURS	AVERAGED SIMULATED FLOW TIME HOURS	STANDARD DEVIATION	SIMULATED MINIMUM FLOW TIME HOURS	SIMULATED MAXIMUM FLOW TIME HOURS	NUMBER OF SAMPLES
	OBS #	FLOW HOURS						
113A	54	1276	864.00	640.87	73.59	508.64	843.13	242
113A	28	1628	864.00	661.01	166.56	589.47	1083.18	227
113A	44	1178	432.00	614.93	86.68	385.47	702.18	68
113A	20	1015	432.00	515.01	26.66	390.79	794.26	68
113A	36	893	432.00	326.91	28.06	247.34	507.16	75
113A	18	372	432.00	416.76	79.43	265.48	722.87	70
113A	11	741	504.00	471.38	57.13	311.25	581.02	23
113A	19	1235	504.00	671.97	208.68	412.55	1061.22	23
113A	34	1453	528.00	511.05	193.81	433.79	868.08	27
113A	24	4183	456.00	402.53	42.95	330.95	546.18	27
113A	2	360	840.00	918.21	128.33	635.09	1503.54	4
113A	40	1011	0.00	262.87	139.53	170.53	363.49	60
113A	44	873	0.00	262.87	139.53	170.53	363.49	60
113A	5	715	0.00	262.87	139.53	170.53	363.49	60
113A	10	814	0.00	262.87	139.53	170.53	363.49	60
113A	41	1028	864.00	262.87	139.53	170.53	363.49	60
113A	9	731	864.00	262.87	139.53	170.53	363.49	60
113A	9	3235	864.00	262.87	139.53	170.53	363.49	60
113A	6	1728	864.00	262.87	139.53	170.53	363.49	60
113A	13	1639	864.00	262.87	139.53	170.53	363.49	60
113A	N/A	N/A	864.00	262.87	139.53	170.53	363.49	60
113A	4	156	864.00	262.87	139.53	170.53	363.49	60
113A	7	833	864.00	262.87	139.53	170.53	363.49	60
113A	8	1731	864.00	262.87	139.53	170.53	363.49	60

NO VALUES RECORDED

UPDATE THE MANPOWER FACTOR WITH OVERTIME

IN DS, ES, FS UPGRADE O.T FACTOR FROM 7.1 TO 7.24

IN BS INCREASE MANPOWER LEVELS BY 7, 6, 7, 6

80.5% WL

1<sup>st</sup>  $\rightarrow$  4.50

2<sup>nd</sup>  $\rightarrow$  4.59

3<sup>rd</sup>  $\rightarrow$  4.75

4<sup>th</sup>  $\rightarrow$  4.67

5.83

141.1

2A

4

5 1

14 0

INDUCTIONS OF ITEM 15113A 53 70  
 INDUCTIONS OF ITEM 15025A 54 75  
 INDUCTIONS OF ITEM 15119A 20 20  
 INDUCTIONS OF ITEM 15321A 20 20  
 INDUCTIONS OF ITEM 15126A 20 20  
 INDUCTIONS OF ITEM 15300A 20 20  
 INDUCTIONS OF ITEM 15136A 23 22  
 INDUCTIONS OF ITEM 15137A 23 21  
 INDUCTIONS OF ITEM 15140A 4 40  
 INDUCTIONS OF ITEM 15150A 35 56  
 INDUCTIONS OF ITEM 15175A 8 15  
 INDUCTIONS OF ITEM 15178A 54 75  
 INDUCTIONS OF ITEM 15128A 15 17  
 INDUCTIONS OF ITEM 15189A 15 17  
 INDUCTIONS OF ITEM 15122ASUB1 15 17  
 INDUCTIONS OF ITEM 15189ASUB1 15 17  
 INDUCTIONS OF ITEM 15191A 16 17  
 INDUCTIONS OF ITEM 15192A 10 17  
 INDUCTIONS OF ITEM 15191ASUB1 15 17  
 INDUCTIONS OF ITEM 15192ASUB1 10 17  
 INDUCTIONS OF ITEM 15236A 9 9  
 INDUCTIONS OF ITEM 15237A 0 0  
 INDUCTIONS OF ITEM 15249A 23 20  
 INDUCTIONS OF ITEM 15250A 23 20  
 INDUCTIONS OF ITEM 15237ASUB1 10 9

TOTAL ITEM INDUCTIONS 519 668

ALC: 10 SCC: MABPAB QUARTER: 4 DATE: 20-MAY-89 TIME: 16:08:26 REPT: 1

INDUCTIONS

1ST QTR 2ND QTR 3RD QTR 4TH QTR



FLOW /CLE TIME STATISTICS

NUMBER OF ITEM SAMPLES	HISTORICAL FLOWTIME HOURS	AVERAGE		STANDARD DEVIATION	SIMULATED		SIMULATED MAXIMUM FLOW TIME HOURS
		SIMULATED FLOW TIME HOURS	FLOW TIME HOURS		MINIMUM FLOW TIME HOURS	MAXIMUM FLOW TIME HOURS	
15113A	864.00	828.94	103.23	579.25	1084.50		
15025A	864.00	848.63	209.84	459.69	1276.36		
15119A	792.00	586.63	28.70	482.98	822.11		
15321A	792.00	578.91	107.63	459.47	870.75		
15126A	792.00	351.01	36.93	171.70	509.41		
15300A	792.00	360.16	32.67	293.97	432.92		
15136A	816.00	490.58	62.41	391.67	654.72		
15137A	916.00	455.43	54.19	365.09	605.70		
15140A	504.00	692.48	230.00	338.75	1250.68		
15150A	744.00	811.12	178.99	510.09	1300.51		
15155A	912.00	715.37	157.21	459.68	1052.69		
15178A	456.00	397.97	35.19	346.34	525.68		
15186A	940.00	1053.72	114.41	777.48	1491.41		
15189A	840.00	1087.84	123.47	844.94	1348.59		
15189ASUB1	0.00	271.28	49.40	114.96	329.40		
15189ASUB1	0.00	257.90	77.81	114.16	327.38		
15191A	864.00	1060.67	118.03	741.85	1342.78		
15192A	892.00	1170.40	151.25	892.64	1445.41		
15191ASUB1	0.00	256.66	48.20	173.66	365.40		
15192ASUB1	0.00	281.76	42.64	175.59	387.20		
15236A	1056.00	767.39	55.50	675.28	915.00		
15237A	384.00	975.55	110.13	772.40	1501.10		
15249A	984.00	942.94	111.25	702.79	1517.65		
15330A	0.00	240.76	43.48	145.30	330.00		

\*\* NO VALUES RECORDED \*\*

ALC: 00  
PAGE: 5

DIRECT LABOR STATISTICS

LATER ITEM	IMUN	MAXIMUM LABOR HOURS	NUMBER OF SAMPLES	EXPECTED HOURS	STANDARD HOURS	SIMULATED AVERAGE		STANDARD DEVIATION	SIMU MIN
						LABOR HOURS	LABOR HOURS		
15113A		137.72	234	123.49	147.70	127.57	127.57	5.88	10
15025A		135.86	212	112.59	163.50	111.07	111.07	9.16	8
15119A		99.30	64	101.01	89.80	99.81	99.81	0.73	9
15321A		114.27	65	113.86	90.70	111.69	111.69	1.17	10
15115A		60.69	68	56.93	88.70	53.70	53.70	3.87	4
15200A		64.17	67	60.40	92.30	57.03	57.03	4.12	4
15176A		45.90	72	37.66	79.20	36.47	36.47	5.30	2
15137A		45.90	69	34.09	79.20	34.11	34.11	6.70	5
15140A		72.20	17	64.80	51.70	64.46	64.46	4.89	5
15150A		112.39	118	81.02	85.20	86.31	86.31	12.31	6
15175A		65.25	68	52.36	73.90	57.05	57.05	5.16	4
15178A		27.80	207	24.20	19.00	22.63	22.63	1.93	1
15188A		292.34	57	193.59	120.70	194.00	194.00	38.01	11
15189A		273.63	53	193.59	120.70	202.71	202.71	38.03	14
15188ASUB1		57.01	57	14.88	15.00	50.08	50.08	14.50	9
15189ASUB1		53.06	59	14.88	15.00	24.01	24.01	12.95	11
15191A		261.24	47	178.33	118.70	179.33	179.33	36.40	8
15192A		271.85	32	195.53	118.70	189.12	189.12	36.97	11
15191ASUB1		53.50	51	14.70	15.00	51.87	51.87	13.03	1
15197ASUB1		52.79	38	14.70	15.00	30.72	30.72	13.84	8
15200A		124.07	104	104.59	121.60	103.60	103.60	10.65	11
15202A		197.96	33	22.55	20.60	103.22	103.22	20.65	9
15207A		196.62	161	161.99	110.50	153.33	153.33	4.95	9
15209A			67	159.32	111.00	171.81	171.81		
15209ASUB1			69	24.00	18.60				

\*\* ND VALUES RECORDED \*\*

ITEM	AVERAGE SIMULATED BACKSHOPS HOURS	STANDARD DEVIATION	NO VALUES RECORDED	SIMULATED MINIMUM BACKSHOPS HOURS	SIMULATED MAXIMUM BACKSHOPS HOURS	NUMBER OF SAMPLES
125A	120.68	0.52	0	124.00	124.00	99
126A	126.00	11.00	0	146.00	196.00	99
127A	126.00	0.00	0	126.00	126.00	99
128A	126.00	0.00	0	126.00	126.00	99
129A	126.00	0.00	0	126.00	126.00	99
130A	126.00	0.00	0	126.00	126.00	99
131A	126.00	0.00	0	126.00	126.00	99
132A	126.00	0.00	0	126.00	126.00	99
133A	126.00	0.00	0	126.00	126.00	99
134A	126.00	0.00	0	126.00	126.00	99
135A	126.00	0.00	0	126.00	126.00	99
136A	126.00	0.00	0	126.00	126.00	99
137A	126.00	0.00	0	126.00	126.00	99
138A	126.00	0.00	0	126.00	126.00	99
139A	126.00	0.00	0	126.00	126.00	99
140A	126.00	0.00	0	126.00	126.00	99
141A	126.00	0.00	0	126.00	126.00	99
142A	126.00	0.00	0	126.00	126.00	99
143A	126.00	0.00	0	126.00	126.00	99
144A	126.00	0.00	0	126.00	126.00	99
145A	126.00	0.00	0	126.00	126.00	99
146A	126.00	0.00	0	126.00	126.00	99
147A	126.00	0.00	0	126.00	126.00	99
148A	126.00	0.00	0	126.00	126.00	99
149A	126.00	0.00	0	126.00	126.00	99
150A	126.00	0.00	0	126.00	126.00	99
151A	126.00	0.00	0	126.00	126.00	99
152A	126.00	0.00	0	126.00	126.00	99
153A	126.00	0.00	0	126.00	126.00	99
154A	126.00	0.00	0	126.00	126.00	99
155A	126.00	0.00	0	126.00	126.00	99
156A	126.00	0.00	0	126.00	126.00	99
157A	126.00	0.00	0	126.00	126.00	99
158A	126.00	0.00	0	126.00	126.00	99
159A	126.00	0.00	0	126.00	126.00	99
160A	126.00	0.00	0	126.00	126.00	99
161A	126.00	0.00	0	126.00	126.00	99
162A	126.00	0.00	0	126.00	126.00	99
163A	126.00	0.00	0	126.00	126.00	99
164A	126.00	0.00	0	126.00	126.00	99
165A	126.00	0.00	0	126.00	126.00	99
166A	126.00	0.00	0	126.00	126.00	99
167A	126.00	0.00	0	126.00	126.00	99
168A	126.00	0.00	0	126.00	126.00	99
169A	126.00	0.00	0	126.00	126.00	99
170A	126.00	0.00	0	126.00	126.00	99
171A	126.00	0.00	0	126.00	126.00	99
172A	126.00	0.00	0	126.00	126.00	99
173A	126.00	0.00	0	126.00	126.00	99
174A	126.00	0.00	0	126.00	126.00	99
175A	126.00	0.00	0	126.00	126.00	99
176A	126.00	0.00	0	126.00	126.00	99
177A	126.00	0.00	0	126.00	126.00	99
178A	126.00	0.00	0	126.00	126.00	99
179A	126.00	0.00	0	126.00	126.00	99
180A	126.00	0.00	0	126.00	126.00	99
181A	126.00	0.00	0	126.00	126.00	99
182A	126.00	0.0				

23-MAY-89 TIME: 10:08:26 RUP1.1

PROCESS TIMES SUMMARY

OW ITEM	BACKSHOP HOURS	%	HISTOR: NUMBER FLOW OF HOURS SAMPLES	SIMULATED FLOW HOURS	WAITING FOR RESOURCES HOURS	%	PROCESSING FL HOURS	%
15113A	192.0	23.2%	864.0	828.9	267.6	31.8%	273.4	45.0%
15025A	150.7	17.8%	864.0	848.6	402.9	47.5%	295.0	34.9%
15119A	96.0	16.4%	792.0	586.6	127.0	21.7%	363.3	61.9%
15118A	76.0	16.6%	792.0	578.9	10.0	1.3%	254.8	41.9%
15126A	76.0	16.6%	792.0	351.0	68.6	19.5%	196.4	53.1%
15300A	76.0	27.3%	792.0	360.2	69.5	19.3%	194.6	34.6%
15136A	66.0	26.7%	816.0	490.6	91.8	18.7%	230.7	47.0%
15137A	66.0	34.2%	816.0	455.4	80.6	17.7%	206.8	45.4%
15140A	66.0	35.9%	504.0	692.5	236.1	34.1%	260.4	52.0%
15150A	66.0	13.9%	744.0	811.1	221.6	27.3%	438.4	54.0%
15175A	151.1	18.6%	912.0	715.4	234.2	32.7%	336.2	47.0%
15178A	145.0	20.3%	456.0	398.6	35.8	8.5%	172.2	43.3%
15188A	192.0	48.2%	840.0	1053.7	202.3	19.2%	683.4	64.9%
15189A	166.0	15.9%	840.0	1087.8	205.1	18.9%	719.7	66.2%
15188ASUB1	166.0	15.0%	0.0	271.3	34.0	12.5%	141.3	52.1%
15189ASUB1	166.0	35.4%	0.0	257.9	32.8	12.7%	129.1	50.1%
15191A	96.0	37.2%	864.0	1060.7	214.6	20.2%	678.2	63.9%
15192A	167.8	15.8%	892.0	1170.4	290.7	24.8%	715.5	61.1%
15191ASUB1	167.8	14.0%	30.0	256.7	45.2	17.6%	91.5	35.6%
15192ASUB1	167.8	45.8%	0.0	281.8	44.0	15.6%	117.8	41.8%
15206A	100.0	42.6%	1056.0	767.4	101.5	13.2%	388.8	50.7%
15237A	277.1	35.1%	984.0	975.6	150.3	15.0%	699.4	71.2%
15249A	120.0	12.3%	984.0	942.9	145.4	15.4%	677.5	71.9%
15250A	100.0	12.7%	0.0	240.8	30.2	1.5%	162.6	67.5%
1527ASUB1	48.0	19.9%	0.0					

\*\* NO VALUES RECORDED \*\*













# ORIGINAL MANPOWER FACTORS



DIRECT LABOR STATISTICS

ITEM	EXPECTED	STANDARD	SIMULATED AVERAGE LABOR HOURS	STANDARD DEVIATION	SIMULATED MINIMUM LABOR HOURS	SIMULATED MAXIMUM LABOR HOURS	NUMBER OF SAMPLES
15013A	139.54	147.70	138.63	6.27	131.40	153.30	20
15026A	124.75	124.75	124.75	0.00	124.75	124.75	20
15119A	110.58	110.58	110.58	0.00	110.58	110.58	20
15324A	60.70	60.70	60.70	0.00	60.70	60.70	20
15126A	42.25	42.25	42.25	0.00	42.25	42.25	20
15300A	72.70	72.70	72.70	0.00	72.70	72.70	20
15137A	58.50	58.50	58.50	0.00	58.50	58.50	20
15140A	217.50	217.50	217.50	0.00	217.50	217.50	20
15150A	15.72	15.72	15.72	0.00	15.72	15.72	20
15177A	200.07	200.07	200.07	0.00	200.07	200.07	20
15178A	117.35	117.35	117.35	0.00	117.35	117.35	20
15179A	181.75	181.75	181.75	0.00	181.75	181.75	20
15180A	28.93	28.93	28.93	0.00	28.93	28.93	20

VALUES RECORDED \*\*

15013A	138.63	6.27	131.40	153.30	20
15026A	124.75	0.00	124.75	124.75	20
15119A	110.58	0.00	110.58	110.58	20
15324A	60.70	0.00	60.70	60.70	20
15126A	42.25	0.00	42.25	42.25	20
15300A	72.70	0.00	72.70	72.70	20
15137A	58.50	0.00	58.50	58.50	20
15140A	217.50	0.00	217.50	217.50	20
15150A	15.72	0.00	15.72	15.72	20
15177A	200.07	0.00	200.07	200.07	20
15178A	117.35	0.00	117.35	117.35	20
15179A	181.75	0.00	181.75	181.75	20
15180A	28.93	0.00	28.93	28.93	20



## PROCESS TIMES SUMMARY

[illegible]





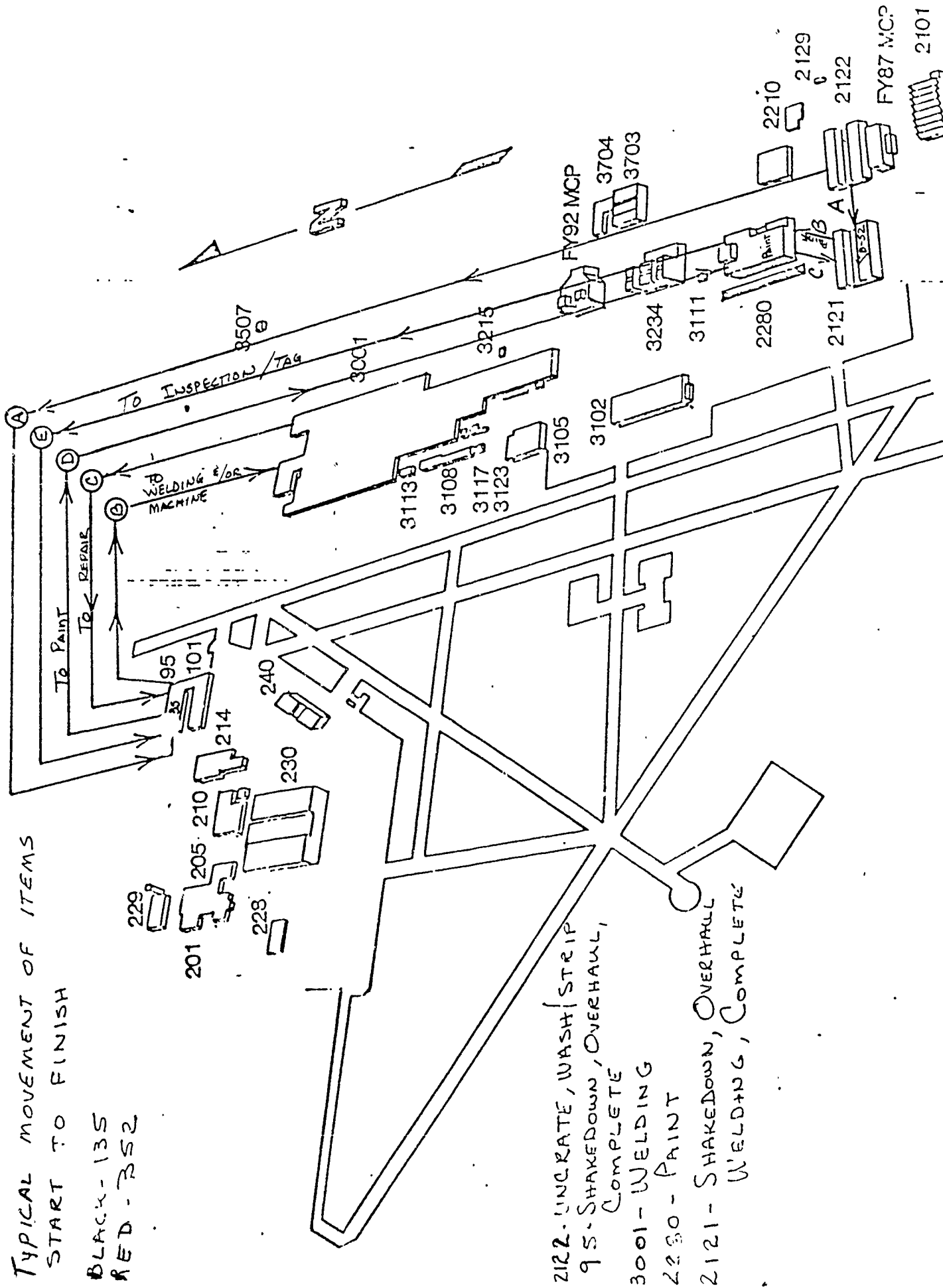


# TYPICAL MOVEMENT OF ITEMS

START TO FINISH

BLACK - 135

RED - 352



## **TECHNOLOGY INSERTION**

---

### **AGENDA RESOURCE CONTROL CENTER (RCC) UNIVERSAL DEPOT OPERATIONS SIMULATOR VERSION 2.0 VALIDATION AND BRAINSTORMING SESSION**

- INTRODUCTION
- RCC REVIEW
  - SCHEDULE
  - FLOW PROCESS
  - SAMPLES OF INPUT FILES AND ASSUMPTIONS
  - UDOS 2.0 SIMULATION OVERVIEW
- MODEL OBJECTIVES
- MODEL VALIDATION CRITERIA
- MODEL OUTPUT ANALYSIS
- LOAD/TRIAL RUN AT ALC (FIRST RCC ONLY)
- BRAINSTORMING SESSION (SEE APPENDIX)
- MEETING MINUTES, ACTION ITEMS & CONCLUSIONS

07 JUNE 1989  
L. A. MAVROS

**AFLC/MDMSC**

## **TECHNOLOGY INSERTION**

### **MODEL OBJECTIVE**

- VALIDATION WILL BE EVALUATED BY RCC AND RECOMMENDED FOR ACCEPTANCE BY RCC VALIDATION TEAM.
- THE MODEL IS AN APPROXIMATION OF THE "AS IS CONDITION" CAPTURED AT THE TIME OF INTERVIEW.
- INTENDED AS A TOOL FOR ENGINEERING ASSESSMENT OF SHOP OPERATIONS:
  - IMPROVED END ITEM THROUGHPUT.
  - IMPROVED UTILIZATION OF RESOURCES.
  - REDUCTION OF OPERATIONS COST.

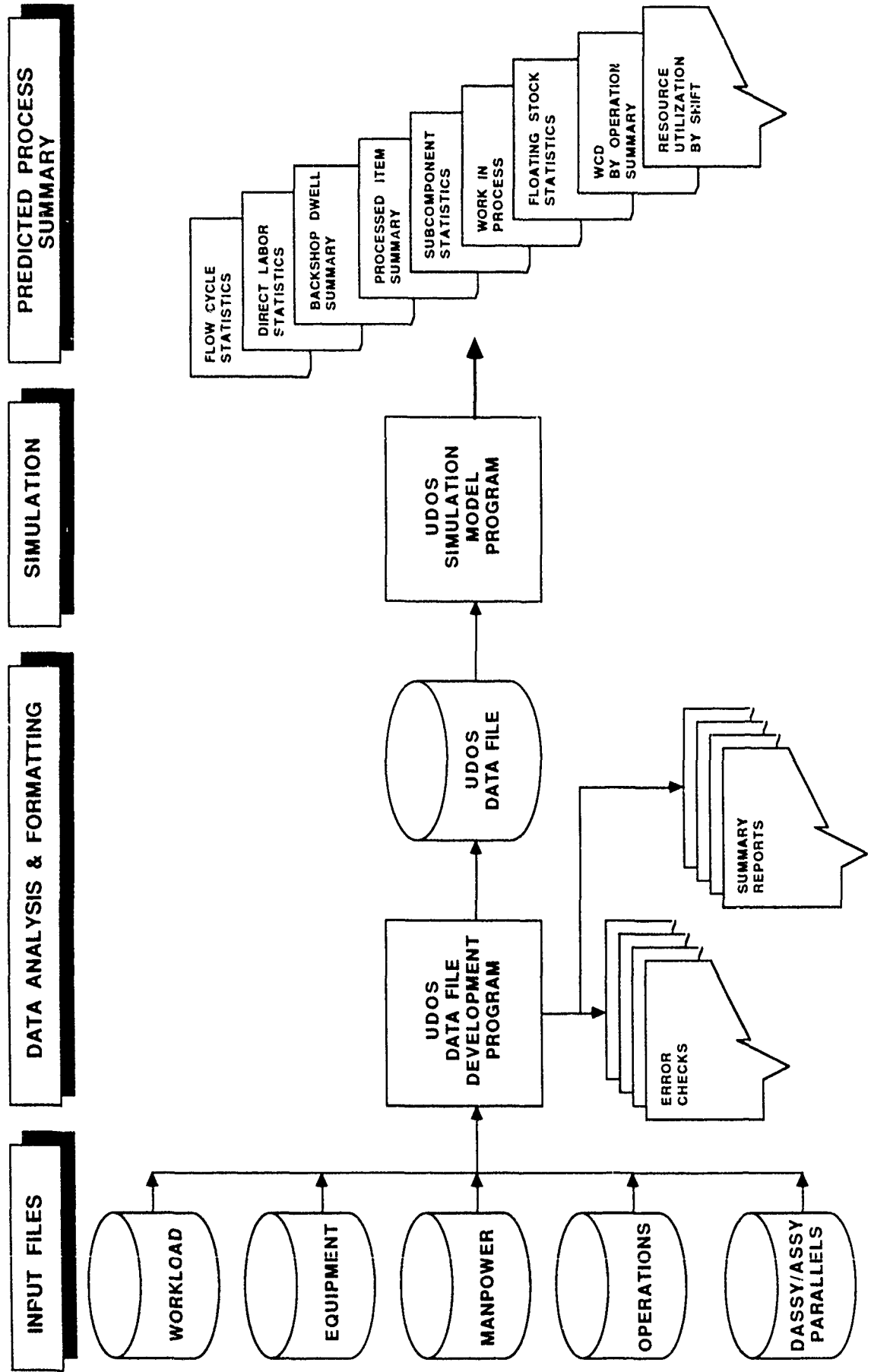
ALLOW EXPERIMENTATION OF CHANGES TO THE "AS IS" CONDITION WITHOUT CAPITAL INVESTMENT.

- THE MODEL WILL:
  - PROVIDE AN APPROXIMATION OF REALITY.
  - ESTABLISH A BASELINE FOR EXPERIMENTATION.
  - PROVIDES A USEFUL TOOL FOR EXPLORING THE EFFECT OF CHANGE WITHOUT DISRUPTION OF OPERATION.

07 JUNE 1989  
L. A. MAVROS

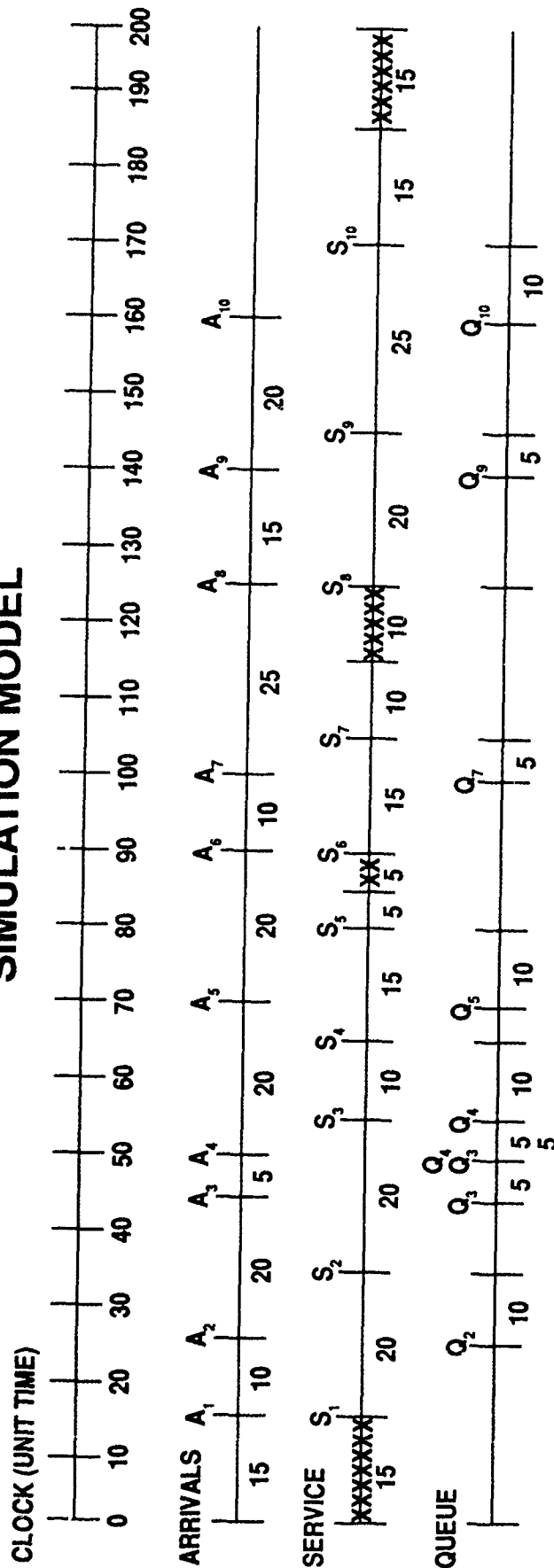
**AFLC/MDMSC**

# UDOS 2.0



# TECHNOLOGY INSERTION

## SIMULATION MODEL



STATISTICS: SERVICE 10 UNITS (THROUGHPUT)

TOTAL SERVICE TIME 155 UNIT TIMES

AVG. SERVICE TIME 15.5 UNIT TIMES

MAX. UNITS IN QUEUE 2

TOTAL IN QUEUE TIME 65 UNIT TIMES

AVG. IN QUEUE TIME 9.3 UNIT TIMES

AVG. ARRIVAL INTERVAL 16 UNIT TIMES

TOTAL IDLE TIME 45 UNIT TIMES

% UTILIZATION  $\frac{155}{200} = 77.5\%$

R. BOLANOS  
16 JUNE 1989

AFLC/MDMSC

## ***TECHNOLOGY INSERTION***

---

### **MODEL VALIDATION CRITERIA**

- SIMULATED THROUGHPUT vs AVAILABLE PRODUCTION DATA.
  - SCHEDULING
  - HISTORY
- SIMULATED FLOW DAYS vs BEST AVAILABLE RCC FLOW DAYS.
  - WCD HISTORY
  - SCHEDULING
  - SHOP FLOOR INTERVIEWS
- SIMULATED RESOURCE UTILIZATION vs ALC/RCC ASSESSMENT.
  - SHOP FLOOR INTERVIEWS
  - AREA MANAGER CONTROL DOCUMENTS

07 JUNE 1989  
L. A. MAVROS

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***AFLC/MDMSC***

## **TECHNOLOGY INSERTION**

### **THROUGHPUT VALIDATION CRITERIA**

- A COMPARISON BY PART NUMBER, BETWEEN ~  
SIMULATED THROUGHPUT & PRODUCTION DATA FOR A  
BASE YEAR.
- THE SIMULATED OUTPUT REPRESENTS A REASONABLE  
APPROXIMATION OF THE BASE YEAR PRODUCTION DATA  
USED AS A BASELINE FOR EXPERIMENTATION.

07 JUNE 1989  
L. A. MAVROS

**AFLC/MDMSC**

## **TECHNOLOGY INSERTION**

### **FLOW DAYS VALIDATION CRITERIA**

- A COMPARISON, BY PART NUMBER, BETWEEN ~  
SIMULATED FLOW DAYS AND BEST AVAILABLE RCC FLOW  
DAYS, SUCH AS
  - HISTORICAL DATA
  - WORK CONTROL DOCUMENT (WCD)
- IN THE EVENT HISTORICAL DATA HAS BEEN PURGED OR IS  
NOT ACCURATE, THE VALIDATION TEAM WILL DETERMINE  
THE BEST SOURCE OF DATA THAT REPRESENTS A REASONABLE  
APPROXIMATION.

07 JUNE 1989  
L. A. MAVROS

**AFLC/MDMSC**



OKLAHOMA CITY AIR LOGISTICS CENTER  
RESOURCE CONTROL CENTER MABPAB  
UNIVERSAL DEPOT OPERATIONS SIMULATOR (UDOS) VERSION 2.0  
VALIDATION CONFERENCE AND BRAINSTORMING SESSION  
AGENDA

MONDAY 22 MAY 1989

8:45 - 9:00 INTRODUCTION: EARL STAMPS - MABEBS  
9:00 - 10:00 MABPAB OVERVIEW: RICARDO BOLANOS  
SCHEDULE  
FLOW PROCESS  
PROCESS PROFILE  
10:00 - 10:15 BREAK  
10:15 - 10:30 MODEL EXPECTATIONS: RICARDO BOLANOS  
10:30 - 12:00 MODEL OUTPUT ANALYSIS: SCOTT VROMAN  
12:00 - 13:00 LUNCH  
13:00 - 16:00 MODEL VALIDATION/ADJUSTMENT RUN AT ST. LOUIS  
16:00 - 16:30 ACTION PLANING

TUESDAY 23 MAY 1989

9:00 - 18:00 DATA OUTPUT ANALYSIS  
& SECOND VALIDATION ADJUSTMENT RUN

WEDENSDAY 24 MAY 1989

9:00 - 10:00 LOAD/TRIAL RUN MABPAB UDOS 2.0 ON OC-ALC  
VAX  
10:00 - 12:00 MODEL VALIDATION & CONCLUSIONS

13:00 16:00 BRAINSTORMING / TAGUCHI

OC-MABPAB

5/24/89

- A. REDUCTION ON MAN-POWER due to 80/20 WORKLOAD IS: 19.5% } MAN POWER PROFILE.
- B. INCREASE ON MAN-POWER due to FY88 EFFICIENCY IS: 11.2% }
- C. REDUCTION ON INTERVIEW TIMES due to BREAKS & PFD OF 7% IS: 89.13%

$$\left( 8 \text{ hrs/day} - \frac{.33 \text{ min.}}{\text{TWO BREAKS}} \right) \times \frac{.93}{\text{PFD}} = 7.13$$

$$\frac{7.13}{8} = .8913$$

THEREFORE :

A & B NET REDUCTION ON MAN POWER PROFILE FACTOR IS 8.3%

$$\begin{array}{r} 19.5 \\ - 11.2 \\ \hline 8.3\% \end{array}$$

1 <sup>ST</sup> QTR	5.6	x .917	=	5.135	hrs (5.14)
2 <sup>ND</sup> QTR	5.7	x .917	=	5.23	
3 <sup>RD</sup> QTR	5.9	x .917	=	5.41	
4 <sup>TH</sup> QTR	5.8	x .917	=	5.32	

ON WEEK END or HOLIDAYS

$$(7.13 \text{ hrs} \times .917) = 6.54$$

C. OPERATION PROFILE REDUCTION ON MAN-POWER & EQUIPMENT TIMES

$$I \quad (5.6 \times .805) \times 1.112 = 5.01$$

$$II \quad (5.6 \times 1.112) \times .805 = 5.01$$

$$III \quad 5.6 \times \cancel{(19.5 - 11.2)} =$$

$$\times [1 - (19.5 - 11.2)] = 5.135$$

$$\begin{array}{r} 5.6 \\ - (5.6 \times 0.995) \\ + (5.6 \times 0.112) \\ \hline \end{array}$$

$$(10 \times .805) \times \underbrace{1.112}_{\substack{\nearrow 80/20 \text{ WL} \\ \nearrow \text{EFF.}}}$$

$$10 \times 0.917$$

## **7.0 COMPUTER SIMULATION ANALYSIS OF RCC**

The computer simulation analysis for RCC MABPAB was previously submitted under memo number NKE-E016-6955, dated June 5, 1989.

## **8.0 VALIDATION OF SIMULATION ANALYSIS**

The validation of simulation analysis for RCC MABPAB was previously submitted under memo number NKE-E016-6955, dated June 5, 1989.

# MABPAB THROUGHPUT STATISTICAL ANALYSIS

PART CONTROL NUMBER (PCN)	SIMULATED	FY 88 ACTUALS	% VARIANCE (SIM /ACTUALS)
15113A	233	243	-4%
15025A	214	240	-12%
15119A	65	69	-6%
15321A	65	69	-6%
15126A	68	69	-1%
15300A	67	69	-3%
15136A	73	76	-4%
15137A	69	73	-6%
15140A	17	45	-165%
15150A	122	154	-26%
15175A	69	71	-3%
15178A	202	220	-9%
15188A	56	58	-4%
15189A	54	60	-11%
15191A	47	55	-17%
15192A	33	39	-18%
15236A	34	34	0%
15249A	67	74	-10%
15250A	65	74	-14%
SHOP AVERAGE	1620	1792	-11%

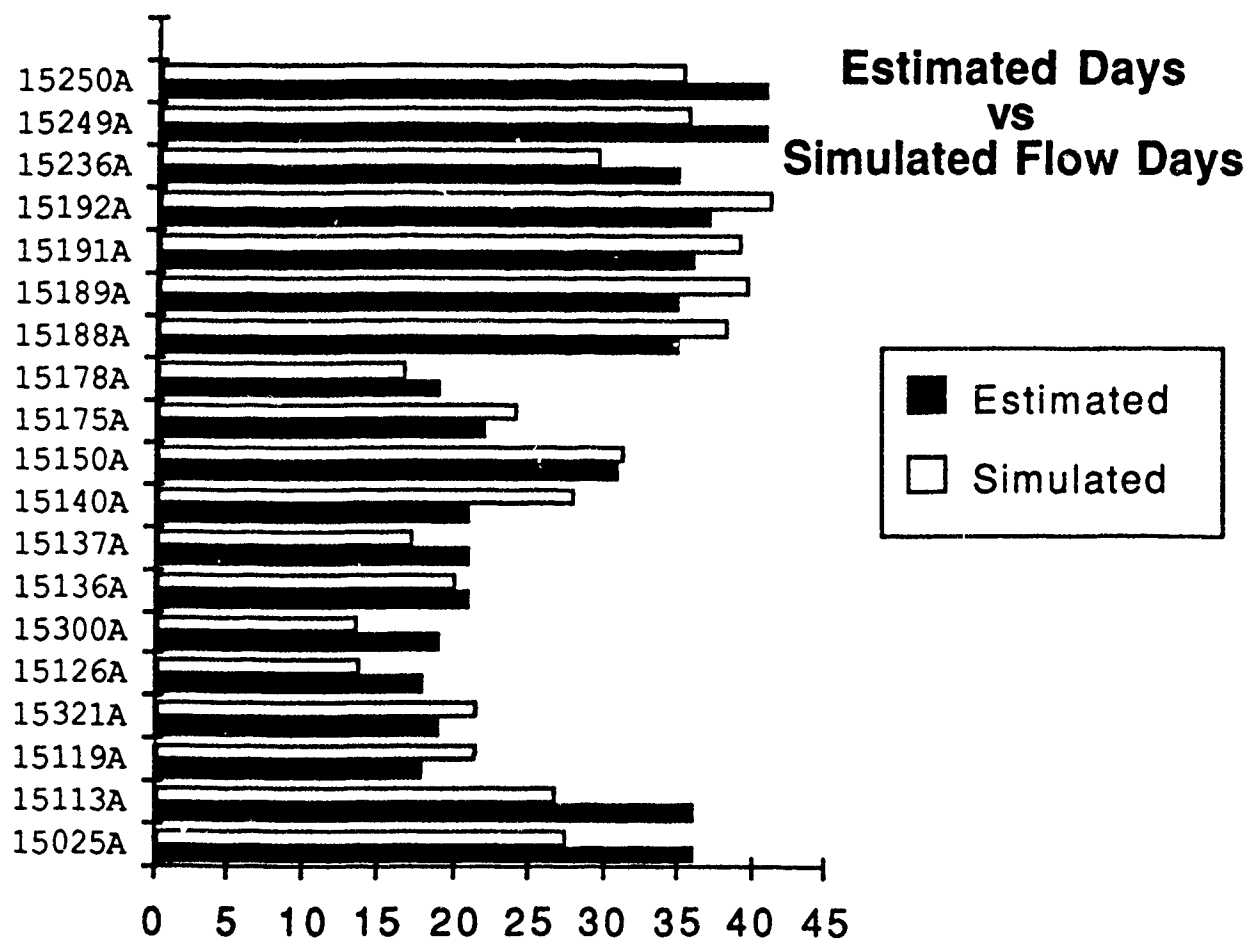
LSC-20454

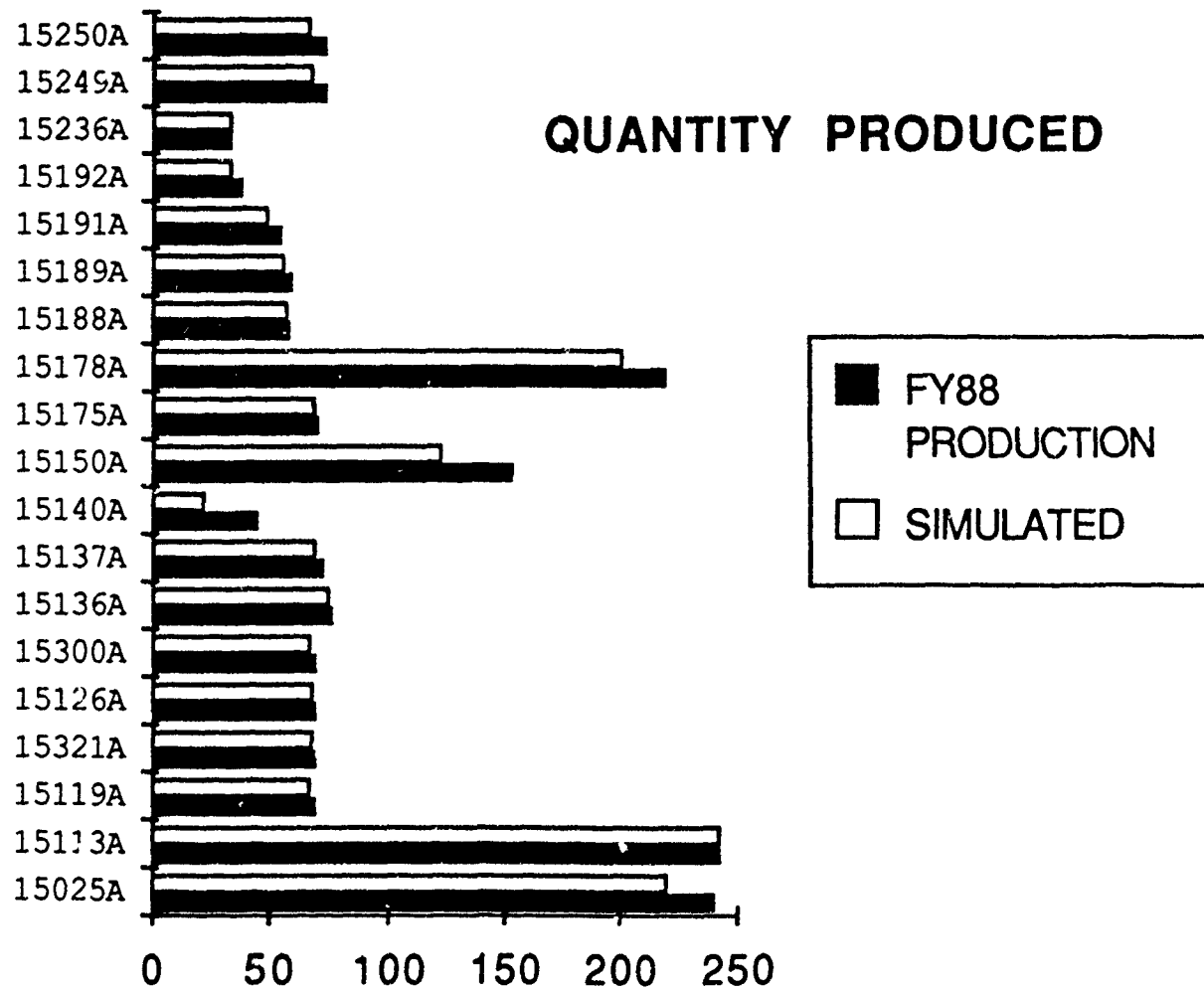
### MABPAB FLOW HOURS STATISTICAL ANALYSIS

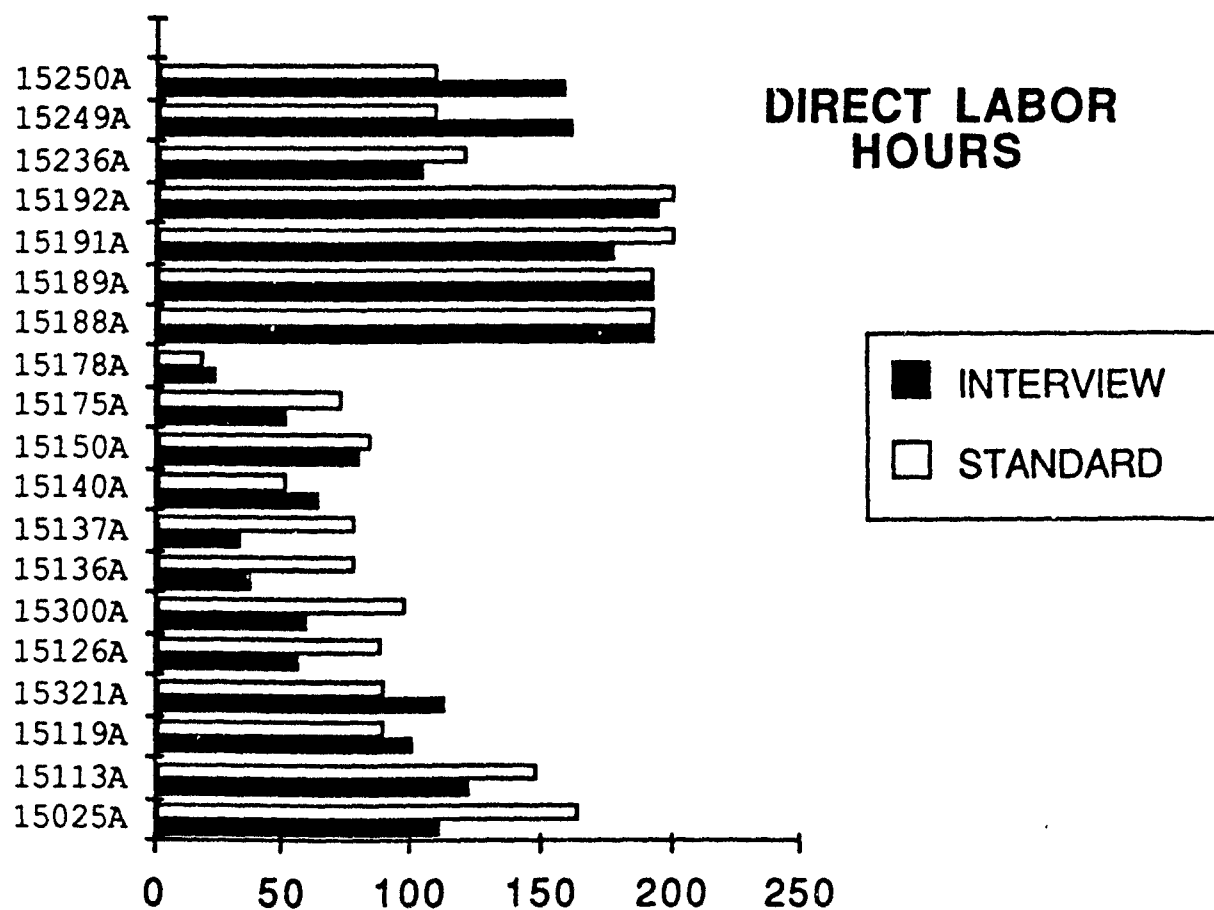
(PCN)	HISTORY	SIMULATED	G-019-C	% VARIANCE (SIM / HIST)	% VARIANCE (SIM / G-019-C)
15113A	1,276	810	864	-58%	-7%
15025A	1,628	848	864	-92%	-2%
15119A	1,178	571	432	-106%	24%
15321A	1,015	562	456	-81%	19%
15126A	892	349	432	-156%	-24%
15300A	376	363	456	-4%	-26%
15136A	767	481	504	-59%	-5%
15137A	441	452	504	2%	-12%
15140A	1,235	688	504	-80%	27%
15150A	1,453	820	744	-77%	9%
15175A	4,183	717	528	-483%	26%
15178A	360	411	456	12%	-11%
15188A	1011	1,059	840	5%	21%
15189A	873	1,126	840	22%	25%
15191A	1,028	1,050	864	2%	18%
15192A	731	1,155	892	37%	23%
15236A	1,689	777	840	-117%	-8%
15249A	156	963	984	84%	-2%
15250A	833	953	984	13%	-3%
SHOP AVERAGE	21,125	14,155	12,988	-49%	8%

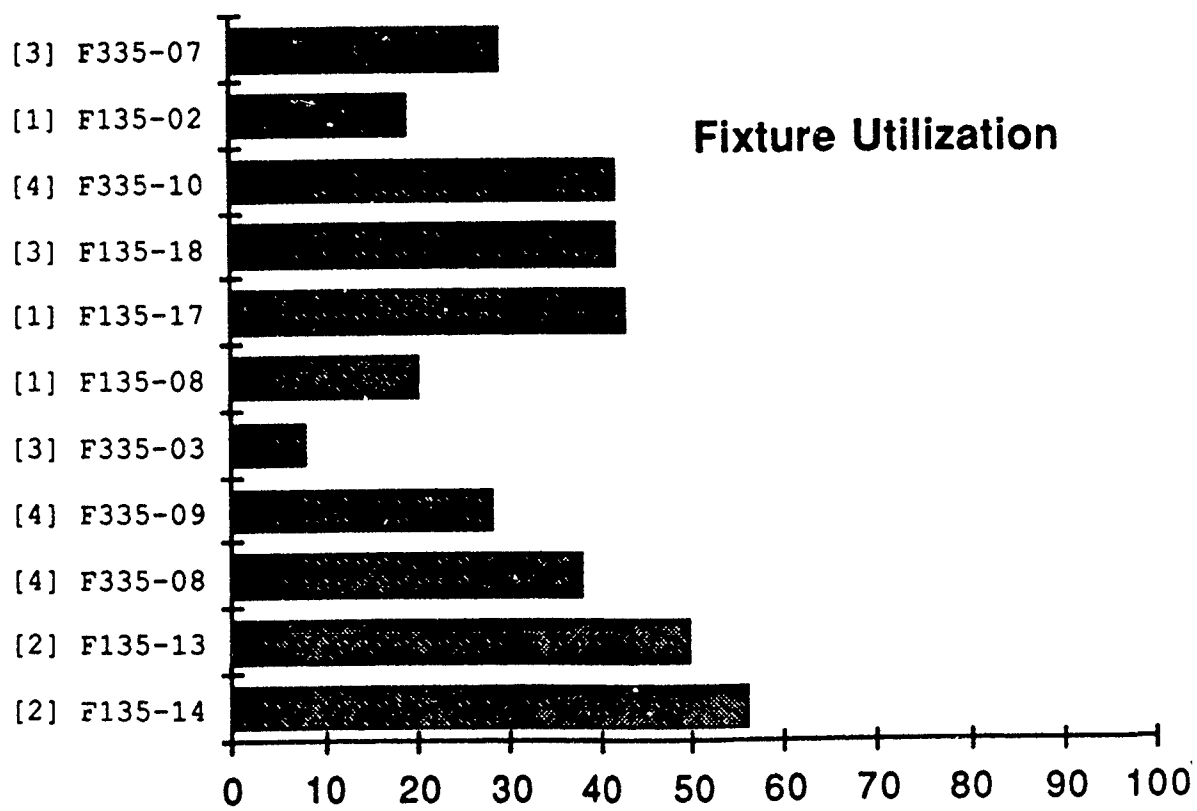
LSC-20455

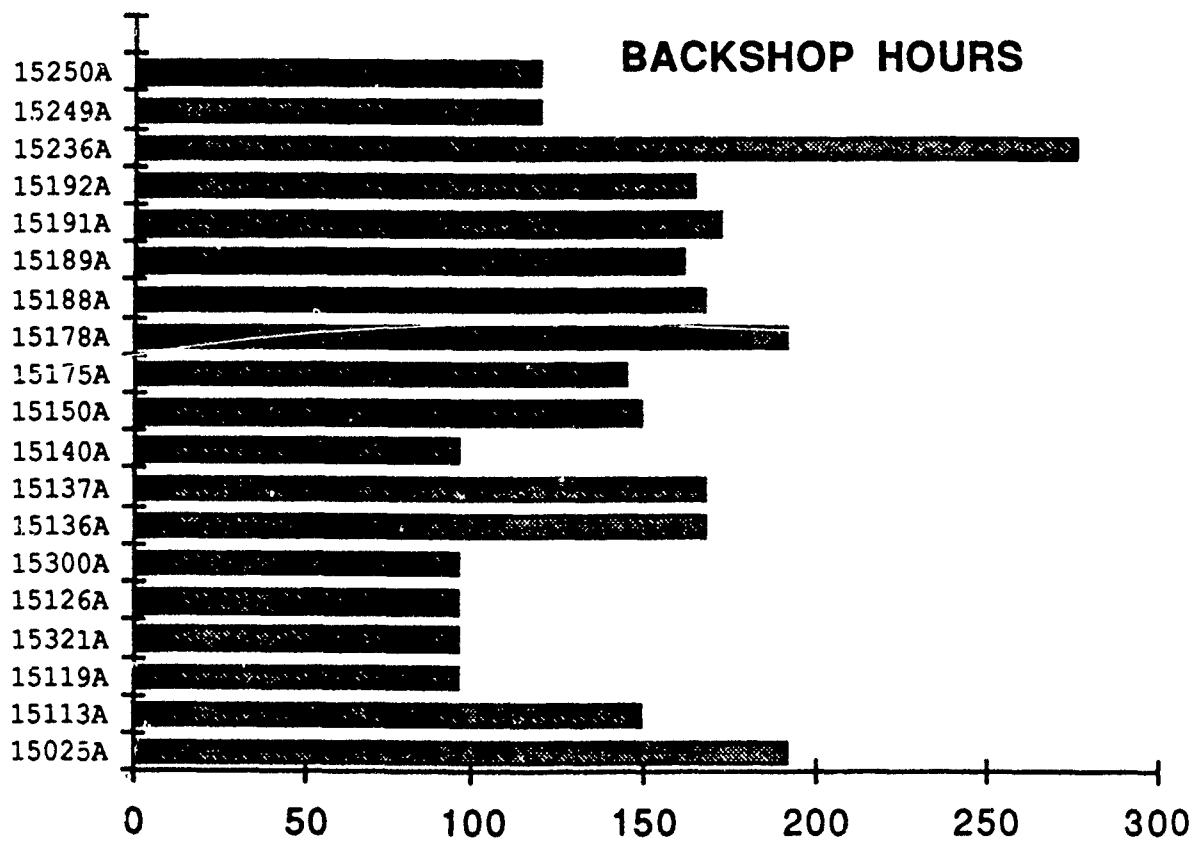




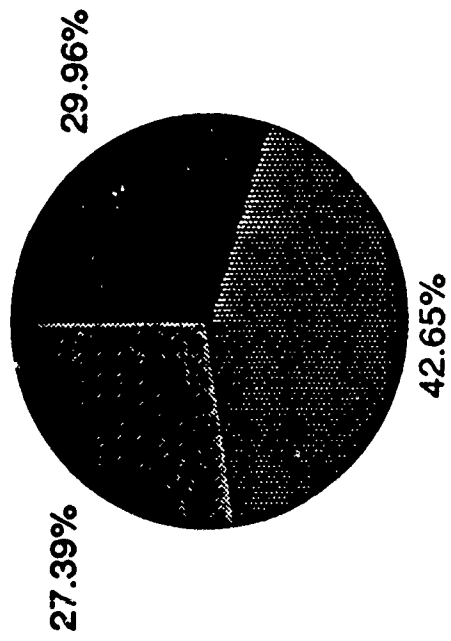




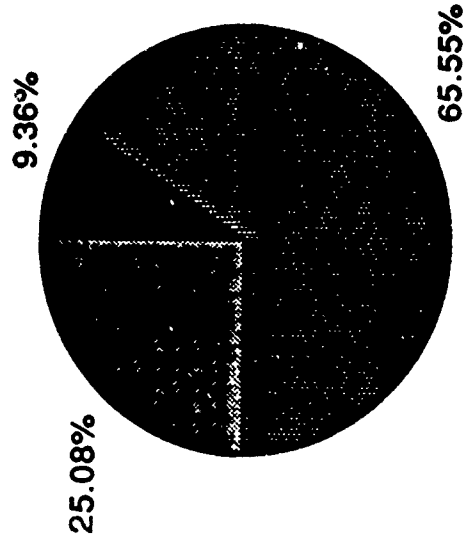




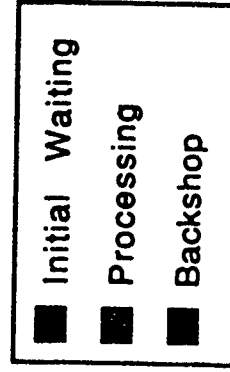
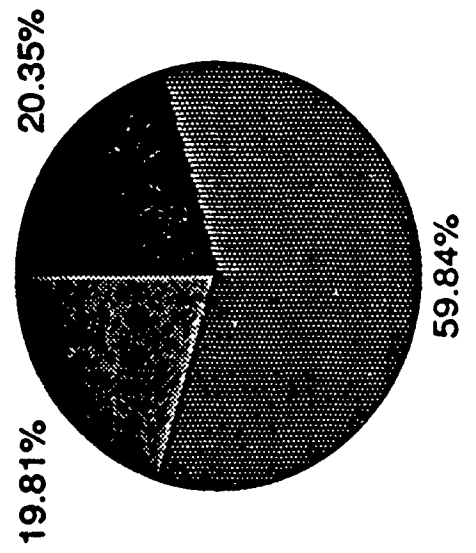
# 15025A PROCESSING SUMMARY



# 15113A PROCESSING SUMMARY

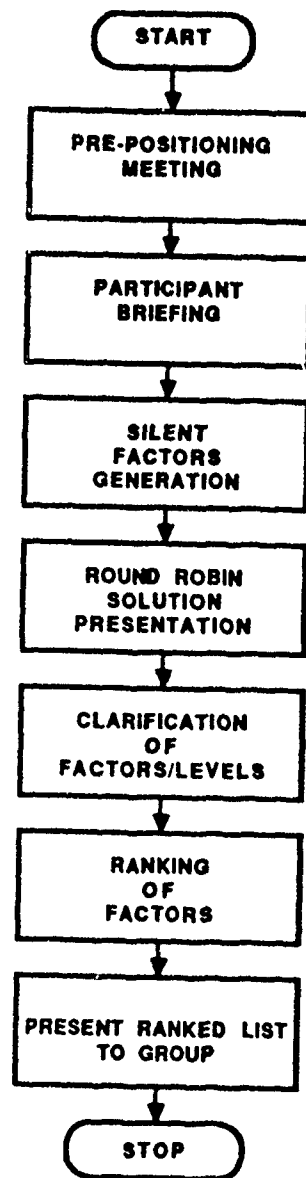


# 15150A PROCESSING SUMMARY



## **9.0 BRAINSTORMING**

The minutes for RCC MABPAB brainstorming were previously submitted under memo number NKE-E016-6955, dated June 5, 1989.



LSC-20462

## TI-ES BRAINSTORMING PROCESS



## **2.7 BRAINSTORMING SESSION**

On the afternoon of Wednesday 24 May, a brainstorming session was conducted in accordance with the procedures set forth in enclosure 18. The problem addressed by this brainstorming session, the Taguchi Factors and levels identified during the session are summarized below:

<u>Problem Statement:</u>	How to move MABPAB from its current 100,000 square foot facility into a new 60,000 square foot facility and maintain FY90 workload and surge capacity.
<u>Taguchi Factors:</u>	Manpower (Control Factor) Equipment (Control Factor) Workload (Noise Factor)
<u>Levels:</u>	To be determined at a later date.

Table 2.7-1. Taguchi Factors.

<u>FACTORS</u>	<u>METHOD OF INVESTIGATION</u>
1) REDUCTION OF BREAK AREAS	Quick Fix (QF)
2) INCREASE MANPOWER ON 2ND SHIFT	Model (M)
3) BALANCE MANPOWER REPORTS BETWEEN 1ST & 2ND SHIFT	M
4) INCREASE NUMBER OF HIGHLY UTILIZED FIXTURES	M
5) MATERIAL CONTROL TO REDUCE QUEUES	Focus Study (FS)
6) INCREASE BACK SHOP DWELL TIME	M
7) OPTIMIZE SPACE REQUIREMENTS (COMPRESSED BARE MINIMUM)	FS
8) 3RD SHIFT POSSIBILITY	M
9) INCREASE MANPOWER AVAILABILITY BY X%	M
10) MODEL NEW FACILITY LAYOUT FOR EQUIPMENT	M
11) REDUCE WORK IN PROCESS	M
12) REDUCE DISTANCE TRAVELED INSIDE RCC	QF or FS
13) CONSOLIDATE SUPERVISOR'S OFFICES	M
14) OVERTIME	M
15) ELIMINATE EQUIPMENT & FIXTURES WITH MINIMUM UTILIZATION	M
16) DETERMINE WAR TIME SURGE CAPABILITY	M
17) INCORPORATE BACK SHOP OPERATIONS	M
18) INCREASE WORKLOAD FROM 18.1 TO 18.5 LEVEL INDUCTIONS	M
19) DECREASE WORKLOAD	M
20) CONTINUITY BETWEEN SHIFTS	M
21) ESTABLISH PICK UP CREW ON 3RD SHIFT	M
22) MOBILE TAGING UNIT	QF
23) INCORPORATE STAGING AREA	FS
24) MODEL FIXTURE FORCASTS	M

### **3.0 LIST OF ATTENDEES**

The list of attendees is provided as enclosure 1 to these meeting minutes. Those not in attendance for the entire conference and brainstorming session are so indicated.

### **4.0 CONFERENCE AGENDA**

The modified agenda reflecting actual conference sequence is provided as enclosure 2 to these meeting minutes.

### **5.0 PRESENTATION MATERIALS**

Presentation materials used during the MABPAB UDOS 2.0 Validation Conference are provided as enclosure 3 to these meeting minutes.

### **6.0 VALIDATION FORM**

The Validation Form form signed at the conclusion of the MABPAB UDOS 2.0 Validation Conference is provided as enclosure 4 to these meeting minutes.

### **7.0 ACTION ITEMS**

Action items annotated on the Validation Form referenced in paragraph 6.0 have been recorded of Action Item forms and are included as enclosure 5 of these meeting minutes.

### **8.0 MODEL INPUT/OUTPUT FILE PRINTOUTS**

MABPAB UDOS 2.0 model input files and output files which resulted in validation of the model are provided as enclosures 6 through 17.

# Factors

100 K S  
60 K S  
H<sub>2</sub> relocate MABPFB into 60 K S

- 1) ~~Reduction~~ of break areas. DONE Quick fix (F)
- 2) Increase  $\frac{MP}{L}$  in 2<sup>nd</sup> shift M
- 3) ~~increase~~  $\frac{MP}{L}$  reports between 1<sup>st</sup> & 2<sup>nd</sup> shift M
- 4) Increase number of utilized fixtures M
- 5) Material Control to reduce queues I S
- 6) Increase back shop dwell time M
- 7) Optimize space requirements  
Complexed base minimum FS total stud.
- 8) 3<sup>rd</sup> shift Possibility M
- 9) Increase  $\frac{MP}{L}$  availability by x% M
- 10) model new facility layout for Eqmt M
- 11) Reduce work in process M
- 12) Minimize ~~distance~~ <sup>travel</sup> inside RCC CF or FS
- 13) Consolidate Supv's Ofc. FS M
- 14) Overtime M
- 15) Eliminate Eqmt + fixtures at maximum utilization M
- 16) <sup>Determine</sup> War Line Surge ~~Rate~~ Capacity M
- 17) Incorporate back shop Operations M

same

- |  |        |
|--|--------|
| 18) Increase Workload: <sup>18.1</sup> Increase Inductions | M      |
| 19) Decrease Workload                                      | M      |
| 20) Continuity between shifts                              | M      |
| 21) Establish Pick Up Low on 3 <sup>rd</sup> shift         | M M RS |
| 22) Mobile Lightning Unit                                  | GF     |
| <del>23) Change Quarterly Inductions</del>                 |        |
| 23) Incorporate Staging Area                               | FS     |
| 24) Model Future Forecasts                                 | M      |
|  | -      |
|  | ...    |
|  | ...    |

Priority (per Scott)

Identifying the factors

Similarities  
2, 3, 20, 21

Continuity of shifts  
Incr Util. Features

New Egypt Profile → levels

# of features)

manpower → levels

Workload → levels

- Now we have the same number of manhours only distributed across different shifts -
- Need to include increased manhours such as weekends -
- This could be the same as adding people -

- Validation -

~~34 hours~~

One week - 7 days

40 hours

$$\left( \frac{56}{40} = 1.4 \right) \quad \frac{48}{40} = 1.2$$

$$\{ 1.204 \} \quad \text{1.08}$$

Examine People distribution  
by shift, staffing level and  
Equipment (no. of fixtures) versus  
FY 90 and Surge workload.  
This examination is limited to  
Part no. 15025A and 1513A  
(left and right hand side coul)  
at MABFAB, Tinker AFB.

---

High Equip, High workload -  
→ 60% above  
Work load 1.6  
- 2 shift - 7 days  
14% down from over 72 hours a  
week ⇒ when in a surge  
mode -

People Eff  
60 hours - 9  
72 hours - 9

split people between shifts -  
and work overtime -  
4 - 3 → 27 people  
2.1 x 40 = every one works →

People - more

- Baseline  
- Baseline + 60%

200 - Baseline - Effective hours  
320 - Surge

- Need to have increase in  
workload / person  
also additional people (?)



MEMO


19 June 1989  
TI-89-FJL-0199

Subject: TECHNOLOGY INSERTION-ENGINEERING SERVICES (TI-ES) TASK ORDER  
NO. 1 PRELIMINARY EXPERIMENTATION RESULTS FOR OC-ALC (RCC MABPAB)

To: R. G. Bolanos, R. Donnelly Jr., C. J. Gonzales, B. Kirk,  
L. A. Mavros, M. S. McCoy, File

Encl: (1) Transmittal Letter NKE-E016-6971, dated 15 June 1989  
(2) Task Order No. 1 Process Characterization, OC-ALC, RCC  
MABPAB Sheetmetal Backshop

1. Enclosures (1) and (2) are provided as internal distribution.
2. If you have any questions or comments, contact R. G. Bolanos at Ext. 925-5840, or the writer.

  
F. J. Lauber  
T. I. Program Administration  
E510/0922272, Sta. 925-5406

FJL:ksf

0048P/5

**MCDONNELL DOUGLAS**

McDonnell Douglas  
Missile Systems Company

15 June 1989  
NKE-E016-6971

CORRESPONDENCE  
ACTION  
ITEM  
RESPONSE

☐ YES ☐ NO

*L.A. MAVROS*  
*R. Donnelly*  
R. DONNELLY JR.

Subject: Contract F33600-88-D-0567, Technology Insertion Engineering Services, Process Characterization at OC-ALC (RCC MABPAB)

To: Department of the Air Force  
Attention: Ms J. Hoyt (PMRP)  
Contracting Officer  
Building 1, Area C  
Wright Patterson Air Force Base, Ohio 45433-5320

Reference: (a) Task Order No. 1, Cure Notice MOA, dated 17 March 1989

Enclosure: (1) Task Order No. 1, Process Characterization: OC-AL RCC MABPAB - Sheetmetal Backshop

1. As required by Paragraph (1) of Reference (a), McDonnell Douglas Missile Systems Company (MDMSC) expedited process characterization of the subject RCC. Data collection, model validation, and experimentation has been completed and, accordingly, MDMSC herein submits Enclosure (1). MDMSC will include the applicable Quick Fix Plans and focus study recommendations in the Block 1 Contract Summary Report.

2. Please address any questions or requests for additional information to the undersigned at (314) 233-8724.

*O.W. Engelbart*  
D. W. Engelbart  
Senior Contracts Administrator  
Advanced Programs

EC: Department of the Air Force  
HQ AFLC/MAQF  
Attn: Doxie Cripe  
Wright Patterson AFB, OH 45433-5320

IC: *G. Eisenhart*  
*F. Lauber* (Bldg. 92 Dist)  
Contract Files  
D. Engelbart  
Master Files

AFTER FINAL  
SIGNATURE  
RETURN TO:

LETTER

ENCLOSURE

USE ☒ NEXT TO LADDER SIGNATURE  
IN APPROPRIATE BOX  
IF COPY IS DESIRED

RAH-96/5  
MDE 14-27-1 (REV 22 AUG 88)

**MASTER FILE**

P.O. Box 516, Saint Louis, MO 63166-0516 (314) 232-0232 TELEX 44-857

**TECHNOLOGY INSERTION ENGINEERING SERVICES  
PROCESS CHARACTERIZATION**

**(TASK ORDER NO. 1)  
OC/ALC RCC MABPAB  
Sheetmetal Backshop  
15 JUNE 1989  
(PRELIMINARY)**

**CONTRACT NO. F33600-88-D-0567**

**MCDONNELL DOUGLAS**

*McDonnell Douglas Missile Systems Company  
St. Louis, Missouri 63166-0516 (314) 232-0232*

**Enclosure (1)**

**OC/ALC MABPAB  
Sheetmetal Repair Shop**

**Results**

The expedited MABPAB experimentation required by the MOA was completed June 15, 1989 on schedule. Preliminary Taguchi results indicated that moving MABPAB from approximately a 100,000 sq. ft. to a 65,000 sq. ft. will require certain considerations if the projected FY-90 workload is to be met.

A 65,000 sq. ft. facility, one shift will produce 66.5% of the FY-90 projected workload. Addition of a second shift will increase the FY-90 thruput to approx. 94%. The addition of assembly fixtures for 15249 & 15250(outboard left hand and right hand aileron assembly) will increase the thruput for one shift from 66.5% to 78.3%. If additional assembly fixtures are added, increased floor space is required.

**Surge Requirement**

Surge requirement was calculated on 1.6 of the FY-90 projected workload. It is assumed that during war time conditions 3 shifts will be used raising the thruput to 93.35%. If the additional assembly fixtures are installed the projected surge thruput will increase to 98.5%. However it should be noted that additional floor space is required.

Additional analysis of the Taguchi results will be made and if warranted a focus study will be recommended.

**MDMSC recommends the following:**

- Maintain the three existing aileron assembly fixtures.
- Increase floor space to accommodate the three aileron fixtures.
- Add a second shift as required.
- Consider a stand alone sheet metal shop by the addition of paint, welding and sand blasting capabilities.

Enclosure (1)

OC/ALC MABPAB  
SHEETMETAL REPAIR SHOP 6/15/89

	FY90	BASE	
END-ITEM	INDUCTIONS	SIMULATION	THROUGHPUT
15188A	0	0	N/A
15237A	0	0	N/A
15249A	182	40	22.0%
15250A	195	47	24.1%
15119A	170	65	38.2%
15321A	161	74	46.0%
15175A	151	82	54.3%
15126A	175	111	63.4%
15300A	184	117	63.6%
15140A	106	72	67.9%
15136A	212	164	77.4%
15137A	201	180	89.6%
15113A	134	124	92.5%
15025A	136	131	96.3%
15150A	146	141	96.6%
15189A	19	19	100.0%
15236A	23	23	100.0%
15192A	12	12	100.0%
15191A	16	16	100.0%
15178A	177	177	100.0%
=====			
	2400	1595	66.5%

40 HOUR WEEK , ONE SHIFT

OC/ALC MABPAB  
SHEETMETAL REPAIR SHOP 6/15/89

	FY90	BASE #5	
END-ITEM	INDUCTIONS	SIMULATION	THROUGHPU
15188A	0	0	N/A
15237A	0	0	N/A
15249A	182	112	61.5%
15250A	195	142	72.8%
15113A	134	129	96.3%
15126A	175	170	97.1%
15119A	170	166	97.6%
15175A	151	148	98.0%
15025A	136	134	98.5%
15136A	212	209	98.6%
15150A	146	145	99.3%
15189A	19	19	100.0%
15236A	23	23	100.0%
15300A	184	184	100.0%
15192A	12	12	100.0%
15137A	201	201	100.0%
15321A	161	161	100.0%
15140A	106	106	100.0%
15191A	16	16	100.0%
15178A	177	177	100.0%
	2400	2254	93.9%

2 SHIFTS, <sup>6</sup>/<sub>7</sub> DAYS A WEEK

OC/ALC MABPAB  
SHEETMETAL REPAIR SHOP

6/15/89

END-ITEM	SURGE INDUCTIONS	BASE #9 SIMULATION	THROUGHPUT
15188A	0	0	N/A
15237A	0	0	N/A
15249A	297	173	58.2%
15250A	309	213	68.9%
15175A	261	242	92.7%
15189A	31	29	93.5%
15236A	47	44	93.6%
15150A	254	247	97.2%
15140A	178	176	98.9%
15025A	224	222	99.1%
15136A	358	355	99.2%
15126A	279	277	99.3%
15113A	219	218	99.5%
15300A	287	286	99.7%
15137A	327	326	99.7%
15178A	286	286	100.0%
15191A	24	24	100.0%
15119A	277	277	100.0%
15321A	249	249	100.0%
15192A	18	18	100.0%
=====			
	3925	3662	93.3%

3 SHIFTS, 7 DAYS A WEEK

OC/ALC MABPAB  
SHEETMETAL REPAIR SHOP 6/15/89

-----			
	SURGE	BASE #9	
END-ITEM	INDUCTION	SIMULATION	THROUGHPUT
-----			
15188A	0	0	N/A
15237A	0	0	N/A
15249A	297	283	95.3%BASE ++
15250A	309	309	100.0%BASE ++
15175A	261	242	92.7%
15189A	31	29	93.5%
15236A	47	44	93.6%
15150A	254	247	97.2%
15140A	178	176	98.9%
15025A	224	222	99.1%
15136A	358	355	99.2%
15126A	279	277	99.3%
15113A	219	218	99.5%
15300A	287	286	99.7%
15137A	327	326	99.7%
15178A	286	286	100.0%
15191A	24	24	100.0%
15119A	277	277	100.0%
15321A	249	249	100.0%
15192A	18	18	100.0%
=====			
	3925	3868	98.5%

3 SHIFTS, 7 DAYS A WEEK PLUS ADDITIONAL AILERON FIXTURES



OC/ALC MABPAB  
SHEETMETAL REPAIR SHOP      6/15/89

	FY90	BASE #5	
END-ITEM	INDUCTION	SIMULATION	THROUGHPUT
15188A	0	0	N/A
15237A	0	0	N/A
15249A	182	116	63.7%BASE ++
15250A	195	146	74.9%BASE ++
15113A	134	129	96.3%
15126A	175	170	97.1%
15119A	170	166	97.6%
15175A	151	148	98.0%
15025A	136	134	98.5%
15136A	212	209	98.6%
15150A	146	145	99.3%
15189A	19	19	100.0%
15236A	23	23	100.0%
15300A	184	184	100.0%
15192A	12	12	100.0%
15137A	201	201	100.0%
15321A	161	161	100.0%
15140A	106	106	100.0%
15191A	16	16	100.0%
15178A	177	177	100.0%
	2400	2262	94.3%

2 SHIFTS, 5 DAYS A WEEK PLUS ADDITIONAL AILERON FIXTURES

## MABPAB TAGUCHI EXPERIMENTAL RESULTS - FY 90 SURGE

PART CONTROL NUMBER (PCN)	FY 90 INDUCTIONS	RUN #1	RUN #2	RUN #3	RUN #4	RUN #5	RUN #6	RUN #7	RUN #8	RUN #9
15113	219	189	218	219	219	218	219	219	217	218
15025	224	150	208	213	224	222	222	222	222	222
15119	277	51	143	200	259	213	259	275	274	277
15321	249	71	112	183	234	144	256	249	248	249
15126	279	116	225	279	276	277	277	275	277	277
15300	287	112	234	287	288	286	286	287	286	286
15136	358	161	355	355	353	354	354	358	355	355
15137	327	186	327	327	324	324	325	327	326	326
15140	178	71	173	173	173	174	176	174	177	176
15150	254	185	229	226	231	243	243	240	245	247
15175	261	82	157	187	217	213	232	231	248	242
15178	286	286	286	286	286	286	286	286	286	286
15188	0	0	0	0	0	0	0	0	0	0
15189	31	30	29	30	30	29	29	29	29	29
15191	24	24	24	24	24	24	24	24	24	24
15192	18	18	18	18	18	18	18	18	18	18
15236	47	44	45	45	44	45	45	45	45	44
15249	297	27	56	91	121	116	143	147	283	173
15250	309	33	79	110	158	147	179	196	316	213
THROUGHPUT	3,925	1,836 46.8 %	2,918 74.3 %	3,253 82.9 %	3,479 88.6 %	3,333 84.9 %	3,573 91.0 %	3,602 91.8 %	3,876 98.8 %	3,662 93.3 %

LSC-20460

# MABPAB TAGUCHI EXPERIMENTAL RESULTS - FY 90

PART CONTROL NUMBER (PCN)	FY 90 INDUCTIONS	RUN #1	RUN #2	RUN #3	RUN #4	RUN #5	RUN #6	RUN #7	RUN #8	RUN #9
15113	134	124	127	127	128	129	129	130	131	130
15025	136	131	136	135	135	134	133	133	134	134
15119	170	65	128	172	168	166	167	166	171	171
15321	161	74	130	161	161	161	161	161	161	161
15126	175	111	170	169	170	170	170	170	170	170
15300	184	117	184	184	184	184	184	184	184	184
15136	212	164	209	208	211	209	210	208	211	211
15137	201	180	199	199	200	201	201	201	200	200
15140	106	72	104	105	105	106	106	106	106	107
15150	146	141	142	141	145	145	144	144	145	145
15175	151	82	135	144	145	148	149	146	149	150
15178	177	177	177	177	177	177	177	177	177	177
15188	0	0	0	0	0	0	0	0	0	0
15189	19	19	19	18	18	19	19	19	19	19
15191	16	16	16	16	16	16	16	16	16	16
15192	12	12	12	12	12	12	12	12	12	12
15236	23	23	23	23	23	23	23	23	23	23
15249	182	40	73	89	116	112	143	144	177	178
15250	195	47	90	111	146	142	183	179	198	198
THROUGHPUT	2,400	1,595 66.5 %	2,074 86.4 %	2,190 91.3 %	2,260 94.2 %	2,254 93.9 %	2,327 97.0 %	2,319 96.6 %	2,384 99.3 %	2,386 99.4 %

LSC-20459

## WORKLOAD / EXPERIMENTATION:

JUNE 2, 1989

ON JUNE 1<sup>ST</sup> WE HAD A TELE-CONFERENCE WITH EARL STAMPS & STAFF TO STRUCTURE THE ORTHOGONAL ARRAY FOR MODEL EXPERIMENTATION USING TAGUCHI CONCEPT.

ISSUES : • MANPOWER DISTRIBUTION  
• FY90 WORKLOAD  
• FY90 SURGE.

### • MAN POWER :

NOW WE HAVE THE SAME NUMBER OF MANHOURS ONLY DISTRIBUTED ACROSS DIFFERENT SHIFT.

NEED TO INCLUDE INCREASED MANHOURS SUCH AS WEEKENDS

THIS COULD BE THE SAME AS ADDING PEOPLE.

40 HOURS BASE

$$\frac{48}{40} = 1.2$$

$$\frac{56}{40} = 1.4$$

EFFICIENCY (90%) 1.08

1.204

- WORKLOAD DRIVES RESOURCE NEEDS
- ON SURGE CONDITION

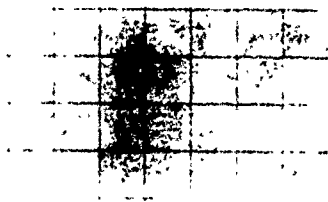
60% INCREASE OR WORKLOAD FACTOR OF 1.6  
2 Shift 7/DAYS 12 hours/shift.

- HOWEVER EFFICIENCY FACTOR ARE :

60 hours/WK  $\rightarrow$  90%

72 hours/WK  $\rightarrow$  86%

- SPLIT PEOPLE BETWEEN Shift  
‡ WORK OVERTIME.



May 31/JUNE

	WORKLOAD FY-90				MAX	
	1 <sup>ST</sup>	2 <sup>d</sup>	3 <sup>r</sup>	4 <sup>TH</sup>	WIP	
15025A	25	39	35	37	15	
15113A	28	35	34	37	15	
15119A	44	42	43	41	3	12
15321A	43	38	41	39	3	12
15126A	45	43	44	43	4	16
15300A	49	44	46	45	4	16
15136A	55	51	54	52	4	16
15137A	52	49	50	50	4	16
15140A	23	27	27	29	8	12
15150A	31	40	34	41	18	
15175A	18	39	38	56	3	12
15178A	41	46	45	45	5	15
15188A	-	-	-	-	-	
15189A	4	4	5	6	4	
15191A	4	4	4	4	4	
15192A	3	3	3	3	4	
15236A	5	9	9	6	4	
15249A	41	49	48	44	4	12
15250A	50	46	50	49	5	15

# TECHNOLOGY INSERTION

## MABPAB FY-90 WORKLOAD

END ITEM	QUARTER				MAX WIP
	1st	2nd	3rd	4th	
15025A	25	39	35	37	15
15113A	28	35	34	37	15
15119A	44	42	43	41	12
15321A	43	38	41	39	12
15126A	45	43	44	43	16
15300A	49	44	46	45	16
15136A	55	51	54	52	16
15137A	52	49	50	50	16
15140A	23	27	27	29	12
15150A	31	40	34	41	18
15175A	18	39	38	56	12
15178A	41	46	45	45	15
15189A	4	4	5	6	4
15191A	4	4	4	4	4
15192A	3	3	3	3	4
15236A	5	9	9	6	4
15249A	41	49	48	44	12
15250A	50	46	50	49	15

E. STAMP  
07 JUNE 1989

AFLC/MDMSC

# TECHNOLOGY INSERTION

## MABPAB FY-90 MANPOWER

SKILL CODE	QUANTITY QUARTER				FACTOR QUARTER			
	1st	2nd	3rd	4th	1st	2nd	3rd	4th
AS	13	18	16	17	5.0	5.3	6.1	5.9
BS	14	16	15	16	5.0	5.3	6.1	5.9
CS	10	16	16	12	5.0	5.3	6.1	5.9
DS	7	9	8	8	5.0	5.3	6.1	5.9
ES	75	72	72	71	5.0	5.3	6.1	5.9
FS	78	78	78	80	5.0	5.3	6.1	5.9

E. STAMP

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AFLC/MDMSC



# TECHNOLOGY INSERTION

## MABPAB Equipment Profile (Benches)

CODE	QUANTITY	END ITEM
25	13	15025A
113	13	15113A
119	3	15119A/15321A
126	3	15126A/15300A
136	6	15136A/15137A
140	7	15140A
150	18	15150A
175	3	15175A
178	5	15178A
188153	6	15188A/15189A
188154	6	15191A/15192A
236	4	15236A
249	7	15249A/15250A

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AFLC/MDMSC

## TECHNOLOGY INSERTION

### MABPAB Equipment Profile (Fixtures)

CODE	QUANTITY	END ITEM
F335-03	2	15136A/15137A
F135-02	1	15191A/15192A
F335-07	1	15249A/15250A
F335-08	3	15119A/15321A
F335-09	3	15126A/15300A
F135-08	1	15140A
F135-18	3	15175A
F135-13	2	15113A
F135-14	2	15025A
F335-10	3	15188A5061/15189A5061
F135-17	1	15150A

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AFLC/MDMSC

## TECHNOLOGY INSERTION

### MABPAB SHEET METAL TAGUCHI ORTHOGONAL ARRAY

					WORKLOAD	
					FLOW TIMES	
RUN #	MANPOWER	FACTOR	EQUIPMENT	FY 90		SURGE
1	1	1	1			
2	1	2	2			
3	1	3	3			
4	2	1	3			
5	2	2	1			
6	2	3	2			
7	3	1	2			
8	3	2	3			
9	3	3	1			

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**AFLC/MDMSC**

# TECHNOLOGY INSERTION

## MABPAB SHEET METAL TAGUCHI ORTHOGONAL ARRAY

WORKLOAD									
FLOW TIMES									
RUN #	MANPOWER			OVERTIME		EQUIPMENT	FY 90	SURGE	
	1	2	3	SAT	SUN				
1	ALL					BASE	66.5		
2	ALL			YES		BASE +	86.4		
3	ALL			YES	YES	BASE ++	94.3		
4	50%	50%				BASE ++	94.2		
5	50%	50%		YES		BASE	93.9		
6	50%	50%		YES	YES	BASE +	97.0		
7	1/3	1/3	1/3			BASE +	96.6		
8	1/3	1/3	1/3	YES		BASE ++	99.3		
9	1/3	1/3	1/3	YES	YES	BASE	99.4		

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# TECHNOLOGY INSERTION

## MABPAB Equipment Quantities

CODE	BASE +	BASE ++
119	4	6
126	4	6
136	8	10
249	9	11
F135-8	2	3
F135-18	4	5
F335-09	4	5

E. STAMP

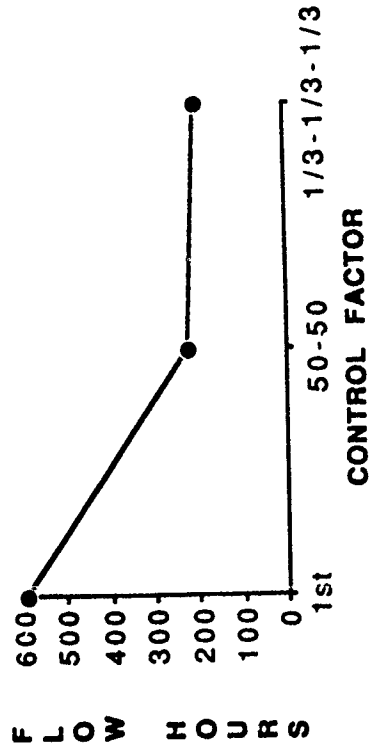
07 JUNE 1989

AFLC/MDMSC

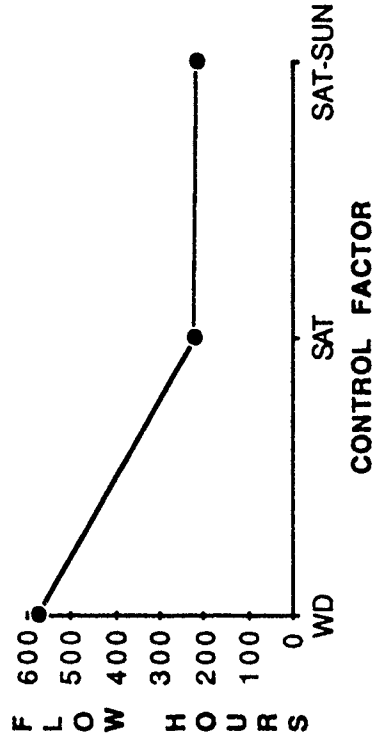
# TECHNOLOGY INSERTION

MABPAB EXPERIMENTATION RESULTS  
FY 90 WORKLOAD  
15126A/15300A

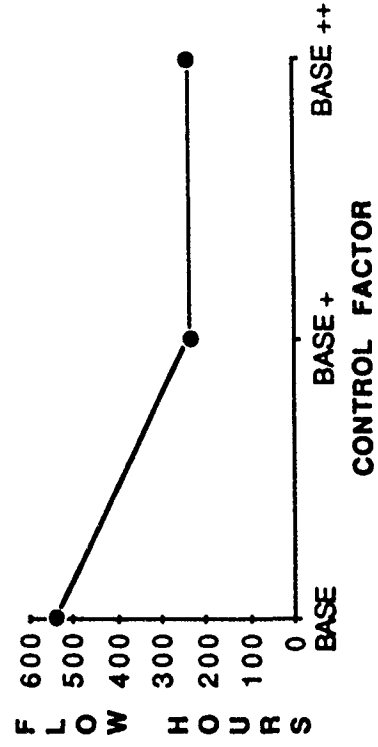
## MANPOWER



## FACTOR



## EQUIPMENT



E. STAMPS  
07 JUNE 1989

AFLC/MDMSC

# EXPERIMENT DATA CALULATION FLOW HOURS

R U N #	ITEM #			AVERAGE
	15126A	15300A		
1	1176	1291	=	1233.5
2	271	288	=	279.5
3	257	268	=	262.5
4	263	272	=	267.5
5	203	208	=	202.5
6	201	205	=	203.0
7	221	234	=	227.5
8	188	190	=	189.0
9	185	187	=	186.0

## MABPAB EXPERIMENT DATA CALCULATIONS

MP1  
 $1233.5+279.5+262.5 = 591.8$   
 MP2  
 $267.5+202.5+203 = 224.3$   
 MP3  
 $227.5+189+186 = 200.8$

F1  
 $1233.5+267.5+227.5 = 576.2$   
 F2  
 $279.5+202.5+189 = 223.7$   
 F3  
 $262.5+203+186 = 217.2$

EQ1  
 $1233.5+202.5+186 = 540.7$   
 EQ2  
 $279.5+203+227.5 = 236.7$   
 EQ3  
 $262.5+267.5+189 = 239.7$





ALC: OC RCC: MABPAB QUARTER: 4 DATE: 13-JUN-89 TIME: 20:05:11 REPT.ID: EXP #1 PAGE: 1

PROCESS TIMES SUMMARY

ITEM	HISTOR. FLOW HOURS	SIMULATED FLOW HOURS	WAITING FOR RESOURCES HOURS	PROCESSING FLOW HOURS	BACKSHOP HOURS	NUMBER OF SAMPLES
151123A	864.0	994.8	93.1	709.6	192.5	124
151125A	864.0	824.7	127.8	545.0	151.5	131
151127A	432.0	1761.6	122.8	446.5	96.0	74
151129A	432.0	1521.4	94.5	426.8	96.0	117
151131A	432.0	1219.5	404.3	213.0	96.0	117
151133A	504.0	1869.7	374.1	227.2	168.0	160
151135A	504.0	789.4	914.7	247.6	168.0	180
151137A	504.0	1436.6	151.8	425.6	150.0	141
151139A	528.0	1016.4	456.9	527.7	145.0	182
151141A	456.0	1465.0	69.8	414.2	192.0	180
151143A	840.0	991.8	VALUES 36 RECORDED **	790.0	165.5	19
151145A	0.0	275.6	VALUES 36 RECORDED **	146.4	96.0	19
151147A	864.0	967.0	46.4	752.3	168.0	17
151149A	0.0	1062.0	32.0	863.7	120.0	13
151151A	0.0	251.4	24.6	116.4	120.0	18
151153A	840.0	784.4	19.4	436.0	279.0	124
151155A	984.0	2807.9	VALUES 7 RECORDED **	911.9	120.0	49
151157A	984.0	2902.1	1776.2	908.6	120.0	47
151159A	0.0	237.0	14.0	175.0	48.0	23







ALC: OC RCC: MABPAB QUARTER: 4 DATE: 3-JUN-84 TIME: 12:48:54 REF: 10: 0000 00  
PROCESS TIMES SUMMARY

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[illegible]

ITEM	HISTOR. FLOW HOURS	SIMULATED FLOW HOURS	WAITING FOR RESOURCES HOURS	WAITING FOR RESOURCES %	PROCESSING FLOW HOURS	PROCESSING FLOW %	BACKSHOP HOURS	BACKSHOP %	NUMBER OF SAMPLES
15113A	864.0	14.7	37.8	7.3%	285.0	55.4%	192.0	37.0%	130
15125A	864.0	593.0	30.1	7.6%	214.4	55.4%	149.4	38.0%	133
15132A	456.0	303.0	40.6	13.5%	166.6	55.5%	96.0	31.0%	166
15136A	432.0	231.0	24.7	11.4%	100.8	55.5%	96.0	43.0%	170
15137A	504.0	234.0	33.8	14.2%	104.6	44.6%	96.0	41.0%	186
15140A	504.0	333.0	19.4	6.2%	161.5	44.6%	168.0	53.0%	201
15150A	504.0	201.8	26.0	9.1%	126.7	40.3%	168.0	53.0%	164
15178A	504.0	336.4	34.0	8.5%	168.2	54.4%	145.0	37.1%	146
15188A	840.0	528.1	52.8	13.8%	312.1	59.1%	163.2	30.9%	178
15189A	0.0	528.1	52.8	10.0%	312.1	59.1%	163.2	30.9%	20
15191A	864.0	190.3	13.7	7.2%	81.0	42.5%	96.0	50.3%	19
15192A	864.0	532.1	15.3	10.5%	340.2	56.6%	174.6	32.0%	113
15192A	864.0	183.9	13.7	7.5%	49.6	27.2%	120.0	65.4%	123
15237A	840.0	183.9	19.8	5.7%	241.3	43.0%	271.3	48.3%	123
15249A	984.0	561.4	48.8	8.0%	318.3	43.3%	120.0	16.3%	149
15250A	984.0	738.2	56.9	40.0%	330.7	44.8%	120.0	16.3%	179
15237A	0.0	145.2	12.1	3.8%	85.0	58.5%	48.0	33.1%	23

15188A SUB1  
 15189A SUB1  
 15191A SUB1  
 15192A SUB1  
 15237A SUB1  
 15249A SUB1  
 15250A SUB1

PROCESS TIMES SUMMARY

ITEM	HISTOR. FLOW HOURS	SIMULATED FLOW HOURS	WAITING FOR RESOURCES HOURS	PROCESSING FLOW HOURS	PROCESSING %	BACKSHOP HOURS	BACKSHOP %	NUMBER OF SAMPLES
1113A	864.0	408.0	3.4	212.2	52.1%	192.0	47.0%	131
15025A	432.0	324.0	7.4	166.7	51.3%	150.4	46.4%	134
1119A	432.0	324.0	4.7	134.7	57.2%	96.0	40.8%	171
1126A	432.0	324.0	6.1	130.7	56.1%	96.0	41.2%	164
1136A	432.0	190.0	6.2	86.2	45.2%	96.0	51.1%	170
1137A	432.0	311.0	6.9	136.0	43.6%	96.0	50.9%	189
1140A	504.0	281.0	5.4	111.4	43.1%	168.0	53.1%	211
1150A	504.0	324.0	5.5	133.2	39.6%	196.0	59.4%	207
1152A	504.0	317.0	5.3	139.2	52.4%	145.0	41.1%	145
1178A	456.0	299.0	2.3	104.7	35.0%	192.0	46.7%	178
1183A	840.0	450.0	VALUES RECORDED **	270.7	60.1%	164.4	36.5%	20
1188A SUB1	0.0	NO	VALUES RECORDED **	77.0	43.8%	96.0	54.5%	20
1189A SUB1	0.0	NO	VALUES RECORDED **	243.3	58.3%	164.0	39.3%	18
1191A	864.0	412.0	6.9	257.2	60.8%	160.0	37.8%	128
1192A SUB1	0.0	NO	VALUES RECORDED **	52.4	29.1%	120.0	68.0%	12
1192A SUB1	0.0	NO	VALUES RECORDED **	205.5	43.0%	268.2	56.2%	23
1236A	940.0	477.0	3.9	205.5	43.0%	268.2	56.2%	23
1237A	984.0	361.0	VALUES RECORDED **	230.7	63.9%	120.0	33.2%	177
1249A	984.0	359.0	10.4	229.6	63.9%	120.0	33.4%	198
1250A SUB1	0.0	NO	VALUES RECORDED **	277.3	61.5%	48.0	38.2%	23



PROCESS TIMES SUMMARY

ITEM	HISTOR. FLOW HOURS	SIMULATED FLOW HOURS	WAITING FOR RESOURCES HOURS	PROCESSING FLOW HOURS	PROCESSING FLOW %	BACKSHOP HOURS	BACKSHOP %	NUMBER OF SAMPLES
13A	64.0	405.0	3.1	210.6	51.9%	192.0	47.3%	130
125A	864.0	319.4	13.6	167.0	52.2%	149.0	46.2%	134
125A	432.0	244.6	13.6	135.9	55.3%	96.0	39.6%	117
125A	432.0	186.4	13.6	85.6	46.3%	96.0	31.4%	164
125A	456.0	206.4	4.4	136.3	44.5%	168.0	51.4%	170
125A	504.0	281.1	2.1	111.0	39.5%	168.0	54.8%	189
125A	504.0	239.5	10.4	133.3	55.9%	156.0	59.8%	200
125A	744.0	326.0	4.4	168.8	55.1%	152.0	40.1%	107
125A	538.0	318.8	4.6	104.3	32.9%	192.0	45.8%	150
125A	456.0	22.0	2.0	267.4	61.6%	164.4	37.9%	178
125A	840.0	43.3	2.0	76.4	44.2%	96.0	55.5%	20
125A	0.0	173.0	0.6	232.0	57.7%	168.0	41.7%	20
125A	864.0	402.5	2.1	250.2	60.9%	160.0	38.3%	18
125A	0.0	170.8	0.6	49.6	29.4%	120.0	70.3%	128
125A	840.0	183.8	0.6	201.2	41.6%	280.7	58.0%	123
125A	984.0	58.0	1.9	230.9	39.3%	120.0	20.4%	178
125A	0.0	125.3	2.9	77.3	61.7%	48.0	38.3%	23
125A	0.0	125.3	0.0	0.0	0.0%	0.0	0.0%	0

SUB1

SUB1

SUB1





QUARTER: 4 DATE: 13-JUN-89 TIME: 08:47:37 REL: 1.00.000000

TIME: 08:44:34 02/03/00 00:00:00

DIRECT LABOR STATISTICS

ITEM	EXPECTED HOURS	STANDARD HOURS	SIMULATED AVERAGE LABOR HOURS	STANDARD DEVIATION	SIMULATED MINIMUM LABOR HOURS	SIMULATED MAXIMUM LABOR HOURS	NUMBER OF SAMPLES
134A	49	147.70	122.68	5.78	102.60	137.36	18
135A	49	147.50	117.84	10.76	91.61	139.92	208
136A	49	189.80	177.85	10.76	75.62	178.62	143
137A	49	90.70	112.84	1.62	108.43	117.13	11
138A	49	88.30	114.44	4.08	47.90	163.50	125
139A	49	79.20	117.88	5.16	44.79	166.79	45
140A	49	79.20	117.88	5.16	44.79	166.79	45
141A	49	79.20	117.88	5.16	44.79	166.79	45
142A	49	79.20	117.88	5.16	44.79	166.79	45
143A	49	79.20	117.88	5.16	44.79	166.79	45
144A	49	79.20	117.88	5.16	44.79	166.79	45
145A	49	79.20	117.88	5.16	44.79	166.79	45
146A	49	79.20	117.88	5.16	44.79	166.79	45
147A	49	79.20	117.88	5.16	44.79	166.79	45
148A	49	79.20	117.88	5.16	44.79	166.79	45
149A	49	79.20	117.88	5.16	44.79	166.79	45
150A	49	79.20	117.88	5.16	44.79	166.79	45
151A	49	79.20	117.88	5.16	44.79	166.79	45
152A	49	79.20	117.88	5.16	44.79	166.79	45
153A	49	79.20	117.88	5.16	44.79	166.79	45
154A	49	79.20	117.88	5.16	44.79	166.79	45
155A	49	79.20	117.88	5.16	44.79	166.79	45
156A	49	79.20	117.88	5.16	44.79	166.79	45
157A	49	79.20	117.88	5.16	44.79	166.79	45
158A	49	79.20	117.88	5.16	44.79	166.79	45
159A	49	79.20	117.88	5.16	44.79	166.79	45
160A	49	79.20	117.88	5.16	44.79	166.79	45
161A	49	79.20	117.88	5.16	44.79	166.79	45
162A	49	79.20	117.88	5.16	44.79	166.79	45
163A	49	79.20	117.88	5.16	44.79	166.79	45
164A	49	79.20	117.88	5.16	44.79	166.79	45
165A	49	79.20	117.88	5.16	44.79	166.79	45
166A	49	79.20	117.88	5.16	44.79	166.79	45
167A	49	79.20	117.88	5.16	44.79	166.79	45
168A	49	79.20	117.88	5.16	44.79	166.79	45
169A	49	79.20	117.88	5.16	44.79	166.79	45
170A	49	79.20	117.88	5.16	44.79	166.79	45
171A	49	79.20	117.88	5.16	44.79	166.79	45
172A	49	79.20	117.88	5.16	44.79	166.79	45
173A	49	79.20	117.88	5.16	44.79	166.79	45
174A	49	79.20	117.88	5.16	44.79	166.79	45
175A	49	79.20	117.88	5.16	44.79	166.79	45
176A	49	79.20	117.88	5.16	44.79	166.79	45
177A	49	79.20	117.88	5.16	44.79	166.79	45
178A	49	79.20	117.88	5.16	44.79	166.79	45
179A	49	79.20	117.88	5.16	44.79	166.79	45
180A	49	79.20	117.88	5.16	44.79	166.79	45
181A	49	79.20	117.88	5.16	44.79	166.79	45
182A	49	79.20	117.88	5.16	44.79	166.79	45
183A	49	79.20	117.88	5.16	44.79	166.79	45

CC: OC RCC: MABPAB QUARTER: 4 DATE: 13-JUN-89 TIME: 11:58:31 REP: 10: 5000-  
ACCESS TIMES SUMMARY

PROCESS TIMES SUMMARY

ITEM	HISTOR. FLOW HOURS	SIMULATED FLOW HOURS	WAITING FOR RESOURCES HOURS	PROCESSING FLOW HOURS	PROCESSING FLOW %	BACKSHOP HOURS	BACKSHOP %	NUMBER OF SAMPLES
13A	864.0	64.7	64.0	402.5	60.9%	192.0	29.1%	2259
13A	864.0	64.7	64.0	297.3	56.7%	150.0	28.6%	2259
13A	432.0	32.3	43.4	245.7	29.7%	96.0	11.7%	2259
13A	432.0	32.3	43.4	239.9	26.6%	96.0	10.8%	2259
13A	432.0	32.3	43.4	134.0	47.0%	96.0	33.8%	2259
13A	432.0	32.3	43.4	174.3	40.3%	168.0	38.4%	2259
13A	432.0	32.3	43.4	174.3	41.3%	168.0	39.4%	2259
13A	432.0	32.3	43.4	236.1	55.2%	196.0	28.5%	2259
13A	432.0	32.3	43.4	236.1	55.2%	196.0	28.5%	2259
13A	432.0	32.3	43.4	146.2	35.0%	192.0	46.0%	2259
13A	840.0	697.5	VALUES RECORDED	468.2	67.1%	164.0	23.5%	30
13A	840.0	697.5	VALUES RECORDED	103.1	45.1%	96.0	42.0%	28
13A	840.0	697.5	VALUES RECORDED	424.8	64.3%	169.2	25.6%	28
13A	840.0	697.5	VALUES RECORDED	468.7	67.2%	159.0	23.0%	28
13A	840.0	697.5	VALUES RECORDED	73.7	33.9%	120.0	51.2%	28
13A	840.0	697.5	VALUES RECORDED	271.0	43.5%	276.0	44.3%	28
13A	984.0	1842.6	VALUES RECORDED	464.5	25.2%	120.0	6.5%	121
13A	984.0	1842.6	VALUES RECORDED	466.9	25.8%	120.0	6.6%	121
13A	984.0	1842.6	VALUES RECORDED	97.9	62.2%	48.0	30.5%	146













Ricardo

DDB

TABLE OF CALCULATIONS

Omega Transform FY-90		
Run No.	Thruput (%)	db
1	66.5	2.9778
2	86.4	8.0297
3	91.3	10.2095
4	94.2	12.1062
5	93.9	11.8734
6	97.0	15.0965
7	96.6	14.5350
8	99.3	21.5185
9	99.4	22.1924

**Manpower Distribution**

1st shift

$$\frac{2.9778 + 8.0297 + 10.2095}{3} = 7.0723 \quad 83.6\%$$

50%/50%

$$\frac{12.1062 + 11.8734 + 15.0965}{3} = 13.0254 \quad 95.25\%$$

3rd

$$\frac{14.5350 + 21.5185 + 22.1924}{3} = 19.4153 \quad 98.87\%$$

**Overtime**

40 hrs

$$\frac{2.9778 + 12.1062 + 21.5185}{3} = 9.873 \quad 90.66\%$$

SAT

$$\frac{8.0297 + 11.8734 + 14.535}{3} = 13.8072 \quad 96.00\%$$

SAT & SUN

$$\frac{10.2095 + 15.0965 + 22.1924}{3} = 15.8328 \quad 97.46\%$$

# Equipment Base

Base

$$\frac{2.9778 + 11.8734 + 22.1924}{3} = 12.3478 \quad 94.50\%$$

Base +

$$\frac{8.0297 + 15.0965 + 14.535}{3} = 12.5537 \quad 94.74\%$$

Base + +

$$\frac{10.2095 + 12.1062 + 21.5185}{3} = 14.6114 \quad 96.66\%$$

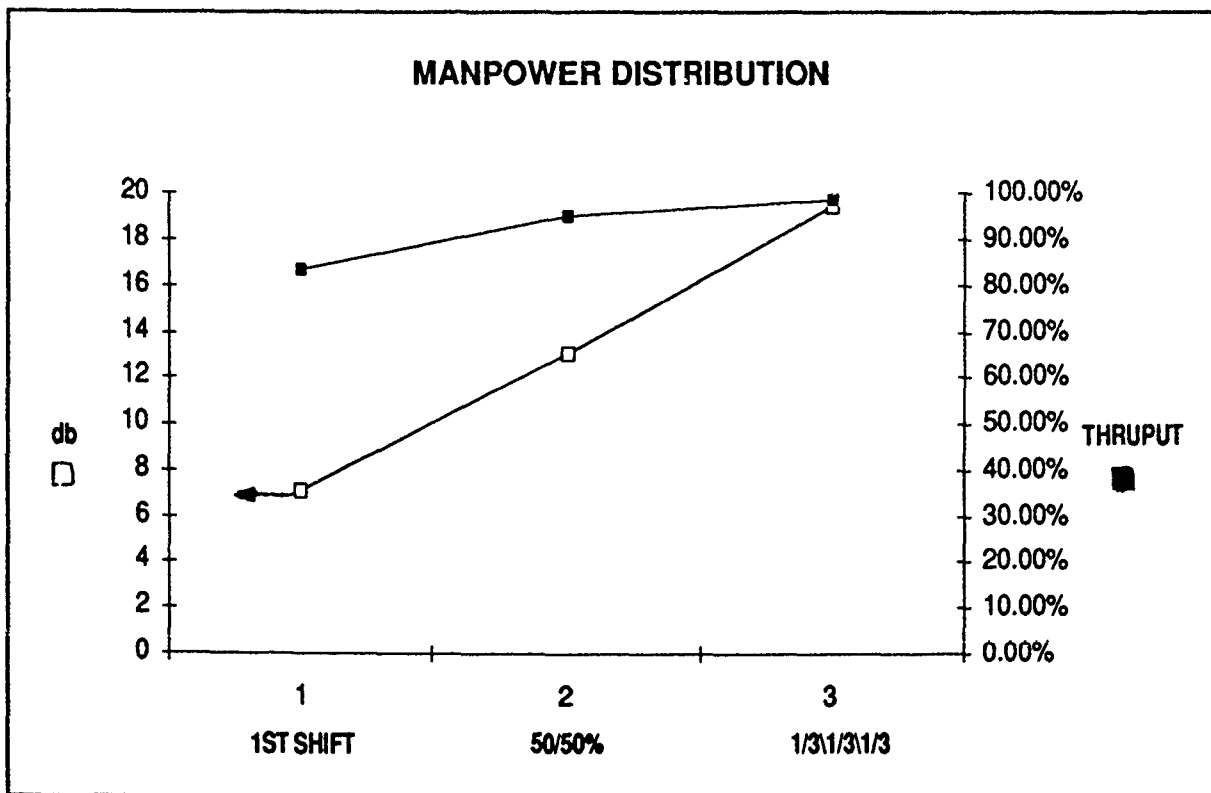
Average = 13.1710      95.4031%

Now for just 2nd shift

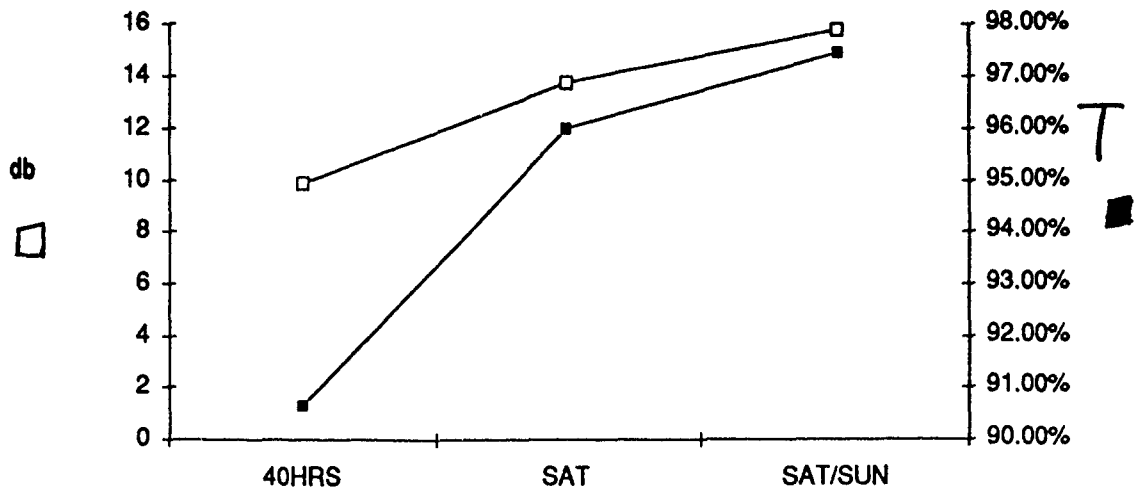
$$13.1710 + (12.3479 + 13.1710) + (9.873 - 13.1710) + (13.1710 - 13.0254) = 9.1955 \quad 89.26\%$$

2nd shift + SAT

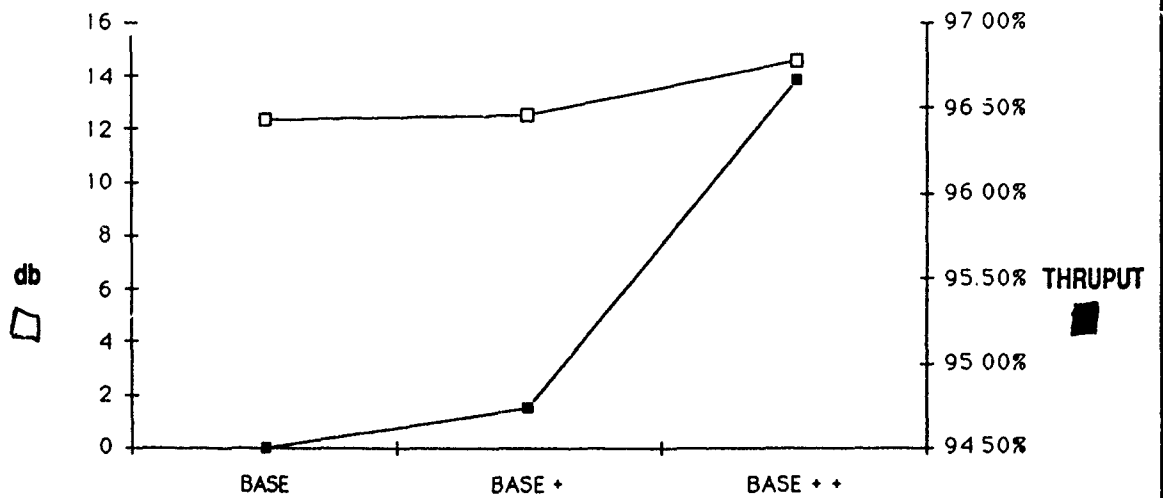
$$13.1710 + (13.0254 - 13.1710) + (13.8072 - 13.1710) + (13.1710 - 12.4379) = 12.8355, \quad 95.06\%$$



# OVERTIME



# EQUIPMENT



### Omega Transform FY-90

Run No.	Thruput (%)	db
1	46.8	-0.5567
2	74.3	4.6106
3	82.9	6.8556
4	88.6	8.9053
5	84.9	7.4993
6	91.0	10.0480
7	91.8	10.4903
8	98.8	19.1558
9	93.3	11.4381

#### Manpower Distribution

1st shift

$$\frac{-0.5567 + 4.6106 + 6.8556}{3} = 3.6365 \quad 69.79\%$$

50%/50%

$$\frac{8.9053 + 7.4993 + 10.0480}{3} = 8.8175 \quad 88.4\%$$

3rd

$$\frac{10.4903 + 19.1558 + 11.4381}{3} = 13.6947 \quad 95.9\%$$

#### Overtime

40 hrs

$$\frac{-0.5567 + 8.9053 + 10.4903}{3} = 6.2796 \quad 80.9\%$$

SAT

$$\frac{4.6106 + 7.4993 + 19.1558}{3} = 10.4219 \quad 91.68\%$$

SAT & SUN

$$\frac{6.8556 + 10.0480 + 11.4381}{3} = 9.4472 \quad 89.8\%$$

#### Equipment Base

Base

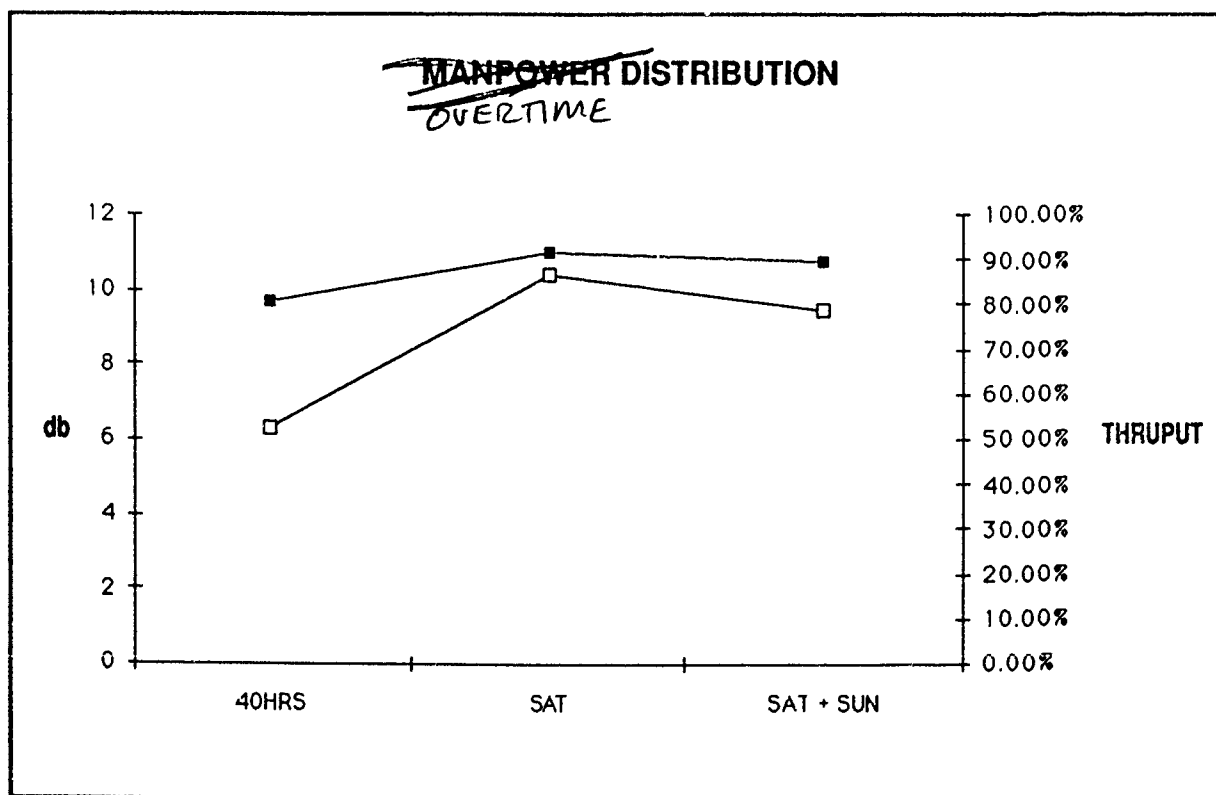
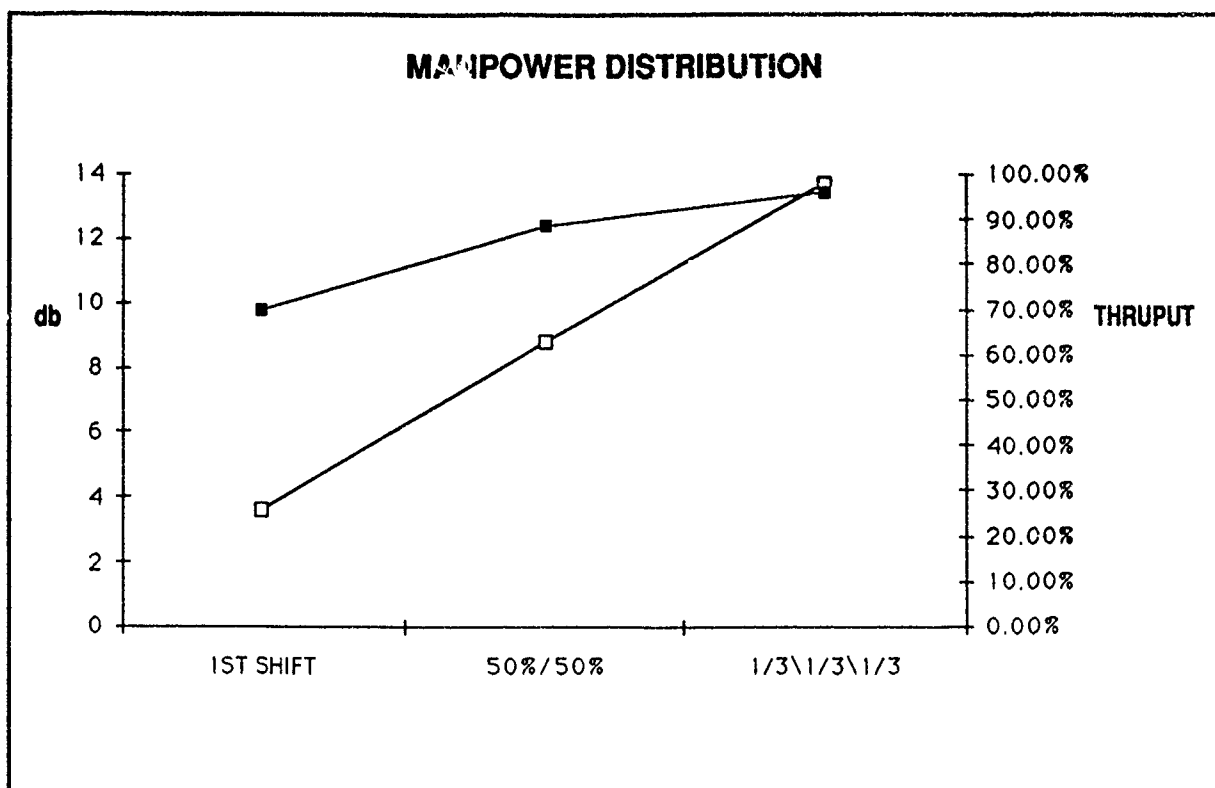
$$\frac{-0.5567 + 7.4993 + 11.4381}{3} = 6.1269 \quad 80.39\%$$

Base +

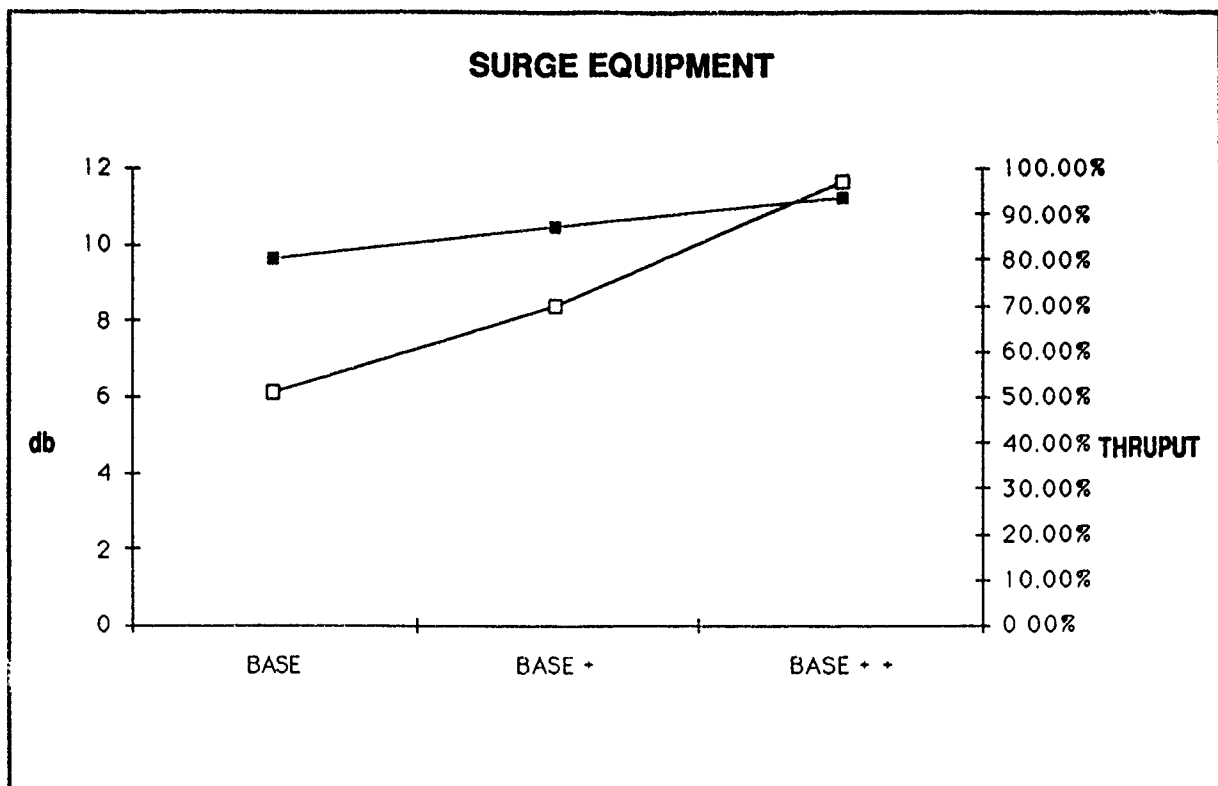
$$\frac{4.6106 + 10.0480 + 10.4903}{3} = 8.383 \quad 87.33\%$$

Base + +

$$\frac{6.8556 + 8.9053 + 19.1558}{3} = 11.6389 \quad 93.58\%$$







**SUMMARY:**

"BEST " WE CAN DO IS 1/3, SAT. AND ONLY BASE BECAUSE OF SPACE LIMITATIONS

AVERAGE = 8.7163

PREDICTED =  $8.8163 + \{13.6947 - 8.7163\} \{10.4219 - 8.7163\} + \{6.1268 - 8.7163\}$

12.8109 ~ 95.0%

# EXPERIMENT DATA Calculation

Flow Hours

	15126A	15300A	$\bar{x}$
1	1176	1291	1233.5
2	271	288	279.5
3	257	268	262.5
4	263	272	267.5
5	203	208	202.5
6	201	205	203.0
7	221	234	227.5
8	188	190	189.0
9	185	187	186.0

# MABPAB EXPERIMENT DATA CALCULATIONS

MRpower 1

$$1233.5 + 279.5 + 262.5 = 591.8$$

MRT 2

$$267.5 + 202.5 + 203 = 224.3$$

MP 3

$$227.5 + 189 + 186 = 200.8$$

---

F 1

$$1233.5 + 267.5 + 227.5 = 576.2$$

$$F 2 \quad 279.5 + 202.5 + 189 = 223.7$$

$$F 3 \quad 262.5 + 203 + 186 = \underline{217.2}$$

---

Eq 1

$$1233.5 + 202.5 + 186 = 540.7$$

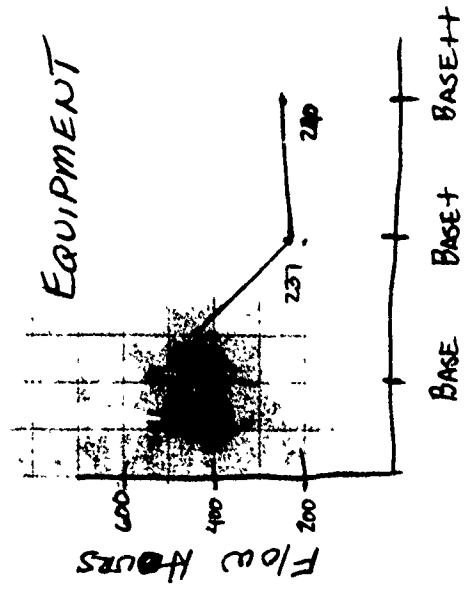
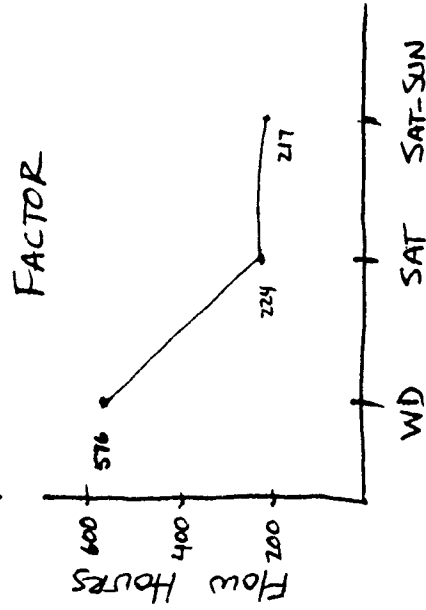
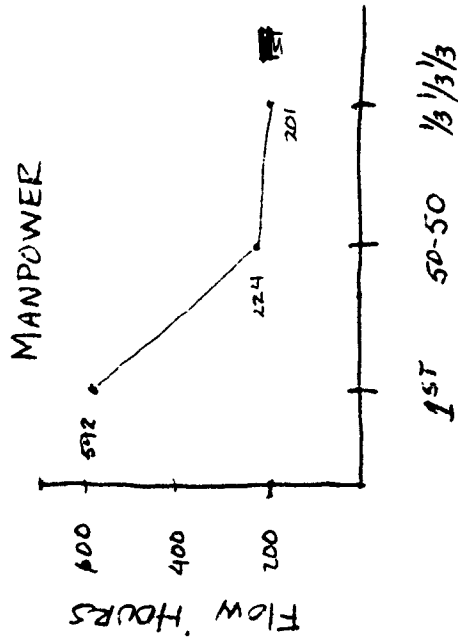
Eq 2

$$279.5 + 203 + 227.5 = 236.7$$

Eq 3

$$262.5 + 267.5 + 189 = \underline{239.7}$$

# MAOTFLC EXPERIMENTATION RESULTS FY 90 WORKLOAD 15126A / 15300A



Part No. 023A

FY90

①

Manpower Dist.

96.3%  
Throughput at  
level 1

All Day shift

$$= (824 + 567 + 560) / 3 = 650.3$$

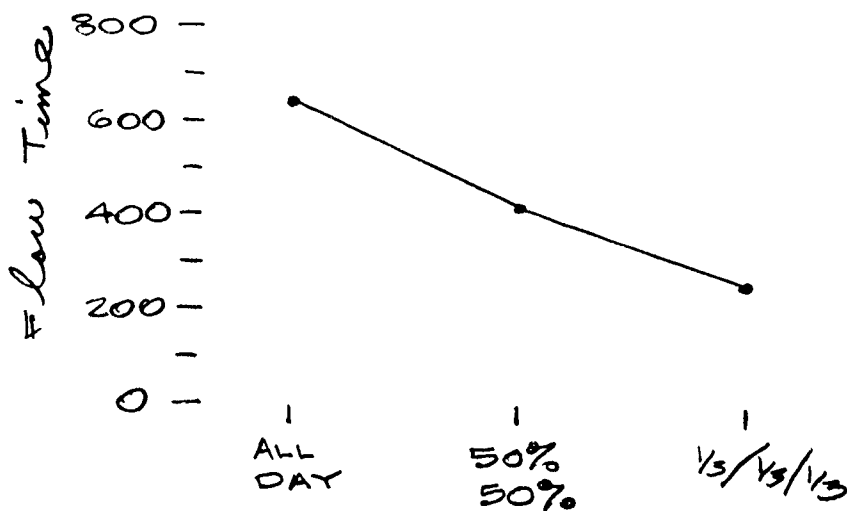
Any  
change  
moves  
to 100%.

50%/50%

$$= (476 + 375 + 371) / 3 = 407.3$$

1/3/1/3/1/3

$$= (394 + 324 + 319) / 3 = 259.2$$



Overtime

40 hrs

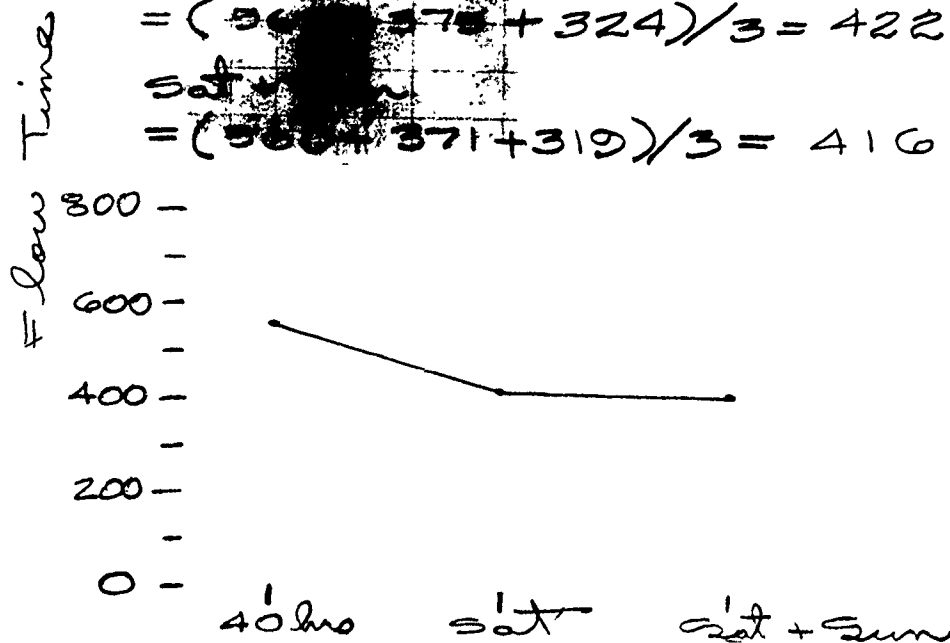
$$= (824 + 476 + 394) / 3 = 564.7$$

Sat

$$= (567 + 375 + 324) / 3 = 422$$

Sat + Sun

$$= (567 + 371 + 319) / 3 = 416.7$$



Part No. 113A

FY 90

②

92.5% Throughput at level 1

Manpower Dist.

All Day shift

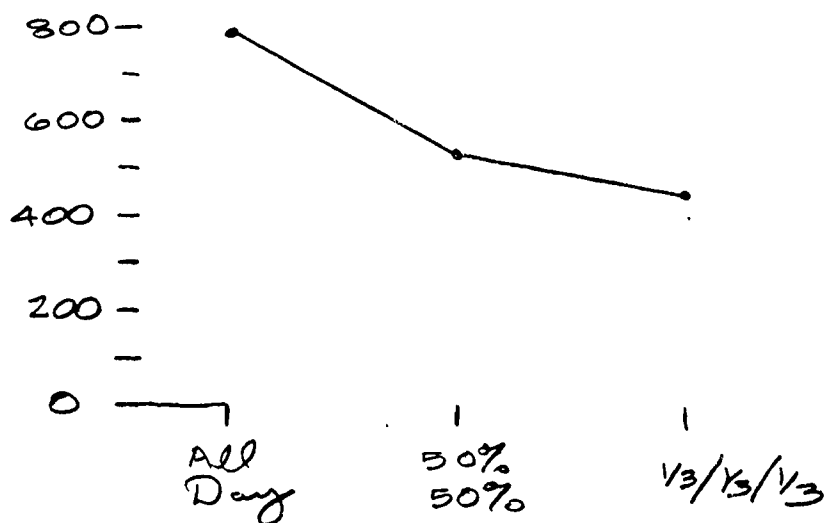
$$= (995 + 699 + 695) / 3 = 796.3$$

50% / 50%

$$= (630 + 473 + 477) / 3 = 526.7$$

1/3 / 1/3 / 1/3

$$= (515 + 408 + 406) / 3 = 443$$



Overtime

40 hrs

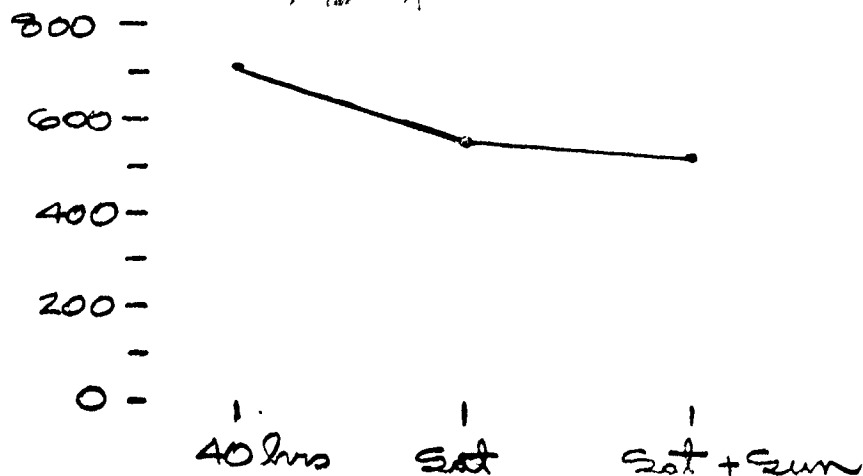
$$= (995 + 630 + 515) / 3 = 713.3$$

Sat.

$$= (699 + 473 + 515) / 3 = 562.3$$

Sat + Sun

$$= (699 + 477 + 406) / 3 = 526.0$$



Part No. 113A

FY 90

Use Omega transform on  
Thruput

$$\text{Omega Transform} = -10 \log_{10} \left( \frac{1}{P} - 1 \right)$$

Run no.	Thruput (%)	Transform (db)
1	92.5	10.9108
2	94.8	12.6080
3	94.8	12.6080
4	95.5	13.2679
5	96.3	14.1542
6	96.3	14.1542
7	97.0	15.0965
8	97.8	16.4792
9	97.0	15.0965

Manpower Dist.  
All Day Shift

$$= (10.9108 + 12.6080 + 12.6080) / 3$$

$$= 12.0423$$

50% / 50%

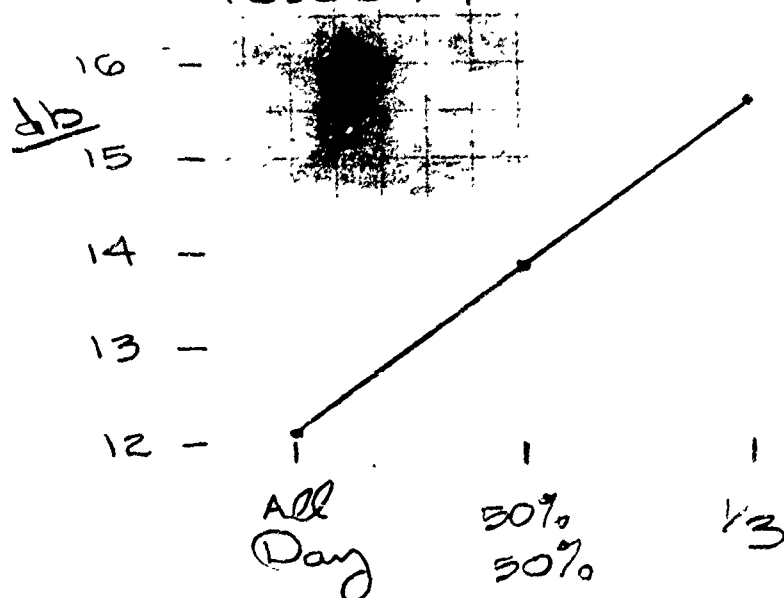
$$= (13.2679 + 14.1542 + 14.1542) / 3$$

$$= 13.8588$$

1/3 / 1/3 / 1/3

$$= (15.0965 + 16.4792 + 15.0965) / 3$$

$$= 15.5574$$



Part no. 113A

FY90

④

Overtime

40 hrs

$$= (10.9108 + 13.2679 + 15.0965) / 3$$

$$= 13.0917$$

Sat.

$$= (12.6080 + 14.1542 + 16.4792) / 3$$

$$= 14.4138$$

Sat + Sun

$$= (12.608 + 14.1542 + 15.0965) / 3$$

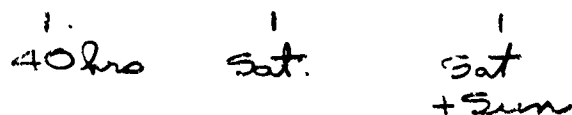
$$\frac{db}{16} = 13.9529$$

15 -

14 -

13 -

12 -



Best condition is  $\frac{1}{3} / \frac{1}{3} / \frac{1}{3}$   
and Sat. which is run no.  
8.

$$\begin{aligned} \text{Prediction} &= 13.8195 + (14.4138 - 13.8195) \\ &+ (15.5574 - 13.8195) \\ &= 16.1517 \end{aligned}$$

which translates to 97.6%  
throughput. Run no. 8 provided  
97.8% throughput



Part no. 119A

FY90

③

Manpower Dist.

All Day Shift

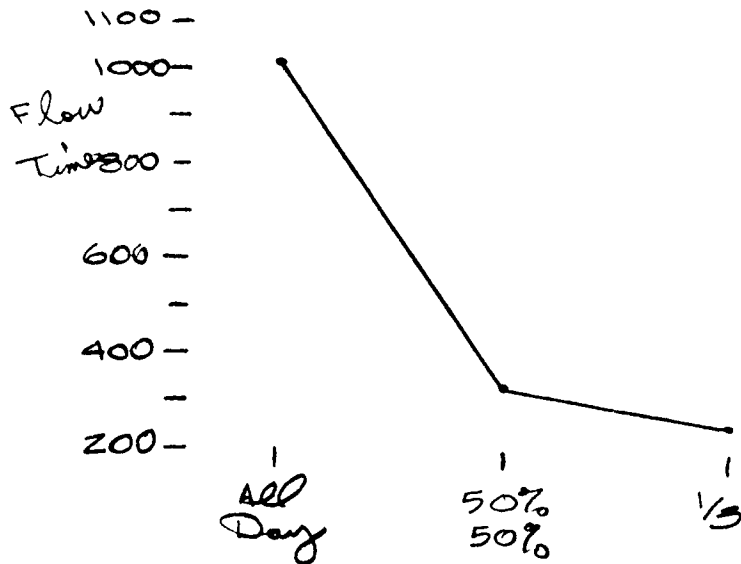
$$= (1765 + 821 + 485) / 3 = 1023.7$$

50%/50%

$$= (376 + 331 + 288) / 3 = 331.7$$

1/3/1/3

$$= (305 + 235 + 245) / 3 = 261.7$$



Overtime

40 hrs

$$= (1765 + 376 + 305) / 3 = 815.3$$

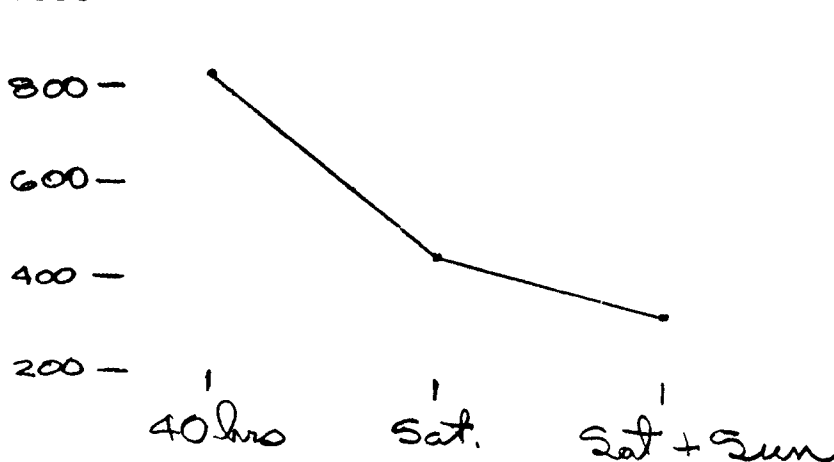
Sat.

$$= (821 + 331 + 235) / 3 = 462.3$$

Sat + Sun

$$= (485 + 288 + 245) / 3 = 339.3$$

Flow Time



Part no. 119A

FY 90

6

Equip.

Base

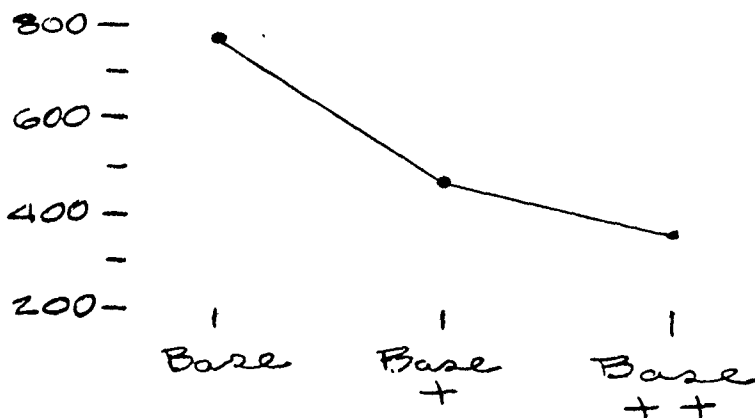
$$= (176 + 331 + 245) / 3 = 780.3$$

Base +

$$= (821 + 288 + 305) / 3 = 471.3$$

Base ++

$$= (485 + 376 + 235) / 3 = 365.3$$



Omega Transform

Run No.	Thruput	(db)
1	38.2 %	-2.0892
2	75.3	4.8410
3	100 ~ 99.0	19.9564
4	98.8	19.1558
5	97.6	16.0924
6	98.2	17.3684
7	97.6	16.0924
8	100	19.9564
9	100	19.9564

Manpower Dist.

All day shift

$$= (-2.0892 + 4.8410 + 19.9564) / 3$$

$$= 7.5694$$

50%/50%

$$= (19.1558 + 16.0924 + 17.3684) / 3$$

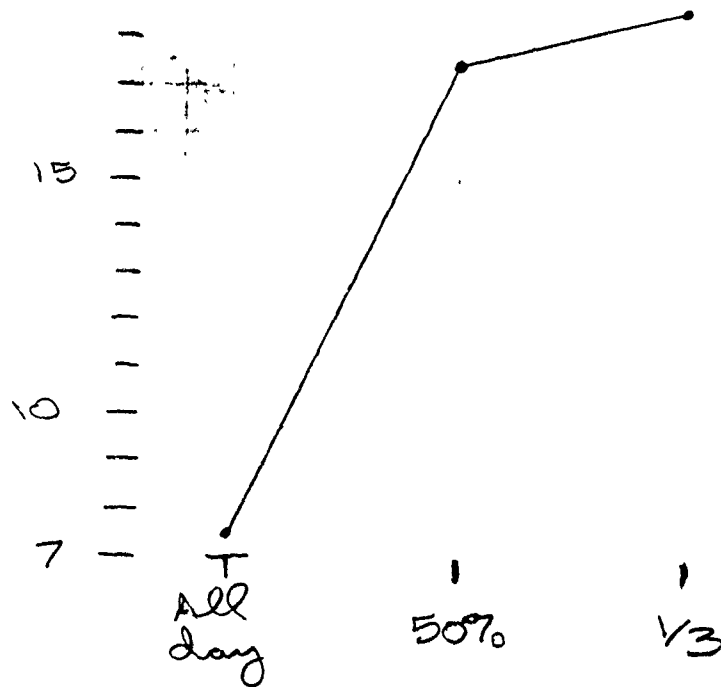
$$= 17.5389$$

$$Y3 = (16.0924 + 19.9564 + 19.9564) / 3 = 18.6684$$

Part no. 119A  
db 19.0

FY 90

(7)



Overtime  
40 hrs.

$$= (-2.0892 + 19.1558 + 16.0924) / 3 = 11.053$$

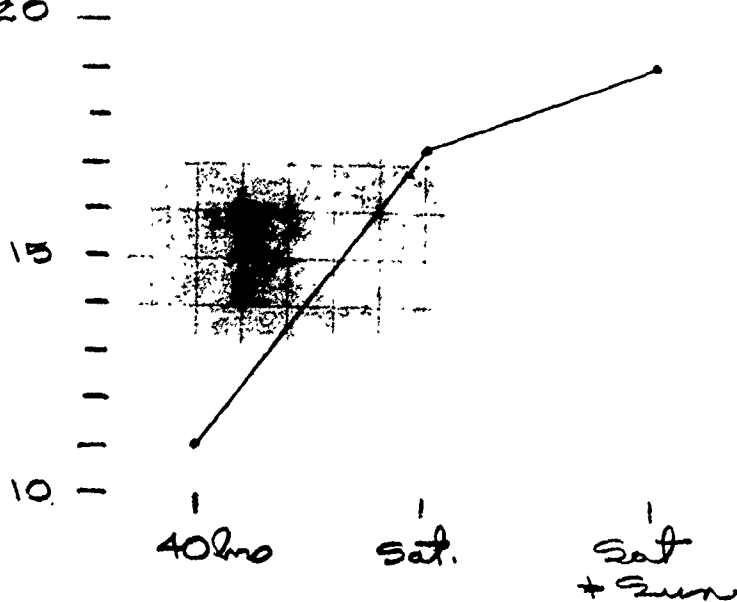
Sat.

$$= (4.8410 + 16.0924 + 19.9564) / 3 = 17.3143$$

Sat + Sun.

$$= (19.9564 + 17.3684 + 19.9564) / 3 = 19.0937$$

db  
20



Part no. 119A FY90

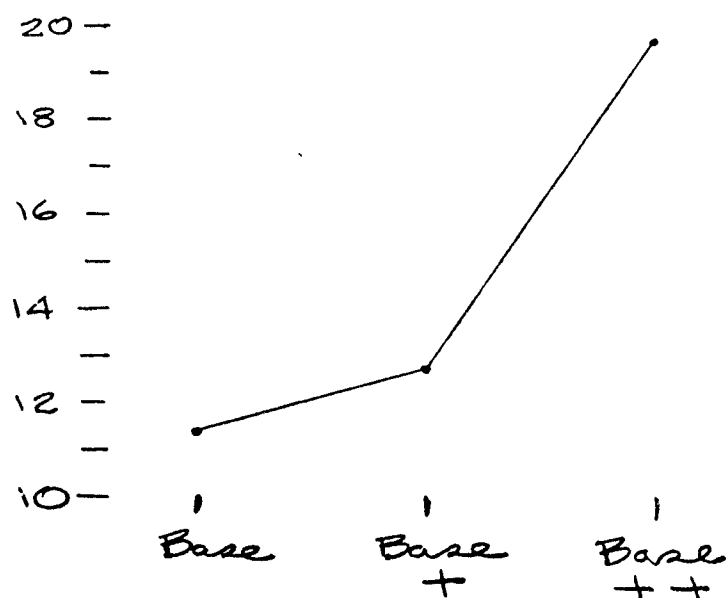
(8)

Equip.

$$\text{Base} = (-2.0892 + 16.0924 + 19.9564) / 3 = 11.3199$$

$$\text{Base} + = (4.8410 + 17.3684 + 16.0924) / 3 = 12.7673$$

$$\text{Base} ++ = (19.9564 + 19.1558 + 19.9564) / 3 = 19.6895$$



Best condition is  $\frac{1}{3} / \frac{1}{3} / \frac{1}{3}$ , Sat + Sun,  
Base ++

$$\begin{aligned} \text{Prediction} &= 14.5922 + (19.6895 - 14.5922) \\ &\quad + (19.0937 - 14.5922) + (18.6684 - 14.5922) \\ &= 28.2672 \text{ which translates} \\ &\text{to } \underline{99.8\% \text{ throughput}} \end{aligned}$$

Now this best condition is too expensive, then consider 50/50, Sat., and Base ++.

$$\begin{aligned} \text{Prediction} &= 14.5922 + (19.6895 - 14.5922) \\ &\quad + (17.3143 - 14.5922) + (17.5389 - 14.5922) \\ &= 25.3583 \text{ which translates} \\ &\text{to } \underline{99.7\% \text{ throughput}} \end{aligned}$$

Also consider only 50% Sat or Sat ++

Part No. 321A  
Mangrove Dist.

FY 90

②

All Day shift

$$= (1522 + 812 + 478) / 3 = 937.3$$

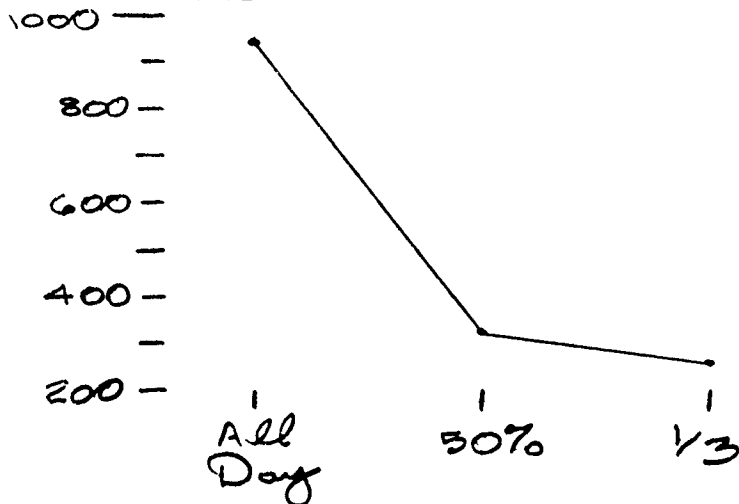
50%/50%

$$= (372 + 328 + 283) / 3 = 327.7$$

1/3/1/3

$$= (311 + 233 + 242) / 3 = 262$$

Flow Time



Overtime

40 hrs

$$= (1522 + 372 + 311) / 3 = 735$$

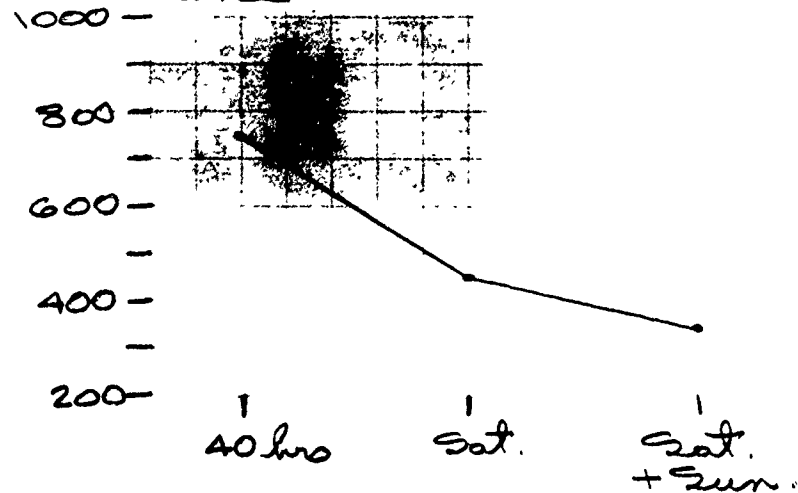
Sat.

$$= (812 + 328 + 233) / 3 = 457.7$$

Sat + Sun

$$= (478 + 283 + 242) / 3 = 334.3$$

Flow Time



Part No. 321A

FY 90

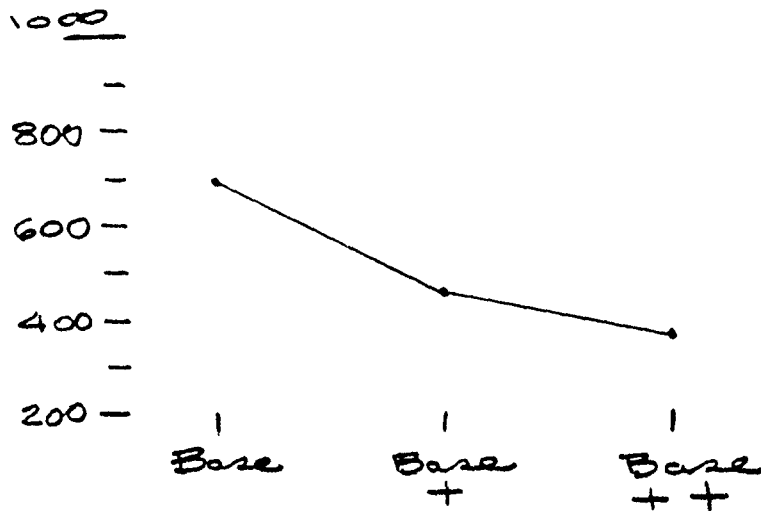
10

Equip.

$$\text{Base} = (1522 + 328 + 242) / 3 = 697.3$$

$$\text{Base} + = (812 + 283 + 311) / 3 = 468.7$$

$$\text{Base} + + = (478 + 372 + 233) / 3 = 361$$



Run No.	Omega Transform Thruput	db
1	46 %	-6.6964
2	80 %	6.0206
3	100 %	19.9564
4	100	19.9564
5	100	19.9564
6	100	19.9564
7	100	19.9564
8	100	19.9564
9	100	19.9564

Manpower Dist.  
All shift

$$= (-6.6964 + 6.0206 + 19.9564) / 3 = 8.4269$$

50%

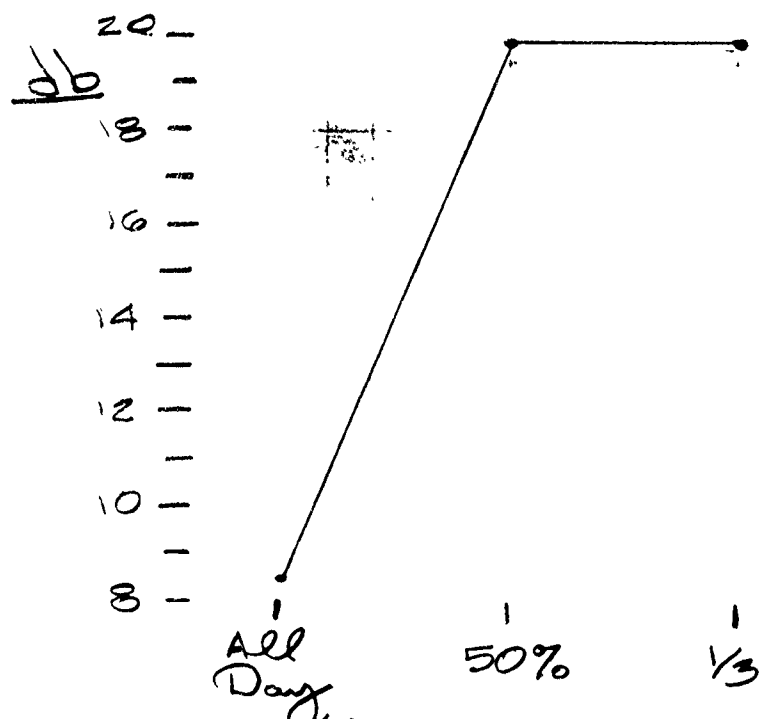
$$= 19.9564$$

$$Y_3 = 19.9564$$

Part No. 321A

FY90

(11)

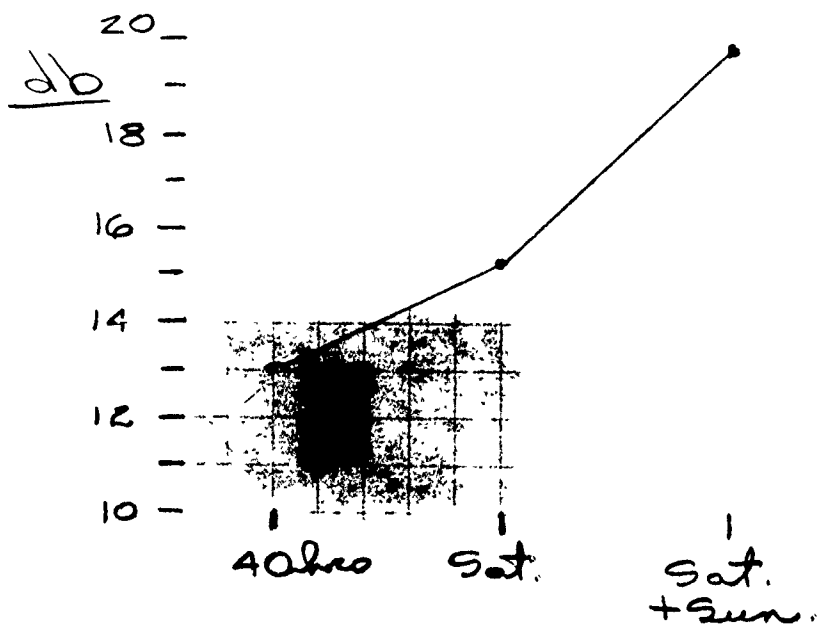


Overtime

$$40\text{hrs} = (-.6964 + 19.9564 + 19.9564) / 3 = 13.0721$$

$$\text{Sat.} = (6.0206 + 19.9564 + 19.9564) / 3 = 15.3111$$

$$\text{Sat.} + \text{Sun.} = (19.9564)$$

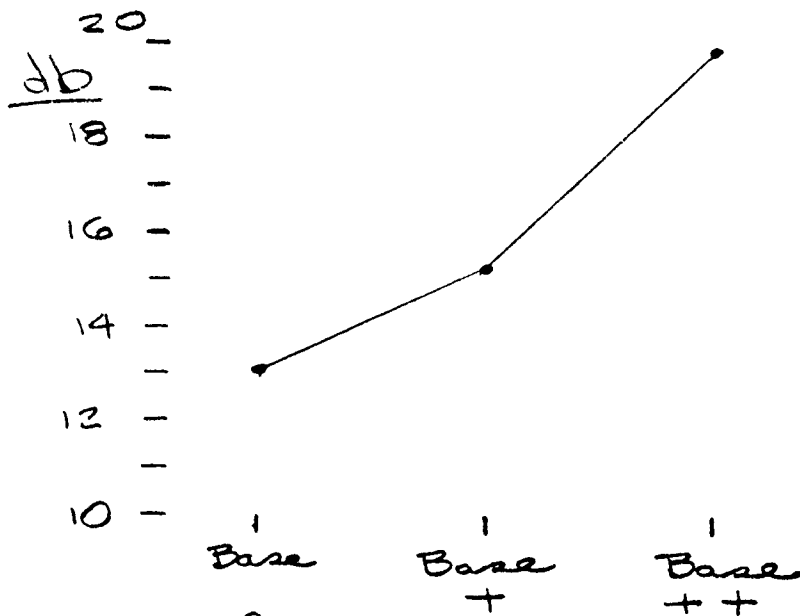


Equip.

$$\text{Base} = (-.6964 + 19.9564 + 19.9564) / 3 = 13.0721$$

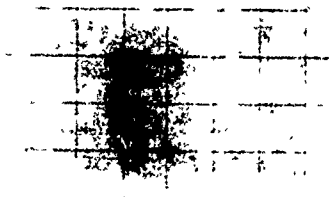
$$\text{Base} + = (6.0206 + 19.9564 + 19.9564) / 3 = 15.3111$$

$$\text{Base} ++ = (19.9564$$



In this case, 50%/50%, Sat + Sun.,  
Base ++ is the best condition

Prediction =  $16.1132 + (19.9564 - 16.1132)$   
(so only need one factor - which is  
50%/50% to achieve 99%)





Part no. 126A  
 Manpower Dist.  
 All Day shift

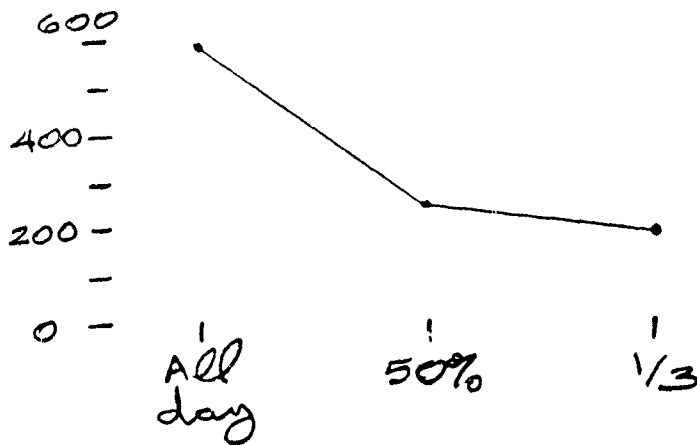
FY 90

15

$$= (1254 + 268 + 257) / 3 = 593$$

$$50\% = (262 + 203 + 200) / 3 = 221.7$$

$$1/3 = (221 + 188 + 185) / 3 = 198$$

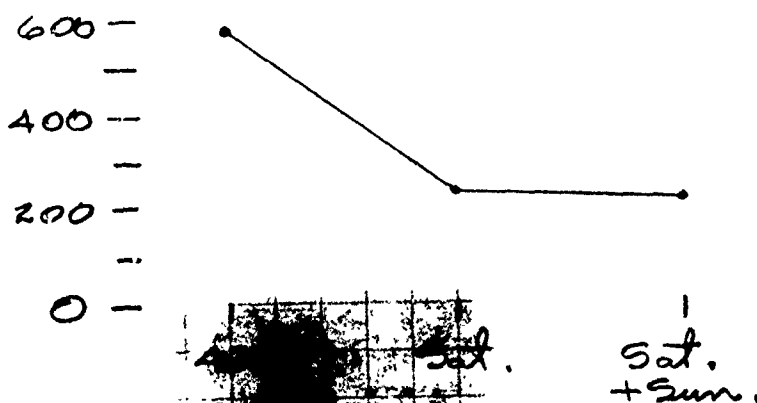


Overtime

$$40 \text{ hr} = (1254 + 262 + 221) / 3 = 579$$

$$\text{Sat.} = (268 + 203 + 188) / 3 = 219.7$$

$$\text{Sat.} + \text{Sun.} = (257 + 200 + 185) / 3 = 214.0$$



Equip.

$$\text{Base} = (1254 + 203 + 185) / 3 = 547.3$$

$$\text{Base} + = (268 + 200 + 221) / 3 = 229.7$$

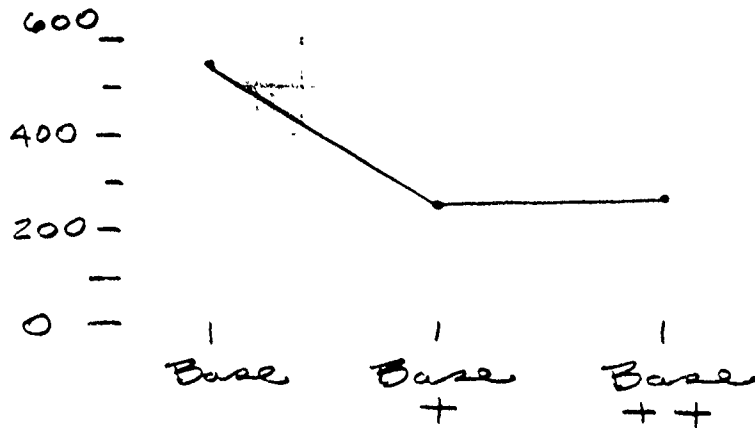
$$\text{Base} + + = (257 + 262 + 188) / 3 = 235.7$$

Part no. 126 A

FY90

14

Flow Time



Omega Transform

Run no.	Thruput	db
1	63.4	2.3861
2	97.1	15.2482
3	96.6	14.5350
4	97.1	15.2482
5	↕	↓
6		
7		
8		
9	97.1	15.2482

Manpower Dist.

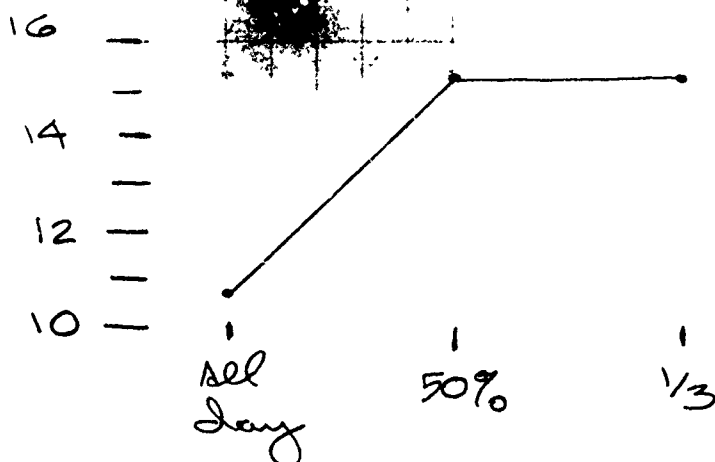
All day shift

$$= (2.3861 + 15.2482 + 14.5350) / 3 = 10.7231$$

50%

$$= (15.2482$$

$$1/3 = 5.0827$$



Part no. 126A

FY 90

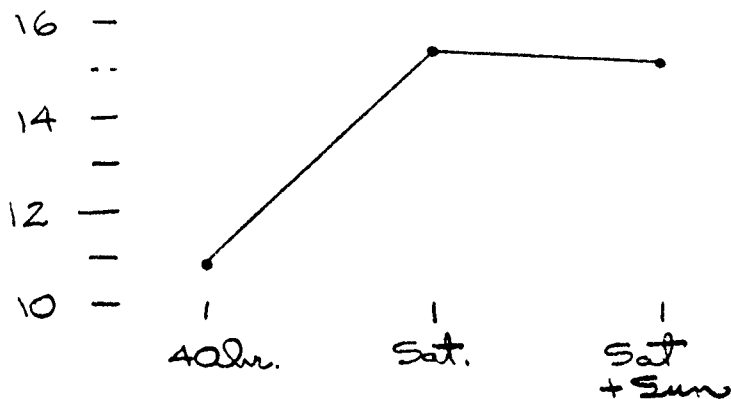
(15)

Overtime

$$40 \text{ hr.} = (2.3861 + 15.2482 + 15.2482) / 3 = 10.9608$$

$$\text{Sat} = (15.2482)$$

$$\text{Sat} + \text{Sun} = (14.5350 + 15.2482 + 15.2482) / 3 = 15.0105$$



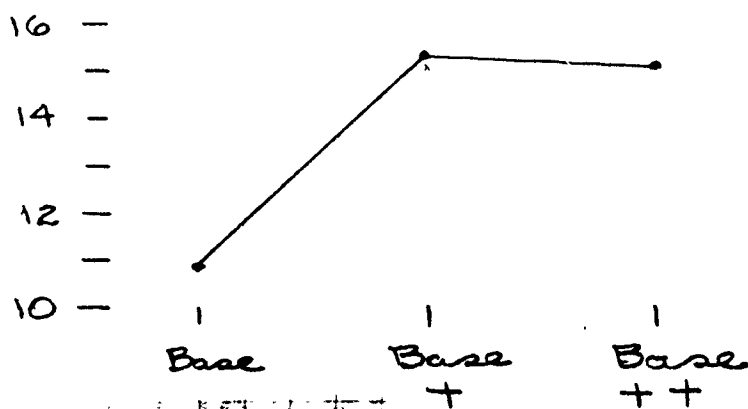
Equip.

$$\text{Base} = (2.3861 + 15.2482 + 15.2482) / 3 = 10.9608$$

$$\text{Base} + = (15.2482)$$

$$\text{Base} ++ = (14.535 + 15.2482 + 15.2482) / 3 =$$

15.0105



So, ~~Base +~~, Sat. (50%)

$$\begin{aligned} \text{Predicted} &= 13.7398 + (15.2482 - 13.7398) \\ &+ (15.2482 - 13.7398) + (15.2482 - 13.7398) \\ &= 18.2649 \approx 98.5\% \end{aligned}$$

300A

MY 90

(16)

Manpower Dist.

All day shift

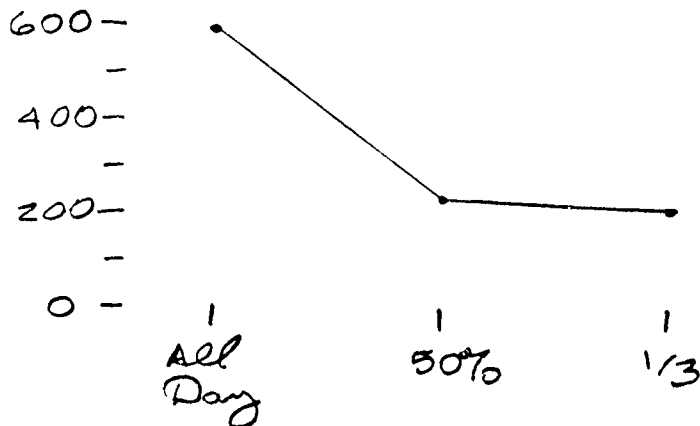
$$= (1220 + 283 + 267) / 3 = 590$$

50/50 ..

$$= (268 + 208 + 203) / 3 = 226.3$$

 $\frac{1}{3}$ 

$$= (234 + 190 + 187) / 3 = 203.7$$

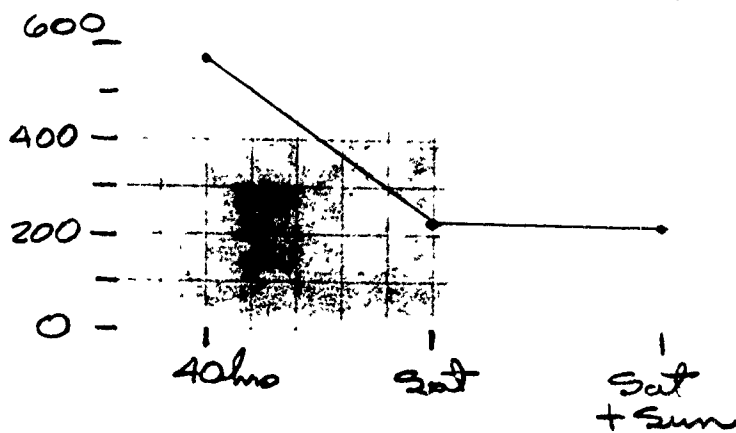


Overtime

$$40 \text{ hrs} = (1220 + 268 + 234) / 3 = 574$$

$$\text{Sat.} = (283 + 208 + 190) / 3 = 227$$

$$\text{Sat} + \text{Sun} = (267 + 203 + 187) / 3 = 219$$

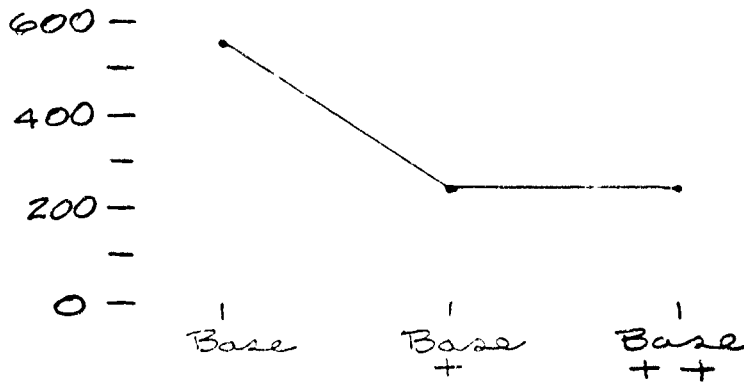


Equip.

$$\text{Base} = (1220 + 208 + 187) / 3 = 538.3$$

$$\text{Base} + = (283 + 203 + 234) / 3 = 240$$

$$\text{Base} ++ = (267 + 268 + 190) / 3 = 241.7$$



Any shift gives 100%  
 Base throughput = 63.6%



136A

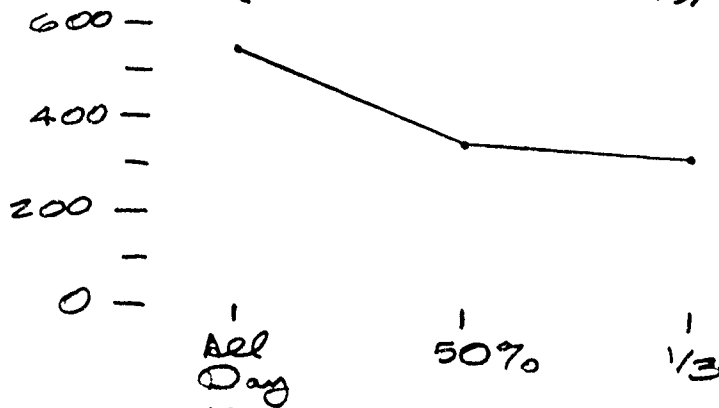
FY90

Manpower Dist.  
All Day shift

$$= (862 + 382 + 380) / 3 = 541.3$$

$$50\% = (393 + 323 + 322) / 3 = 346$$

$$1/3 = (365 + 312 + 306) / 3 = 327$$

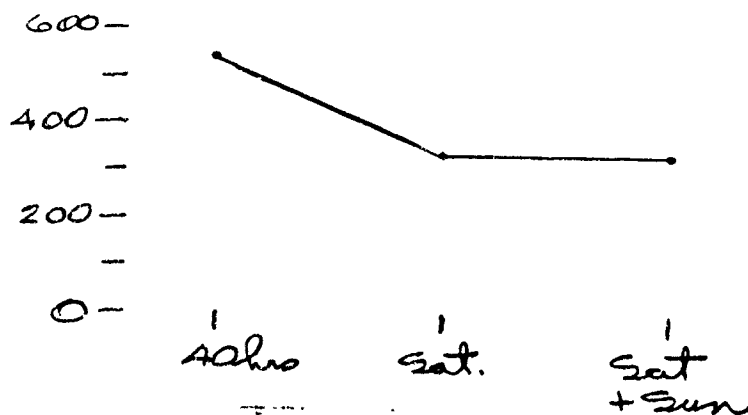


Overtime

$$40hrs = (862 + 393 + 363) / 3 = 539.3$$

$$Sat. = (382 + 323 + 312) / 3 = 339$$

$$Sat. + Sun. = (380 + 322 + 306) / 3 = 336$$

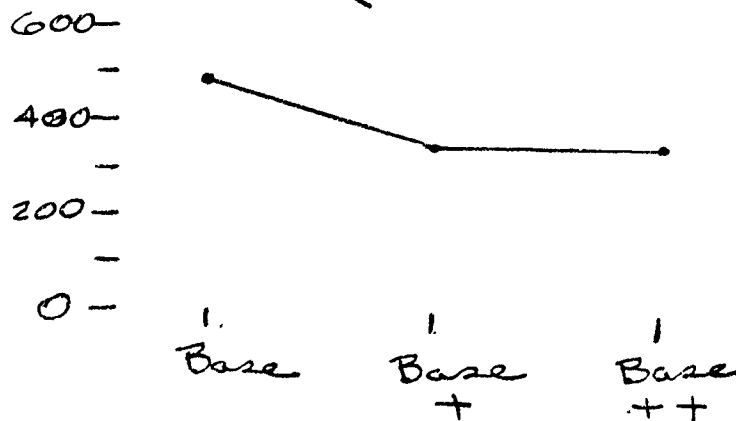


Equip

$$Base = (302 + 323 + 306) / 3 = 497$$

$$Base + = (382 + 322 + 363) / 3 = 355.7$$

$$Base ++ = (380 + 393 + 312) / 3 = 361.7$$



136A

FY 90

$$-10 \log_{10} \left( \frac{1}{P} - 1 \right)$$

(19)

Omega Transform  
Run No.      Thruput

1	77.4	5.3463
2	98.6	18.4775
3	98.1	17.1292
4	99.5	22.9885
5	98.6	18.4775
6	99.1	20.4183
7	98.1	17.1292
8	99.5	22.9885
9	99.5	22.9885

Manpower Dist.

All day

$$= (5.3463 + 18.4775 + 17.1292) / 3 = 13.651$$

50%

$$= (22.9885 + 18.4775 + 20.4183) / 3 = 20.6281$$

$$1/3 = (17.1292 + 22.9885 + 22.9885) / 3 = 21.0351$$

db

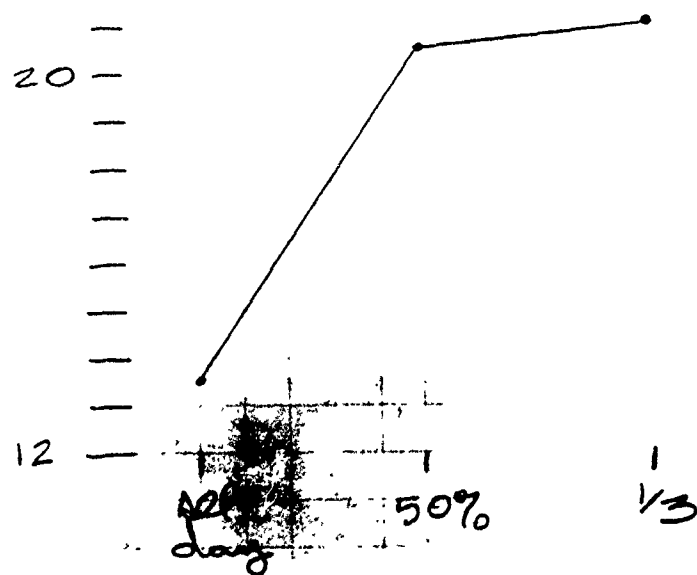
22 -

20 -

12 -

All day 50%

1/3



136AFY9020

overtime

40hrs

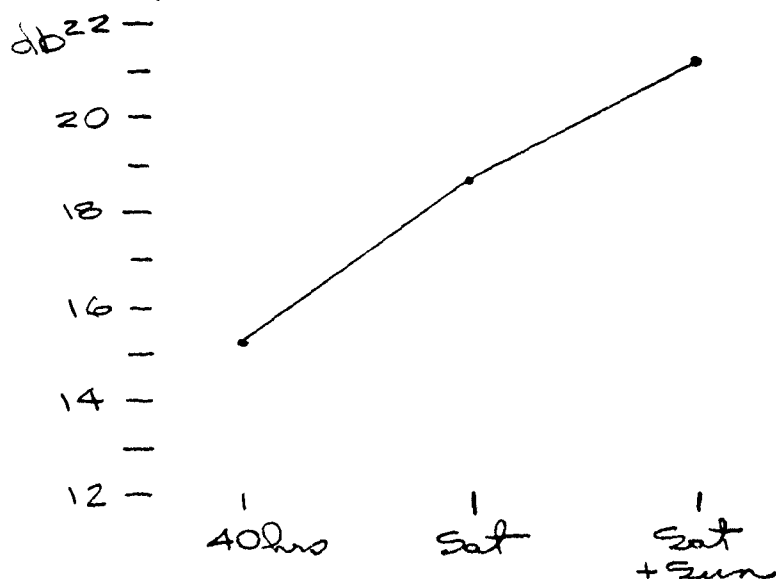
$$= (5.3463 + 22.9885 + 17.1292) / 3 = 15.1547$$

Sat

$$= (18.4775 + 20.4183 + 17.1292) / 3 = 18.675$$

Sat + Sun

$$= (17.1292 + 22.9885 + 22.9885) / 3 = 21.0354$$

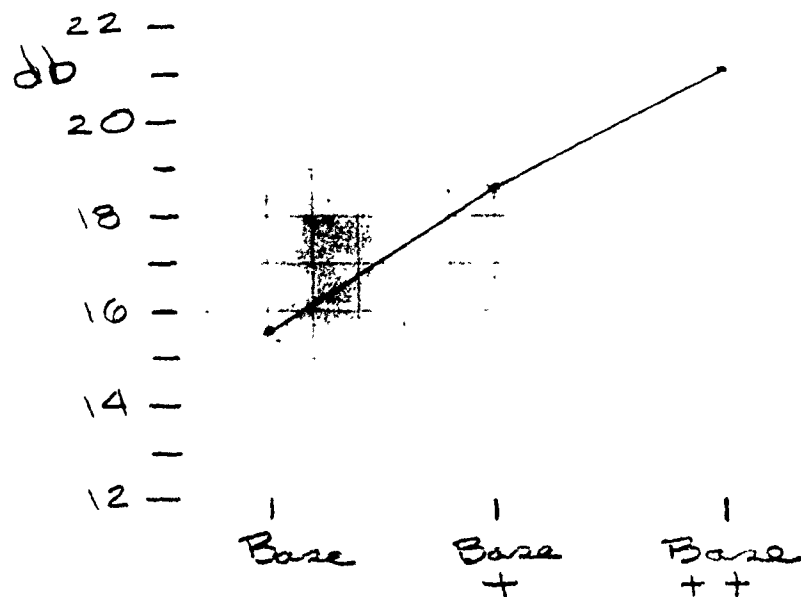


Equip.

$$\text{Base} = (5.3463 + 18.4775 + 22.9885) / 3 = 15.6041$$

$$\text{Base} + = (18.4775 + 20.4183 + 17.1292) / 3 = 18.675$$

$$\text{Base} ++ = (17.1292 + 22.9885 + 22.9885) / 3 = 21.0354$$



$$\text{Average} = 18.4382$$

so with just 50%, 99.1%



137A

FY90

(21)

Manpower Dist.  
All day shift

$$= (790 + 351 + 351) / 3 = 497.3$$

$$50\% = (363 + 296 + 296) / 3 = 318.3$$

$$1/3 = (314 + 284 + 281) / 3 = 293$$

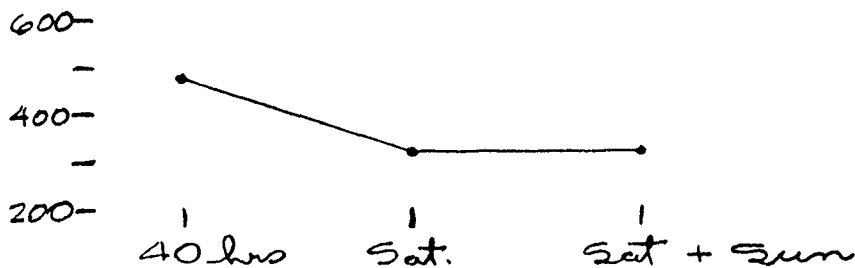


Overtime

$$40 \text{ hrs} = (790 + 363 + 314) / 3 = 489$$

$$\text{Sat.} = (351 + 296 + 284) / 3 = 310.3$$

$$\text{Sat} + \text{Sun} = (351 + 296 + 281) / 3 = 309.3$$

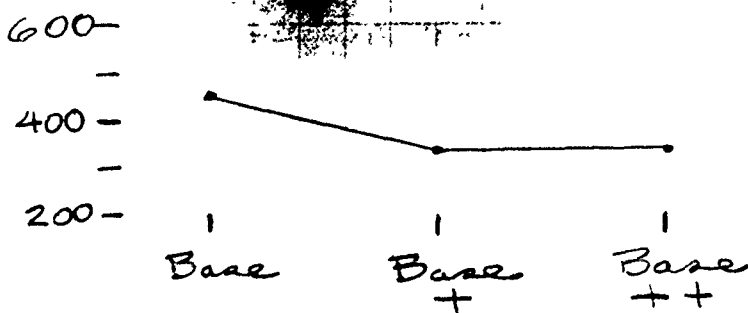


Equip.

$$\text{Base} = (790 + 296 + 281) / 3 = 455.7$$

$$\text{Base} + = (351 + 296 + 314) / 3 = 320.3$$

$$\text{Base} + + = (351 + 296 + 284) / 3 = 332.7$$



Any shift moves to 99%  
Base = 89.6%

140A

FY90

(2)

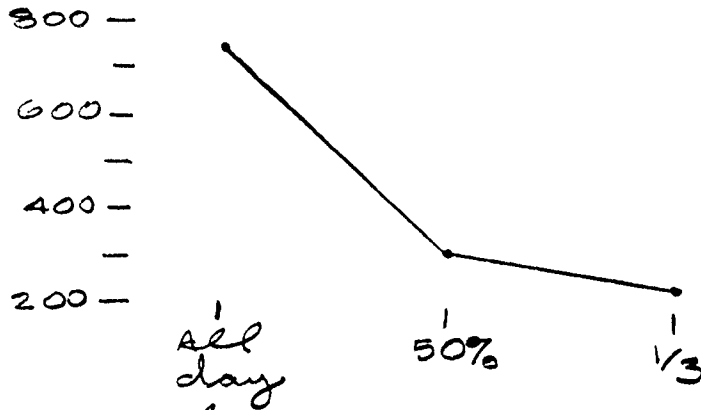
Manpower Dist.  
All day shift

$$= (1436 + 408 + 401) / 3 = 748.3$$

50%

$$= (374 + 286 + 274) / 3 = 311.3$$

$$1/3 = (288 + 232 + 239) / 3 = 253$$

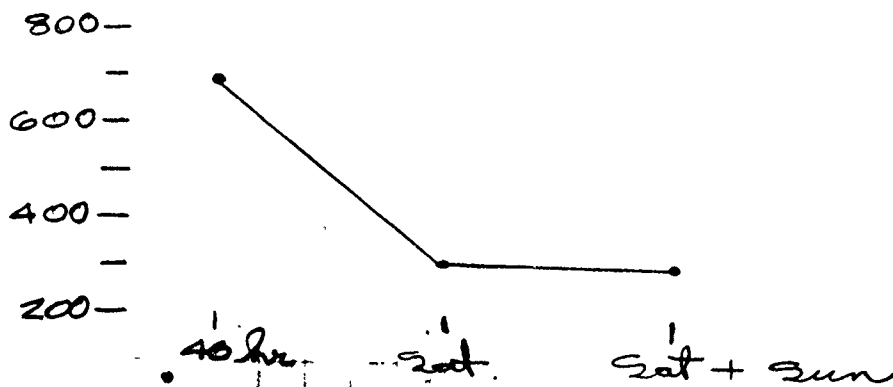


Overtime

$$40 \text{ hr.} = (1436 + 374 + 288) / 3 = 699.3$$

$$\text{Sat.} = (408 + 286 + 232) / 3 = 308.7$$

$$\text{Sat.} + \text{Sun} = (401 + 274 + 239) / 3 = 304.7$$

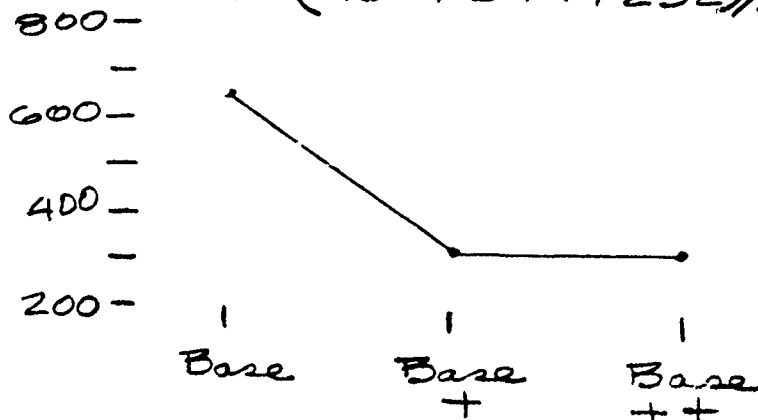


Equip.

$$\text{Base} = (1436 + 286 + 239) / 3 = 653.7$$

$$\text{Base} + = (408 + 274 + 288) / 3 = 323.3$$

$$\text{Base} + + = (401 + 374 + 232) / 3 = 335.7$$



Base 67.9  
Day shift  
provides  
at least  
98.1%

150A

FY90

23

Manpower Dist.  
All day shift

$$(329 + 536 + 557) / 3 = 640.7$$

$$50\% (475 + 369 + 368) / 3 = 404$$

$$1/3 (402 + 324 + 326) / 3 = 350.7$$

Overtime

$$40\text{hrs} = (329 + 475 + 402) / 3 = 568.7$$

$$\text{Sat.} = (536 + 369 + 324) / 3 = 409.7$$

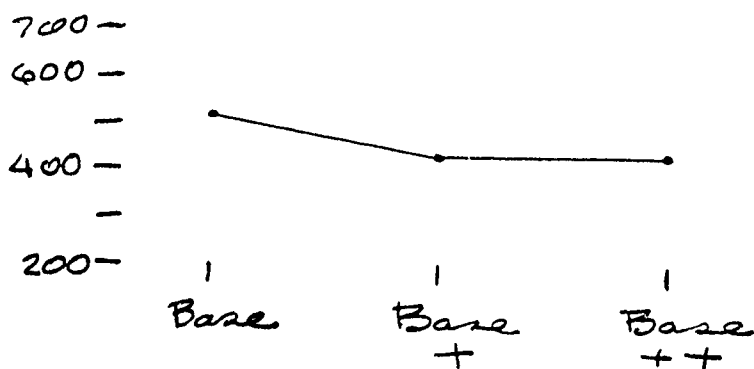
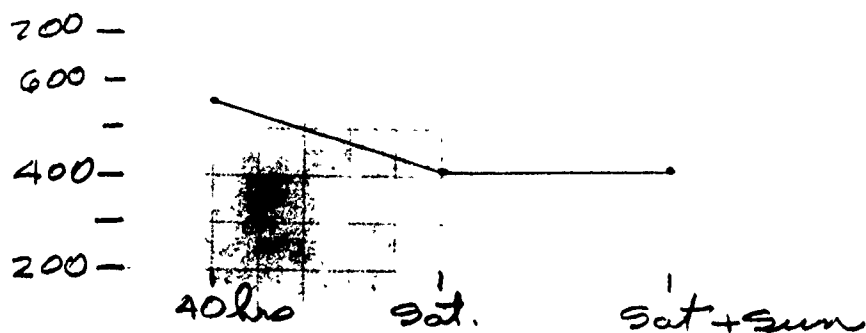
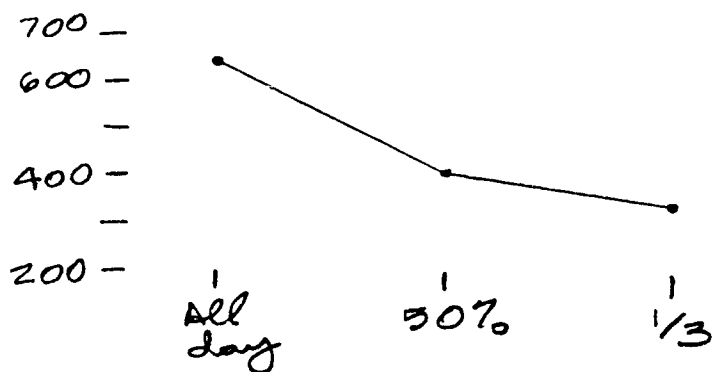
$$\text{Sat} + \text{Sun} = (557 + 368 + 326) / 3 = 417$$

Equip.

$$\text{Base} = (329 + 369 + 326) / 3 = 508$$

$$\text{Base} + = (536 + 368 + 402) / 3 = 435.3$$

$$\text{Base} ++ = (557 + 475 + 324) / 3 = 452.0$$



## Omega Transform

Run no.	Thruput	db
1	96.6	14.5350
2	97.3	15.5675
3	96.6	14.5350
4	99.3	21.5185
5	99.3	21.5185
6	98.6	18.4775
7	98.6	18.4775
8	99.3	21.5185
9	99.3	21.5185

## Manpower Dist.

All day shift

$$(14.5350 + 15.5675 + 14.5350) / 3 = 14.8792$$

$$50\% (21.5185 + 21.5185 + 18.4775) / 3 = 20.5048$$

$$1/3 (18.4775 + 21.5185 + 21.5185) / 3 = 20.5048$$

## Overtime

$$40 \text{ hrs } (14.5350 + 21.5185 + 18.4775) / 3 = 18.177$$

$$\text{Sat } (15.5675 + 21.5185 + 21.5185) / 3 = 19.5348$$

$$\text{Sat} + \text{Sun } (14.5350 + 18.4775 + 21.5185) / 3 = 18.177$$

## Equip.

$$\text{Base} = (14.5350 + 21.5185 + 21.5185) / 3 = 19.1907$$

$$\text{Base} + \text{Sat} = (15.5675 + 18.4775 + 18.4775) / 3 = 17.5075$$

$$\text{Base} + \text{Sun} = (14.5350 + 21.5185 + 21.5185) / 3 = 19.1907$$

$$\text{Average} = 18.6296$$

150A

FY90

25

db 21 -

20 -

18 -

16 -

14 -

12 -

1  
A22  
Long

1  
50%

1  
1/3

db 21 -  
20 -

18 -

16 -

14 -

12 -

1  
40hr.

1  
sat

1  
sat+sun

db 21 -  
20 -

18 -

16 -

14 -

12 -

1  
Base

1  
Base  
+

1  
Base  
+ +

173AFY90

(26)

Manpower Dist.

All day shift

$$(1016 + 521 + 467) / 3 = 668$$

50%

$$(432 + 365 + 350) / 3 = 382.3$$

$$\frac{1}{3} (386 + 317 + 318) / 3 = 340.3$$

Overtime

$$40 \text{ hr. } (1016 + 432 + 386) / 3 = 611.3$$

$$\text{Sat. } (521 + 365 + 317) / 3 = 401$$

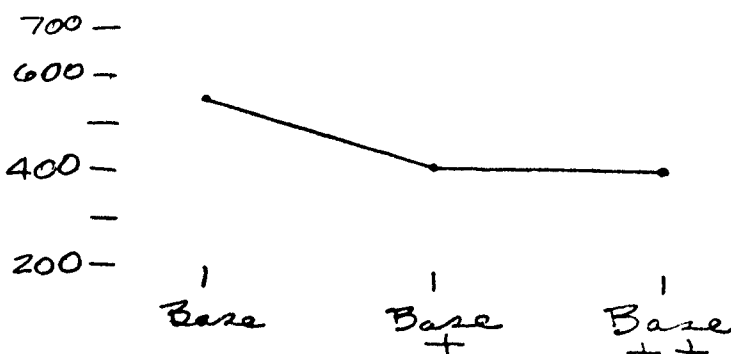
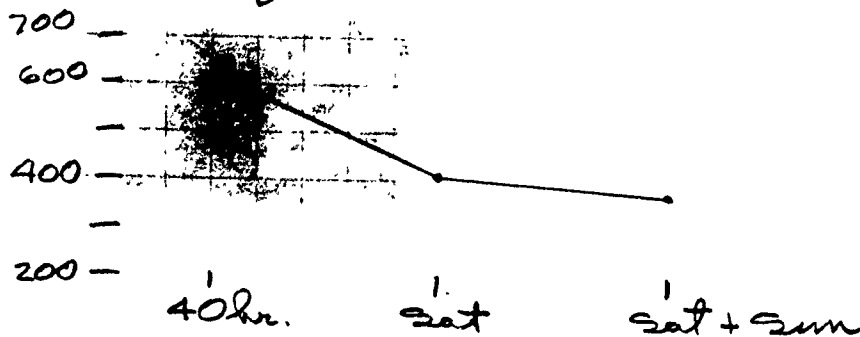
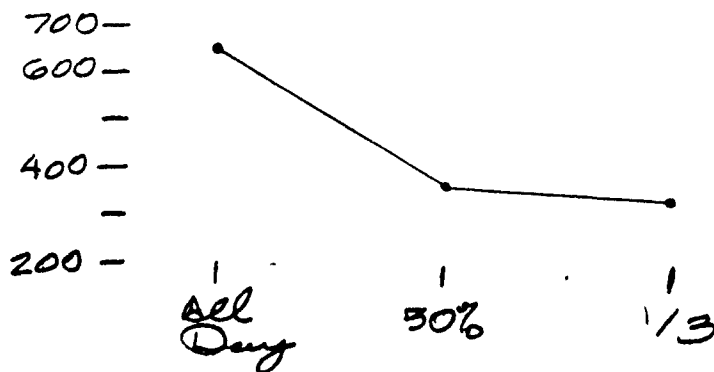
$$\text{Sat} + \text{Sun } (467 + 350 + 318) / 3 = 378.3$$

Equip.

$$\text{Base } (1016 + 365 + 318) / 3 = 566.3$$

$$\text{Base} + (521 + 350 + 386) / 3 = 419$$

$$\text{Base} + + (467 + 432 + 317) / 3 = 405.3$$



175AFY90

(27)

Omega Transform

Run No.	Throughput	db
1	54.3	.7488
2	89.4	9.2603
3	95.4	13.1679
4	96.0	13.8021
5	98.0	16.9020
6	98.7	18.8037
7	96.7	14.6691
8	98.7	18.8037
9	99.3	21.5185

Manpower Dist.All day

$$(.7488 + 9.2603 + 13.1679)/3 = 7.7257$$

50%

$$(13.8021 + 16.9020 + 18.8037)/3 = 16.5026$$

1/3

$$(14.6691 + 18.8037 + 21.5185)/3 = 18.3304$$

Overtime

$$40 \text{ hr. } (.7488 + 13.8021 + 14.6691)/3 = 9.74$$

$$\text{Sat } (9.2603 + 16.9020 + 18.8037)/3 = 14.9387$$

$$\text{Sat + Sun } (13.1679 + 18.8037 + 21.5185)/3 = 17.8300$$

Equip.

$$\text{Base } (.7488 + 16.9020 + 21.5185)/3 = 13.0564$$

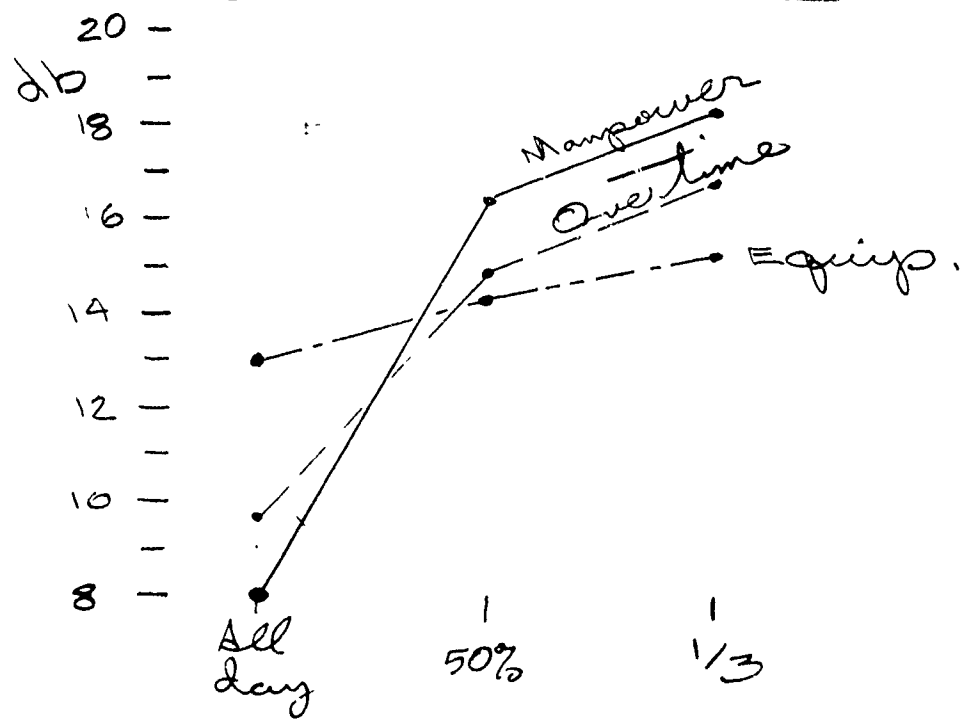
$$\text{Base + } (9.2603 + 18.8037 + 14.6691)/3 = 14.2444$$

$$\text{Base + + } (13.1679 + 13.8021 + 18.8037)/3 = 15.2579$$

$$\text{Average} = 14.1862$$

175 A

FT 90





249A

FY90

(29)

Manpower Dist.

All day

$$(2808 + 1474 + 1183) / 3 = 1821.7$$

50%

$$(903 + 920 + 729) / 3 = 850.7$$

$$1/3 (735 + 361 + 588) / 3 = 561.3$$

Overtime

$$40 \text{ hr } (2808 + 903 + 735) / 3 = 1482$$

$$\text{Sat } (1474 + 920 + 361) / 3 = 918.3$$

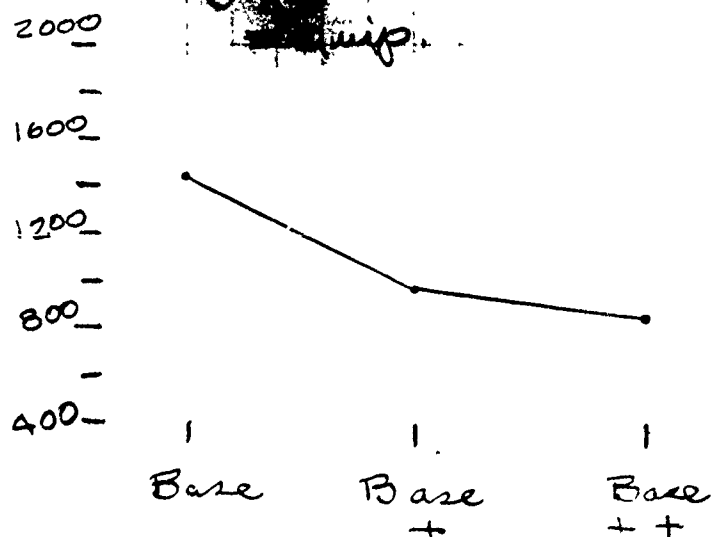
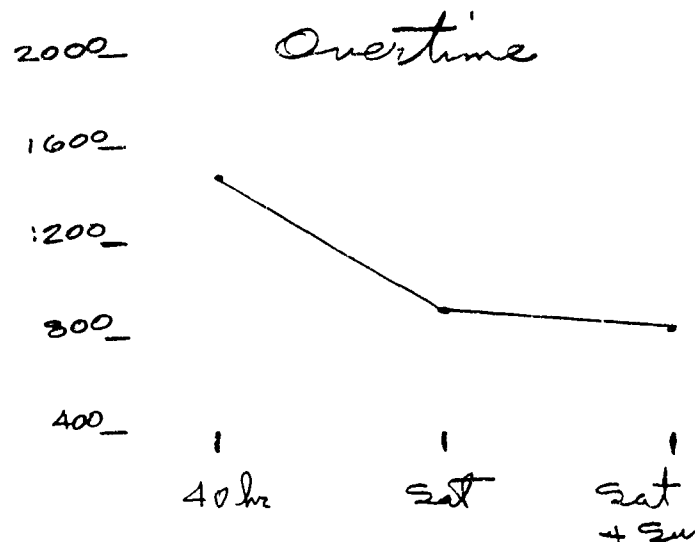
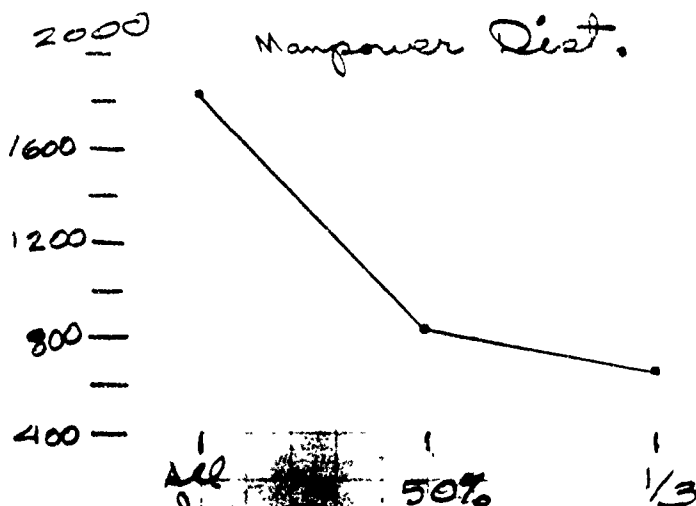
$$\text{Sat} + \text{Sun } (1183 + 729 + 588) / 3 = 833.3$$

Equip.

$$\text{Base } (2808 + 920 + 588) / 3 = 1438.7$$

$$\text{Base} + (1474 + 729 + 735) / 3 = 979.3$$

$$\text{Base} + + (1183 + 903 + 361) / 3 = 815.7$$



(1912) 926-2693

## Omega Transform

Run no.

Thruput

db

1	22	-5.4967
2	40.1	-1.7428
3	48.9	-.1911
4	63.7	2.4423
5	61.5	2.0341
6	78.6	5.6501
7	79.1	5.7803
8	97.2	15.4051
9	97.8	16.4792

Manpower Dist.

All day shift

$$(-5.4967 - 1.7428 - .1911) / 3 = -2.4769$$

50%

$$(2.4423 + 2.0341 + 5.6501) / 3 = 3.3755$$

$$1/3(5.7803 + 15.4051 + 16.4792) / 3 = 12.5549$$

overtime

$$40 \text{ hr } (-5.4967 + 2.4423 + 5.7803) / 3 = .9086$$

$$\text{sat } (-1.7428 + 2.0341 + 15.4051) / 3 = 15.6964$$

$$\text{sat} + \text{sun. } (-.1911 + 5.6501 + 16.4792) / 3 = 21.9382$$

Equip.

$$\text{Base } (-5.4967 + 2.0341 + 16.4792) / 3 = 4.5389$$

$$\text{Base } + (-1.7428 + 5.6501 + 5.7803) / 3 = 3.2292$$

$$\text{Base } ++ (15.4051 + 2.4423 - .1911) / 3 = \underline{17.6563}$$

Average 4.4845

250AFY90

31

Manpower Dist.

$$\text{All day } (2902 + 1456 + 1185)/3 = 1847.7$$

$$50\% (908 + 911 + 725)/3 = 848$$

$$1/3 (739 + 359 + 596)/3 = 564.7$$

Overtime

$$40\text{hr} \cdot (2902 + 908 + 739)/3 = 1516.3$$

$$\text{Sat} (1456 + 911 + 359)/3 = 908.7$$

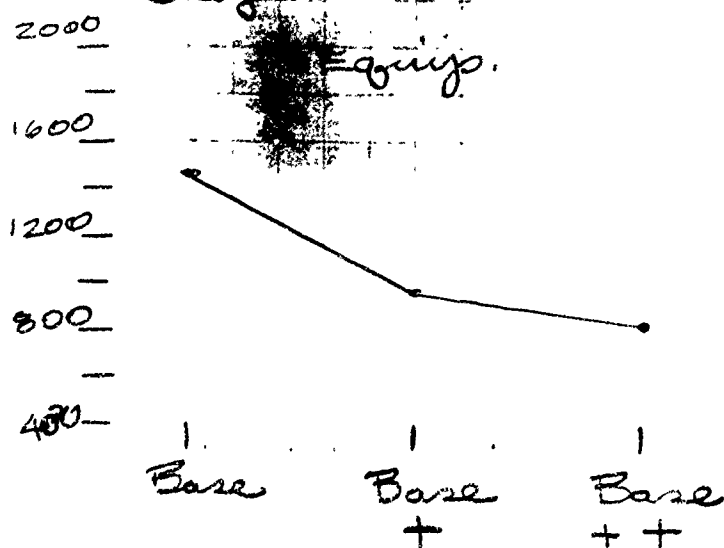
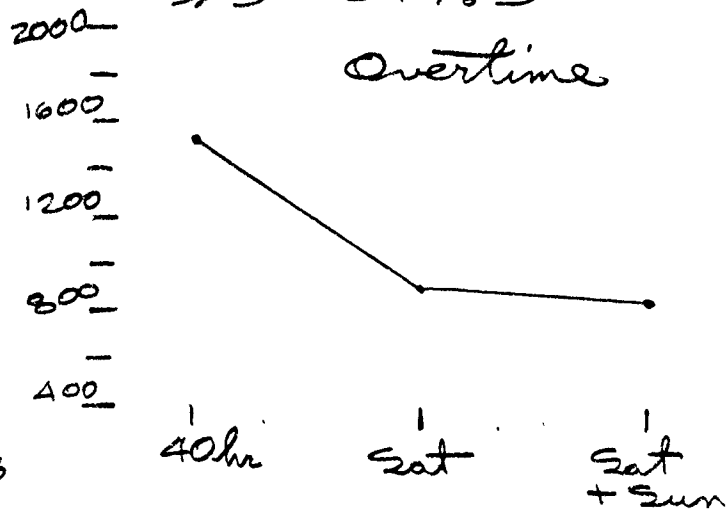
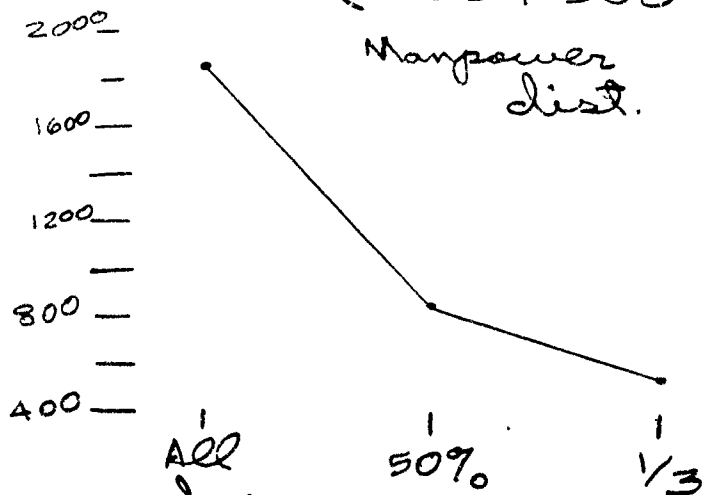
$$\text{Sat} + \text{Sun} (1185 + 725 + 596)/3 = 835.3$$

Equip.

$$\text{Base } (2902 + 911 + 596)/3 = 1469.7$$

$$\text{Base} + (1456 + 725 + 739)/3 = 973.3$$

$$\text{Base} ++ (1185 + 908 + 359)/3 = 817.3$$



250AFY 90

(32)

Omega

Run No.	Thruput	db
1	24.1	-4.9822
2	46.2	-.6614
3	56.9	1.2063
4	74.9	4.7480
5	72.8	4.2756
6	93.8	11.7981
7	91.8	10.4903
8	100 (99)	19.9564
9	100 (99)	19.9564

Manpower Dist.

All day shift

$$(-4.9822 + (-.6614) + 1.2063) / 3 = -1.4791$$

50%

$$(4.7480 + 4.2756 + 11.7981) / 3 = 6.9406$$

$$1/3 (10.4903 + 19.9564 + 19.9564) / 3 = 16.8010$$

Overtime

$$40hr (-4.9822 + 4.7480 + 10.4903) / 3 = 3.4187$$

$$Sat (-.6614 + 4.2756 + 19.9564) / 3 = 7.8569$$

$$Sat + Sun (1.2063 + 11.7981 + 19.9564) / 3 = 10.9869$$

Equip

$$Base (-4.9822 + 4.2756 + 19.9564) / 3 = 6.4166$$

$$Base + (-.6614 + 11.7981 + 10.4903) / 3 = 7.209$$

$$Base ++ (1.2063 + 4.7480 + 19.9564) / 3 = 8.6369$$

Average 7.4208

→ 97.2     $\frac{1}{3}$ , sat. ++  
100%     $\frac{1}{3}$ , sat    ++

~~177~~

137  
148

119

99.7    50, sat, Base ++

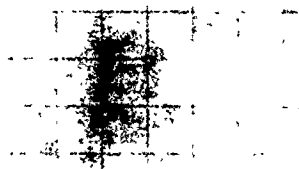
99    50, —,

321

168

103  
85

86.2%



SURGE INDUCTIONS	BASE SIMULATION	THROUGHPUT
224	150	67.0%
219	189	86.3%
277	51	18.4%
249	71	28.5%
279	116	41.6%
287	112	39.0%
358	161	45.0%
327	186	56.9%
178	71	39.9%
254	185	72.8%
261	82	31.4%
286	286	100.0%
0	0	N/A
31	30	96.8%
24	27	112.5%
18	19	105.6%
47	44	93.6%
0	0	N/A
297	27	9.1%
309	33	10.7%
=====	=====	=====
3925	1840	46.9%

DC/ALC MAPAD  
SHEETMETAL REPAIR SHOP  
JUNE 15, 1989

F190		BASE		SURGE		BASE	
END-ITEM	INDUCTIONS	SIMULATION	THROUGHPUT	END-ITEM	INDUCTIONS	SIMULATION	THROUGHPUT
15180A	0	0	N/A	15180A	0	0	N/A
15237A	6	0	N/A	15237A	0	0	N/A
15249A	187	40	22.02	15249A	297	27	9.12
15250A	195	47	24.12	15250A	309	33	10.72
15119A	176	65	38.22	15119A	277	51	18.42
15121A	161	74	46.02	15121A	249	71	28.52
15175A	131	82	54.32	15175A	261	82	31.42
15128A	175	111	63.42	15300A	287	112	39.02
15309A	184	117	63.52	15146A	178	71	39.92
15140A	196	72	67.92	15126A	279	116	41.62
15136A	212	164	77.42	15136A	358	161	45.02
15137A	201	180	89.62	15137A	327	186	56.92
15113A	134	124	92.52	15025A	224	150	67.02
15025A	136	131	96.32	15159A	254	185	72.82
15159A	146	141	96.62	15113A	219	189	86.32
15189A	19	19	100.02	15236A	47	46	55.62
15236A	23	23	106.02	15189A	31	30	96.82
15192A	12	12	100.02	15192A	18	18	100.82
15191A	16	16	100.02	15191A	24	24	100.32
15178A	177	177	100.02	15178A	286	286	100.02
2400	1595		66.52	3925	1836		46.82

78.3  
2242  
250  
862 { 119  
321

ABBATANA

OC/ALC MABPAB  
SHEETMETAL REPAIR SHOP 6/15/89

END-ITEM	SURGE INDUCTIONS	BASE SIMULATION	THROUGHPUT
15188A	0	0	N/A
15237A	0	0	N/A
15249A	297	27	9.1%
15250A	309	33	10.7%
15119A	277	51	18.4%
15321A	249	71	28.5%
15175A	261	82	31.4%
15300A	287	112	39.0%
15140A	178	71	39.9%
15126A	279	116	41.6%
15136A	358	161	45.0%
15137A	327	186	56.9%
15025A	224	150	67.0%
15150A	254	185	72.8%
15113A	219	189	86.3%
15236A	47	44	93.6%
15189A	31	30	96.8%
15192A	18	18	100.0%
15191A	24	24	100.0%
15178A	286	286	100.0%
=====	=====	=====	=====
	3925	1836	46.8%



OC/ALC MABPAB  
SHEETMETAL REPAIR SHOP

6/15/89

END-ITEM	SURGE INDUCTIONS	STD HRS	WORKLOAD W/AVG	%
15025A	224	163.49	36622	10.2%
15250A	309	110.99	34296	9.5%
15249A	297	110.53	32827	9.1%
15113A	219	147.72	32351	9.0%
15136A	358	79.18	28346	7.9%
15300A	287	98.31	28215	7.8%
15137A	327	79.18	25892	7.2%
15119A	277	89.76	24864	6.9%
15126A	279	88.73	24756	6.9%
15321A	249	90.24	22470	6.2%
15150A	254	85.15	21628	6.0%
15175A	261	73.86	19277	5.3%
15140A	178	51.65	9194	2.5%
15236A	47	121.58	5714	1.6%
15178A	286	18.97	5425	1.5%
15189A	31	120.73	3743	1.0%
15191A	24	118.72	2849	0.8%
15192A	18	118.72	2137	0.6%
15188A	0	120.73	0	0.0%
15237A	0	28.6	0	0.0%
=====				
			360606	100.0%

# SET WITH INDEPENDENT FIXTURES

①

PART NO. 15023A		WORKLOAD SURGE	
RUN NO.	FLOW TIME	NO. OF PARTS	INDUCTION
1 F B	1566	150	224
2 S B+	850	208	224
3 SS B++	802/	213	
4 F B++	520	225	
5 S B	308	222	
6 SS B+	300	222	
7 F B+	425	222	
8 S B++	347	222	
9 SS B	321	222	

PART NO. 15113A		WORKLOAD SURGE	
RUN NO.	FLOW TIME	NO. OF PARTS	INDUCTION
1	1328	189	219
2	738	218	219
3	736	219	
4	660	220	
5	485	218	
6	481	219	
7	534	219	
8	420	217	
9	407	218	

②

SET

RUN NO.	PART NO. 15119A	WORKLOAD SURGE	
		NO. OF PARTS	INDUCTION
1		51	277
2		143	277
3		200	
4		259	
5		213	
6		259	
7		276	
8		274	
9		279	

RUN NO.	PART NO. 15321A	WORKLOAD SURGE	
		NO. OF PARTS	INDUCTION
1		71	249
2		112	249
3		183	
4		234	
5		144	
6		256	
7		210	
8		248	
9		255	

SET

(3)

PART NO. 15126A			
RUN NO.	FLOW TIME	NO. OF PARTS	WORKLOAD SURGE INDUCTION
1	2417	116	279
2	1184	225	279
3	6158	282	
4	276	276	
5	236	277	
6	203	277	
7	258	275	
8	210	277	
9	187	277	

PART NO. 15300A			
RUN NO.	FLOW TIME	NO. OF PARTS	WORKLOAD SURGE INDUCTION
1	2377	112	287
2	1184	234	287
3	630	297	
4	285	288	
5	250	286	
6	210	286	
7	266	288	
8	217	286	
9	194	286	

SET

(4)

RUN NO.	PART NO. 15136A		WORKLOAD	SURGE
	FLOW TIME	NO. OF PARTS		
1	1746	161		358
2	689	355		358
3	328	356		
4	437	353		
5	344	354		
6	324	354		
7	431	358		
8	327	355		
9	308	355		

RUN NO.	PART NO. 15137A		WORKLOAD	SURGE
	FLOW TIME	NO. OF PARTS		
1	1538	186		327
2	658	328		327
3	368	328		
4	422	324		
5	315	324		
6	299	325		
7	407	330		
8	296	326		
9	284	326		

# INDEPENDENT

15

PART NO. 13140A			
RUN NO.	FLOW TIME	NO. OF PARTS	WORKLOAD SURGE INDUCTION
1	2771	71	178
2	457	173	178
3	400	173	
4	361	173	
5	335	174	
6	275	176	
7	296	174	
8	235	177	
9	246	176	

# INDEP.

PART NO. 15150A			
RUN NO.	FLOW TIME	NO. OF PARTS	WORKLOAD SURGE INDUCTION
1	1476	185	254
2	662	229	254
3	677	226	
4	527	231	
5	382	243	
6	375	243	
7	422	240	
8	346	245	
9	325	247	

INDEF.

⑥

PART NO. 15175A

RUN NO.	FLOW TIME	NO. OF PARTS	WORKLOAD	SURGE INDUCTION
1	2239	82		261
2	911	157		261
3	766	187		
4	512	217		
5	482	213		
6	405	232		
7	446	231		
8	329	248		
9	351	242		

INDEF.

PART NO. 15178A

RUN NO.	FLOW TIME	NO. OF PARTS	WORKLOAD	SURGE INDUCTION
1	738	286		286
2	388	289		286
3	387	291		
4	417	293		
5	313	288		
6	312	287		
7	351	290		
8	301	287		
9	299	287		

SET

(7)

PART NO. 15188A (?) NOTE POSSIBLE ERROR SURGE

FLOW TIME

NO. OF PARTS

INDUCTION  
0(?)

RUN NO.

1  
2  
3  
4  
5  
6  
7  
8  
9

PART NO. 15189A

FLOW TIME

WORKLOAD

NO. OF PARTS

SURGE

INDUCTION

RUN NO.

1  
2  
3  
4  
5  
6  
7  
8  
9

1640  
764  
771  
628  
538  
513  
584  
509  
428

30  
29  
30  
30  
29  
29  
29  
29  
29

31  
31



8

SET

RUN NO.	PART NO. 15101A		WORKLOAD SURGE	
	FLOW TIME	NO. OF PARTS	INDUCTION	
1	10083	27	24	
2	767	27	24	
3	786	27		
4	661	26		
5	507	26		
6	486	27		
7	583	26		
8	459	26		
9	409	26		

RUN NO.	PART NO. 15102A		WORKLOAD SURGE	
	FLOW TIME	NO. OF PARTS	INDUCTION	
1	1712	19	18	
2	802	19	18	
3	762	19		
4	692	19		
5	532	19		
6	508	19		
7	618	19		
8	510	19		
9	418	19		

60

PART NO. 15236A		WORKLOAD SURGE	
RUN NO.	FLOW TIME	NO. OF PARTS	INDUCTION
1	805	44	47
2	633	45	47
3	632	45	
4	624	44	
5	518	45	
6	518	45	
7	588	45	
8	498	45	
9	486	44	

PART NO. 15237A		WORKLOAD SURGE	
RUN NO.	FLOW TIME	NO. OF PARTS	INDUCTION
1			0(?)
2			
3			
4			
5			
6			
7			
8			
9			

(10)

SET

PART NO. 15243A		WORKLOAD SURGE	
RUN NO.	FLOW TIME	NO. OF PARTS	INDUCTION
1	5572	27	297
2	3093	58	297
3	2361	91	
4	1843	121	
5	1870	116	
6	1482	143	
7	1520	147	
8	740	283	
9	1231	173	

PART NO. 15250A		WORKLOAD SURGE	
RUN NO.	FLOW TIME	NO. OF PARTS	INDUCTION
1	5891	33	309
2	2956	79	309
3	2377	110	
4	1805	158	
5	1819	147	
6	1489	179	
7	1438	196	
8	711	316	
9	1235	213	

# SET WITH INDEPENDENT FIXTURES

①

PART NO. 15025A		WORKLOAD FY90	
RUN NO.	FLOW TIME	NO. OF PARTS	INDUCTION
1	824	131	136
2	567	136	136
3	560	135	136
4	476	135	136
5	375	134	136
6	321	133	136
7	394	133	136
8	324	134	136
9	319	134	136

PART NO. 15113A		WORKLOAD FY90	
RUN NO.	FLOW TIME	NO. OF PARTS	INDUCTION
1	995	124	92.5% 134
2	699	127	94.8% 134
3	695	127	94.8% 134
4	630	128	95.5% 134
5	473	129	96.3% 134
6	477	129	
7	515	130	97.0% 134
8	408	131	97.8% 134
9	406	130	97.0% 134

SET

PART NO. 15119A

WORKLOAD

RUN NO.	FLOW TIME	NO. OF PARTS	INDUCTION
1	1765	65	38.2
2	821	128	75.3
3	485	172	100%
4	376	168	28.8
5	331	166	27.6
6	288	167	28.2
7	305	166	27.6
8	235	171	100
9	245	171	100

PART NO. 15321A

WORKLOAD

RUN NO.	FLOW TIME	NO. OF PARTS	INDUCTION
1	1522	74	46%
2	812	130	80.7
3	478	163	100
4	322	163	100
5	328	161	100
6	283	164	100
7	311	166	100
8	233	164	100
9	242	164	100

SET

RUN NO.	PART NO. 15126A		WORKLOAD	
	FLOW	TIME	NO. OF PARTS	INDUCTION
1	1254		111	63.4%
2	268		120	97.1%
3	257		169	96.6%
4	262		170	97.1
5	203		120	125
6	200		170	125
7	221		170	125
8	188		170	125
9	185		170	97.1
10			170	125

RUN NO.	PART NO. 15300A		WORKLOAD	
	FLOW	TIME	NO. OF PARTS	INDUCTION
1	1220		117	63.6%
2	283		186	100%
3	267		186	184
4	268		186	184
5	208		189	184
6	203		189	184
7	234		186	184
8	190		189	184
9	187		189	184

# SET

PART NO. 15136A		WORKLOAD	
RUN NO.	FLOW TIME	NO. OF PARTS	INDUCTION
1	862	164	77.4
2	382	209	28.6
3	380	208	28.1
4	393	211	29.5
5	323	209	28.6
6	322	210	29.1
7	363	208	28.1
8	312	211	29.5
9	306	211	29.5

PART NO. 15137A		WORKLOAD	
RUN NO.	FLOW TIME	NO. OF PARTS	INDUCTION
1	790	180	89.6
2	351	199	99.0
3	351	199	99.0
4	363	200	99.5
5	296	201	100%
6	296	201	100%
7	314	201	100%
8	284	200	99.5
9	281	200	99.5

INDEP.

RUN NO.	PART NO. 15140A		WORKLOAD	
	FLOW TIME	NO. OF PARTS	INDUCTION	
1	1436	72	67.9	106
2	408	104	98.1	106
3	401	105	99.1	106
4	324	105	99.1	106
5	286	106	100%	106
6	274	106		106
7	288	106		106
8	232	107		106
9	239	107	100%	106

INDEP.

RUN NO.	PART NO. 15150A		WORKLOAD	
	FLOW TIME	NO. OF PARTS	INDUCTION	
1	829	141	96.6%	146
2	536	142	97.3	146
3	557	141	96.6%	146
4	475	145	99.3	146
5	369	145	99.3	146
6	368	144	98.6	146
7	402	144	98.6	146
8	324	145	99.3	146
9	326	145	99.3	146



INDEX.

PART NO. 15175A		WORKLOAD	
RUN NO.	FLOW TIME	NO. OF PARTS	INDUCTION
1	1016	82	151
2	521	135	151
3	467	144	151
4	432	145	151
5	365	148	151
6	350	149	151
7	386	146	151
8	317	149	151
9	318	150	151

INDEX.

PART NO. 15178A		WORKLOAD	
RUN NO.	FLOW TIME	NO. OF PARTS	INDUCTION
1	465	180	177
2	358	178	177
3	361	178	177
4	382	179	177
5	311	178	177
6	311	178	177
7	336	178	177
8	299	178	177
9	299	178	177

100%

PART NO. 15188A		WORKLOAD	
RUN NO.	FLOW TIME	NO. OF PARTS	INDUCTION
1	0	0	0
2	0	0	0
3	0	0	0
4	0	0	0
5	0	0	0
6	0	0	0
7	0	0	0
8	0	0	0
9	0	0	0

PART NO. 15189A		WORKLOAD	
RUN NO.	FLOW TIME	NO. OF PARTS	INDUCTION
1	992	19	19
2	730	19	19
3	731	19	19
4	653	18	19
5	498	20	19
6	502	20	19
7	528	20	19
8	450	20	19
9	434	20	19

100%

# SET

RUN NO.	PART NO. 15191A		WORKLOAD	
	FLOW TIME	NO. OF PARTS	INDUCTION	
1	967	17	16	
2	703	17	16	
3	732	17	16	
4	660	17	16	
5	429	17	16	
6	489	17	16	
7	531	17	16	
8	417	18	16	
9	403	18	16	

100%

RUN NO.	PART NO. 15192A		WORKLOAD	
	FLOW TIME	NO. OF PARTS	INDUCTION	
1	1062	13	12	
2	764	13	12	
3	755	12	12	
4	657	13	12	
5	520	13	12	
6	505	13	12	
7	532	13	12	
8	423	12	12	
9	414	12	12	

100%

PART NO. 15236A		WORKLOAD	
RUN NO.	FLOW TIME	NO. OF PARTS	INDUCTION
1	784	24	23
2	618	24	23
3	617	24	23
4	632	24	23
5	510	23	23
6	515	23	23
7	561	23	23
8	478	23	23
9	484	23	23

100%

PART NO. 15237A		WORKLOAD	
RUN NO.	FLOW TIME	NO. OF PARTS	INDUCTION
1	0	0	0
2	0	0	0
3	0	0	0
4	0	0	0
5	0	0	0
6	0	0	0
7	0	0	0
8	0	0	0
9	0	0	0

SET

RUN NO.	PART NO. 15249A		WORKLOAD		INDUCTION
	FLOW TIME	NO. OF PARTS			
1	2808	40	22%		182
2	1474	73	40.1		182
3	1183	89	48.9		182
4	903	116	63.7		182
5	920	112	61.5		182
6	729	143	78.6		182
7	735	144	79.1		182
8	361	177	97.2		182
9	588	178	97.8		182

RUN NO.	PART NO. 15250A		WORKLOAD		INDUCTION
	FLOW TIME	NO. OF PARTS			
1	2902	47	24.1		195
2	1456	90	46.2		195
3	1185	111	56.9		195
4	908	146	74.9		195
5	911	142	72.8		195
6	725	183	93.8		195
7	739	179	91.8		195
8	359	198	100%		195
9	596	198	100%		195

# OC-ALC/MABPAB SHEET METAL SHOP DRAFT RECOMMENDATIONS

RECOMMENDATION TYPE	POTENTIAL BENEFIT(S)
FOCUS STUDY	QUEUE REDUCTION BY IMPLEMENTING A MATERIAL CONTROL (PULL-APPROACH).
QUICK FIX	IMPROVE SPACE UTILIZATION BY CONSOLIDATING SUPERVISORS' OFFICES.
FOCUS STUDY	IMPLEMENT A "STAND-ALONE" SHEET METAL CONCEPT BY INCORPORATING BACKSHOP OPERATIONS.
QUICK FIX	REDUCTION OF TRAVEL TIME & DISTANCE ON END ITEMS BY IMPLEMENTING A MOBILE TAGGING UNIT.
FOCUS STUDY	INCREASE PAINTING CAPACITY BY DEVELOPING A VERTICAL-PAINTING PROCESS.
QUICK FIX	INCREASE STORAGE CAPACITY BY USING VERTICAL SPACE.
QUICK FIX	IMPROVE FLOW DAYS BY IMPLEMENTING COLOR TAGGING PARTS.
QUICK FIX	<p><u>TOOLING</u></p> <ul style="list-style-type: none"> <li>IMPROVE ACCURACY &amp; MINIMIZE TIME FOR WEIGHT &amp; BALANCE OPERATION ON FLIGHT CONTROL USING AN ELECTRONIC DEVICE.</li> </ul> <p>CO<sub>2</sub> SANDING VS. BRUSH SANDING.</p>

## #1 - PRIORITY

2.1 FOCUS STUDY - OPPORTUNITY TO PROVIDE THE OPTIMUM LAYOUT FOR  
AT OC SHEET METAL OPERATIONS IN  
BLDG. # 2101

2.1.1 DESCRIPTION OF CURRENT OPERATION  
OPERATIONS ARE NOW LOCATED IN BLDG #95 WHICH IS TO  
BE VACATED BY SEPT. '89. SHEET METAL REFURBISHING IS  
PERFORMED ON COWLING, FLAPS, FLIGHT CONTROLS, DOORS AND  
MISC. STRUCTURES.

2.1.2 OVERALL ASSESSMENT OF CURRENT OPERATION  
CURRENT OPERATIONS ARE CONGESTED AND THE  
FLOW OF PARTS DOES NOT CONFORM TO ANY TYPE OF  
SYSTEMATIC PROGRESSION.

2.1.2.1 CURRENT PROCESS PROBLEMS  
MATERIAL HANDLING - EXCESSIVE  
TOOLING LAYOUTS CAUSES OPERATION INTERFERENCES  
WORK STATION LAYOUTS - NOT EFFICIENT  
STAGING AREAS NOT IN LINE OF FLOW.  
AIR AND UTILITIES LOCATIONS - IN ADEQUATE

2.1.2.2 SHOP ORGANIZATION

TOTAL REORGANIZATION OF OFFICE SUPPORT, RECEIVING  
STORES, SHIPPING AND OPERATIONS

2.1.3 RATIONALE LEADING TO CHANGE  
OBSERVATIONS INDICATE POOR FLOW, CONGESTED  
AREAS, EXCESSIVE MATERIAL HANDLING THAT CAN  
BE RESOLVED WITH THE APPLICATION OF GENERAL  
I.E. PLANT LAYOUT PRINCIPLES

2.1.3.1 SUPPORTING DATA -PROFILES -MODEL -GENERAL KNOWLEDGE

2.1.4 DESCRIPTION OF NEW PROCESS

(SEE ATTACHMENT)

- PRODUCTIVITY IMPROVEMENTS

A 15 TO 20 % INCREASE IN PRODUCTIVITY IS ANTICIPATED

- RESOURCE UTILIZATION

MORE EFFICIENT FLOOR SPACE UTILIZATION BY REDUCING  
THE PRESENT 105,000 SQ.FT. TO 61,000 SQ.FT.

- FLEXIBILITY

CONSOLIDATED AREAS WILL ACCOMMODATE THE  
VARIATIONS IN PRODUCTION REQUIREMENTS

(BLDG #95 - RELOCATION)

#### 2.1.4 DESCRIPTION OF NEW PROCESS

AN ORGANIZED I E EFFORT WILL BE DIRECTED TOWARD THE ESTABLISHMENT OF THE OPTIMUM LAYOUT FOR SHEET METAL OPERATIONS IN BLDG. #2102 BY:

- DEVELOPING A DETAILED PRODUCT FLOW ANALYSIS
- PROVIDING COMPLETE OPERATIONAL ANALYSES FOR ALL TASKS
- RE-DESIGN OF WORK STATION LAYOUTS
- TOOLING EVALUATIONS & LAYOUTS
- PROPER LOCATIONS OF AIR & UTILITIES.
- DESIGNATED STORES AREAS
  - " IN PROCESS STORAGE AREAS
  - " STAGING AREAS
- EVALUATION & RECOMMENDATION OF MORE EFFICIENT MATERIAL HANDLING EQUIPMENT
- CONSOLIDATED RECEIVING AREA
- CONSOLIDATED SHIPPING AREA
- ESTABLISHMENT AND LOCATION OF AN INCOMING RECEIVING INSPECTION AREA FOR VENDOR PARTS



2.1.5. BENEFITS/TRADE-OFFS

- MORE EFFICIENT OPERATIONS AND A 40% REDUCTION  
IN REQUIRED FLOOR SPACE.
- DOLLAR SAVINGS

COST BENEFIT ANALYSIS

IT IS ANTICIPATED A 15% REDUCTION  
IN LABOR REQUIREMENTS WILL BE REALIZED.

- INTANGIBLE SAVINGS
  - MORE ORGANIZED OPERATIONS
  - BETTER SCHEDULING OVERVIEW
  - MORE ON TIME DELIVERIES

2.1.6 IMPLEMENTATION COST/SCHEDULE

I.E. REQUIREMENT IS 3000 MAN HOURS

NOTES IF IMPLEMENTATION ASSISTANCE IS REQUIRED AN ADDITIONAL  
1000 I.E. MAN HOURS WOULD BE REQUIRED.

- IMPACT

MINIMAL - BY IMPLEMENTING A SEQUENTIAL SCHEDULE  
OF SEGMENTED MOVES.

2.1.7 SAFETY IMPROVEMENTS

ELIMINATION OF MATERIAL HANDLING HAZARDS.

2.1.8 ENVIRONMENTAL HAZARDS/IMPROVEMENTS

ENVIRONMENTALLY CONTROLLED PAINT OPERATION

2.1.9 RELIABILITY / MAINTAINABILITY CHARACTERISTICS

NON/APPLICABLE

2.1.10 HUMAN FACTORS DESIGN CRITERIA

LESS FATIGUE THROUGH BETTER WORK PLACE  
LAYOUT & MORE EFFECTIVE MATERIAL HANDLING.

ALC	RCC	TYPE	POTENTIAL BENEFIT(S)
OC	MABPAB	FS	QUEUE REDUCTION by implementing A MATERIAL CONTROL (pull-approach)
OC	MABPAB	QF	Improve space utilization by consolidating SUPERVISORS OFFICE
OC	MABPAB	FS	Implement A "STAND-ALONE" SHEET METAL CONCEPT by incorporating back shop operations
OC	MABPAB	QF	REDUCTION OF TRAVEL TIME + DISTANCE ON END ITEMS by Implementing A MOBILE-TAGGING UNIT.
OC	MABPAB	FS	INCREASE PAINTING CAPABILITY by developing A VERTICAL-Painting process.
OC	MABPAB	QF	INCREASE STORAGE CAPACITY using VERTICAL space.
OC	MABPAB	QF	IMPROVE Flow Days by implementing Color Tagging Parts.
OC	MABPAB	QF	<p>"Tooling."</p> <ul style="list-style-type: none"> <li>• IMPROVE ACCURACY + minimize TIME OF weight + BALANCE operation on Flight Control using AN ELECTRONIC DEVICE.</li> <li>• CO<sub>2</sub> SANDING VS. BRUSH SANDING</li> </ul>

R Bofanes



MABFAB		FY 88 UNLOAD BY QUARTER *				
		MABFAB	LABOR			
		STD	# UNITS	1st	2nd	3rd
				4th		
				# UNITS	# UNITS	# UNITS
1	15073	163.5	56	55	54	75
2	15117	155.7	60	60	53	70
3	15120	92.4	25	25	22	66
4	15137	193.9	13	15	15	17
5	15173	193.9	13	13	15	17
6	15174	201.8	11	11	16	17
7	15180	110.5	13	18	23	20
8	15249	110.5	13	14	25	20
9	15192	201.8	6	6	10	17
10	15100	98.3	13	16	20	20
11	15136	79.2	13	17	23	22
12	15121	90.2	13	16	20	20
13	15176	88.7	13	16	20	20
14	15119	89.8	13	16	20	20
15	15137	79.2	13	16	22	21
16	15175	74.9	25	12	8	26
17	15179	24.0	36	50	59	75
18	15236	149.6	6	10	9	9
19	15140	58.7	1	0	4	40

\* IAW A-GO 19C-CAA-CA-MCE  
DATED 16 JUN 1988



DEPARTMENT OF THE AIR FORCE  
HEADQUARTERS AIR FORCE LOGISTICS COMMAND  
WRIGHT-PATTERSON AIR FORCE BASE, OHIO 45433 5001

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21 OCT 1988

REFLY TO  
ATTN OF MAQF

SUBJECT Surge Factors for Technology Insertion (TI) Program

TO Mr Dave Szukalski  
McDonnell Douglas Corp  
St Louis MO 63166-0516

1. The weapon systems surge factors to be used in the TI program are provided in attachment 1. For some weapon system subsystems you may need to contact the TI center representative to obtain a further surge factor breakdown.

2. If additional information is required, please contact myself or Trixie Brown at 513-257-7277.

*Doxie L. Cripe*  
DOXIE L. CRIPE  
Chief, Facilities & Equipment Div

1 Atch  
Surge Factors

cc: TI Working Group Members  
WPCC/PMRP (Don Peterson)

UNITED STATES AIR FORCE



SEPTEMBER 18, 1947

19 OCT 1988

	FY 89 SURGE %	FY90 SURGE %
MDS		
A-7D	37	99
A-7E	68	66
TOTAL	86	96
A-10A	39	24
B-1B	3	-5
B-52G	134	186
B-52H	128	-10
TOTAL	132	115
C-5A	656	695
C-5B	549	488
TOTAL	612	597
C-7	0	0
C-9A	-11	45
C-9C	0	0
TOTAL	-10	42
C-12A	0	0
C-12F	-96	124
C-12J	0	0
TOTAL	-82	104
C-18A	0	0
C-20A	0	0
C-20B	0	0
C-20C	0	0
TOTAL		0
C-21A	-96	69

page 1 of 6

C-22A	0	0
C-22B		0
TOTAL	0	0

C-23A	-100	218
-------	------	-----

C-47A	0	0
-------	---	---

C-130A	-61	-18
C-130B	218	187
C-130E	123	133
C-130H	146	209
TOTAL	93	159

C-131D	0	0
C-131E	0	0
TOTAL	0	0

C-135A	0	0
C-135B	0	0
C-135C	0	0
C-135E	0	0
TOTAL	0	0

C-137B	0	0
C-137C	0	0
TOTAL	0	0

C-140A	51	29
--------	----	----

C-141A	0	0
C-141B	249	247
TOTAL	248	246

E-3A		99
E-3B	122	122
E-3C	124	124
TOTAL	122	110

E-4B	0	0
F-5A		0
F-4C	-53	0
F-4D	45	-43
F-4E	84	60
F-4G	81	81
TOTAL	64	39
F-SE	0	0
F-SF	0	0
TOTAL	0	0
F-15A	89	63
F-15B	24	29
F-15C	61	62
F-15D	55	66
F-15E	0	69
TOTAL	65	61
F-16A	68	41
F-16B	20	31
F-16C	48	28
F-16D	56	22
TOTAL	55	35
F-111A	67	55
F-111D	66	65
F-111E	89	76
F-111F	86	80
TOTAL	78	71
AC-130A	202	237
AC-130B	231	257
AC-130U		0
TOTAL	220	238
CH-003E	17	0
CH-003A	162	0

page 3 of 6



EC-0188	0	0
FC-130E	250	241
EC-130H	320	244
TOTAL	290	245
EC-135A	37	0
EC-135C	1	0
EC-135E	0	0
EC-135G	56	0
EC-135H	225	225
EC-135J	159	159
EC-135K	147	104
EC-135L	46	0
EC-135P	225	225
EC-135Y	0	188
TOTAL	55	50
EF-111A	196	176
FB-111A	0	-61
HC-130H	150	162
HC-130N	125	116
HC-130P	119	110
TOTAL	123	119
HH-001H	-44	-15
HH-003E	48	72
HH-033B	0	0
HH-53C	0	0
KC-10A	-44	484
KC-135A	251	220
KC-135E	288	279

WC-135B	-7	-7
NKC-135A	0	0
NKC-135E	0	0
TOTAL	0	0

KL-135Q	408	400
KL-135R	234	277
TOTAL	268	265
LC-130H	23	-7
MC-130E	120	127
MC-130H	153	108
TOTAL	126	120
MH-053H	0	0
MH-053J	0	107
TOTAL	0	101
MH-606		69
NA-007E	0	0
NC-130H	0	0
OA 10A		16
OA-37B	81	52
OV-10A	113	117
TOTAL	77	117
RC-135S	44	44
RC-135U	38	38
RC-135V	44	44
RC-135W	74	74
RC-135X	0	0
TOTAL	50	50
RF-004C	114	114
UH-001N		-10
UH-060A	73	78
WC-130B	0	0
WC-130E	32	32
WC-130H	188	188
TOTAL	81	81

page 6 of 6

MODEL EXPERIMENTATION

## PROBLEM APPROACH

1. FLOW TIME IS THE QUALITY CHARACTERISTIC WE ARE TRYING TO IMPROVE (MINIMIZE).
2. BRAIN STORM FOR PHYSICAL FACTORS THAT EFFECT FLOW TIME. APPLY NO CONSTRAINTS-PREPARE LIST.
3. APPLY 1<sup>st</sup> BOUNDARY CONDITION. IS THE FACTOR TRIVIAL IN AN ENGINEERING SENSE? REDUCE LIST.
4. APPLY 2<sup>nd</sup> BOUNDARY CONDITION. IS THE FACTOR AVAILABLE IN THE SIMULATION? REDUCE LIST.
5. DIVIDE REMAINING FACTORS INTO CONTROL FACTORS AND NOISE FACTORS.
6. DISCUSS/IDENTIFY INTERACTIONS AND LEVELS FOR:  
A. CONTROL FACTORS  
B. NOISE FACTORS
7. DEFINE DEGREES OF FREEDOM AND REQUIRED LINEAR GRAPHS FOR:  
A. CONTROL FACTORS  
B. NOISE FACTORS
8. SELECT PROPER ORTHOGONAL ARRAY AND ASSIGN COLUMNS FOR:  
A. CONTROL FACTORS  
B. NOISE FACTORS
9. COORDINATE THE RESULTING TEST MATRIX WITH SOUTHWEST RESEARCH.

PROBLEM APPROACH (CONT.)

10. EXECUTE MODEL THROUGH THE TEST MATRIX.
11. INTERPRET RESULTS.
12. CONFIRM PREDICTIONS BY RUNNING MODEL WITH THE SELECTED VALUES.

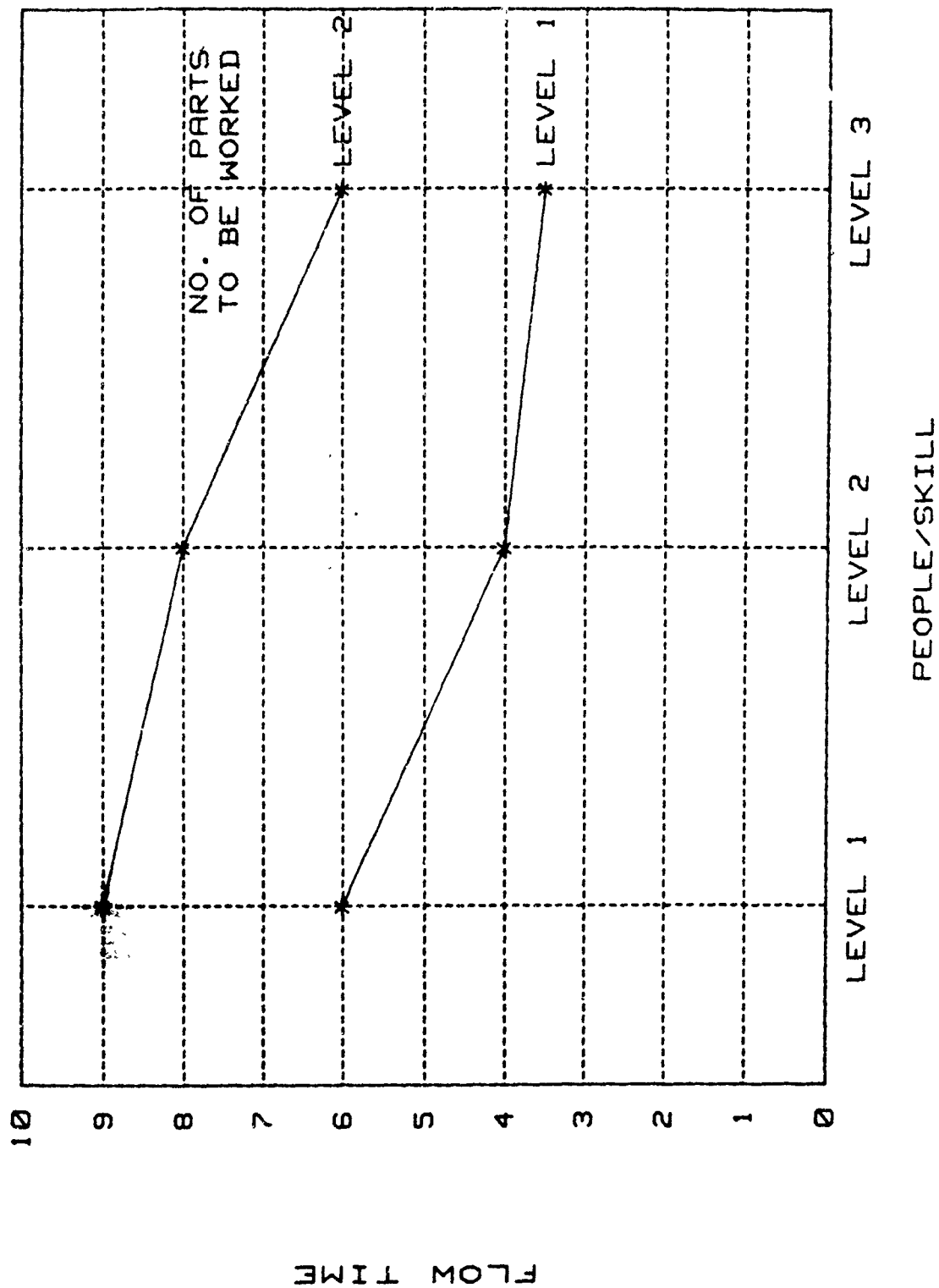


Run No.	People / Skill	Equipment	Flooding Stock	Calibration / Maintenance of Test Equipment	REC. / SELL TIME	NO. OF PARTS TO BE WORKED	1	2	1	2	SIGNAL TO NOISE RATIO (db)
1	1	1	1	1			1	2	1	2	
2	1	2	2	2			1	1	2	2	
3	1	3	3	3							
4	2	1	2	3							
5	2	2	3	1							
6	2	3	1	2							
7	3	1	3	2							
8	3	2	1	3							
9	3	3	2	1							

Run No.	People / Skill	Equipment	Flooting Stock	Calibration / Maintenance of Test Equipment	REC. / SELL TIME	NO. OF PARTS TO BE WORKED	1	2	1	2	SIGNAL TO NOISE RATIO (db)
1	1	1	1	1			1	2	1	2	
2	1	2	2	2			1	1	2	2	
3	1	3	3	3							
4	2	1	2	3							
5	2	2	3	1							
6	2	3	1	2							
7	3	1	3	2							
8	3	2	1	3							
9	3	3	2	1							



# MODEL EXAMPLE (CONT.)



R. B. B. B.

OC-ALC/MAB

TECHNOLOGY INSERTION

AND

COLLECTION PROCESS REVIEW

# MAB TECHNOLOGY INSERTION TEAM

## POINT OF CONTACT

EARL STAMPS

MABEFS

65267

## PLANNING

LARRY MULLINAX  
ROGER WADDELL

MABEFS  
MABEFS

65261  
65265

## PRODUCTION

JANIS WOOD  
TERRY BREWER  
IDA M. GRAVES  
DONNA MASON

MABPAB (-135)  
MABPAB (-135)  
MABPFF (B52)  
MABPFF (B52)

63595  
63595  
63860 ✓  
63860

## SCHEDULING

DARRELL TANNER  
PAT HANCOCK

MABSFS (B52)  
MABSFS

62969  
67235

## ENGINEERING

DON HRNCIR  
PHIL KUERNER

MABEE (FACILITIES)  
MABEP (TOOLING)

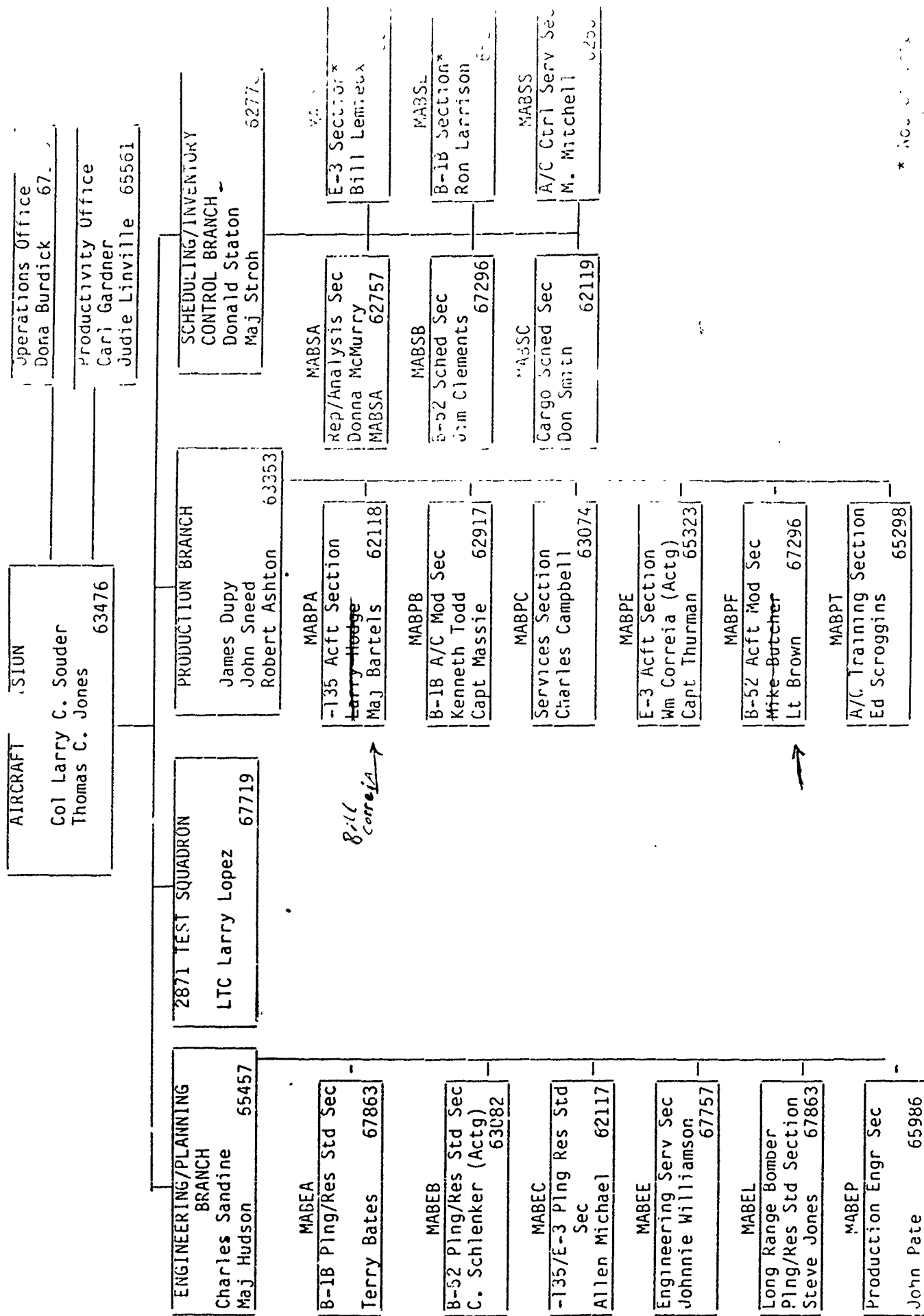
67757  
65986

## QUALITY

TED KAYES  
JACKIE LENDERMAN

MAQBF (-135)  
MAQBBA (B52)

62390  
67322



# Activity Checklist

MABPAB - EARL STAMPS (unit Chief)  
 SHEET METAL C-135  
 R. Bolanos / T. Hall

#	PRIORITY	Activity	D = Delegated for Action		
			Delegated to	Start Date	Due Date
1	100%	✓ ENVELOP SIZE/NO. SUFF.	R.B.	✓ 4/7	4/7
2	80%	✓ ITEM CHECK LIST	R.B.	✓ 4/7	4/14
3	80%	✓ ITEM SUMMARY	R.B.	✓ 4/7	4/14
4	80%	✓ RCC. CHECK LIST	R.B.	✓ 4/7	4/14
5	95%	✓ OPERATION - MATCH W/ ELEM. PROCESS - EQUIPMENT - TSP TIMES - MAND. FLOW TIME (WEEK) - SKILL LEVEL (MIN. REQ.)	T.H.	✓ 4/3	4/12
6	100%	✓ MANPOWER - RTY - HES - AIT. SKILL CODE	E.S./T.D.	✓ 4/7	4/12
7	100%	✓ WORKLOAD - FLOWING STOCK - ACT. PRESS. BY AIR - MAX. W.I.P. - STD. HRS	L.M.	✓ 4/7	4/12
8	90%	✓ EQUIPMENT - Press. Paint. - BOARD - IN - LAISSES BY OTHER - ALTERNATIVE	L.M.	✓ 4/6	4/13
9	100%	✓ DISASSEMBLE/ASSEMBLE	R.B.	✓ 4/7	4/10
10	100%	✓ PARALLEL	R.B.	✓ 4/7	4/10
11	16%	✓ IN DATES	E.S.	✓ 4/7	6/7
12	16%	✓ OUT DATES	E.S.	✓ 4/7	6/7
13	✓	✓ IE ASSESSMENT	R.B./T.H.	4/3	ON GOING

- TEAM EFFORT
  - CLIENT OWNERSHIP
  - ROAD MAP
  - CLEAR COMMUNICATION
- THE TEAM:
- EARL STAMPS (ALC/Plng Unit. Chief)
  - LARRY MULLINAX (ALC/Sr. Plng Eng.)
  - JIM DOTSON (ALC/Plng Eng.)
  - TIM HALL (MDMSC/CPI)
  - RICARDO BOLANOS (MDMSC/PROJ. LEADER)

**1989 Project Overview-Day**  
**MABFAB - EARL STAMPS (PUNG UNIT Chief)**

R. Bolanos / T. Hall

Week	M	T	W	T	F	S	S
22				1	2	3	4
23		5	6	7	8	9	10 11
24		12	13	14	15	16	17 18
25		19	20	21	22	23	24 25
26		26	27	28	29	30	31

COMPLETED ON SCHEDULE

October	Week	M	T	W	T	F	S	S
30				2	3	4	5	6
31				9	10	11	12	13
41				16	17	18	19	20
42				23	24	25	26	27
43				30	31			
44								

July							August							September							October						
Week 24	Week 25	Week 26	Week 27	Week 28	Week 29	Week 30	Week 31	Week 32	Week 33	Week 34	Week 35	Week 36	Week 37	Week 38	Week 39	Week 40	Week 41	Week 42	Week 43								
1 2 3 4 5 6 7 8 9 10 11 12 13 14 15 16 17 18 19 20 21 22 23 24 25 26 27 28 29 30 31	1 2 3 4 5 6 7 8 9 10 11 12 13 14 15 16 17 18 19 20 21 22 23 24 25 26 27 28 29 30 31	1 2 3 4 5 6 7 8 9 10 11 12 13 14 15 16 17 18 19 20 21 22 23 24 25 26 27 28 29 30 31	1 2 3 4 5 6 7 8 9 10 11 12 13 14 15 16 17 18 19 20 21 22 23 24 25 26 27 28 29 30 31	1 2 3 4 5 6 7 8 9 10 11 12 13 14 15 16 17 18 19 20 21 22 23 24 25 26 27 28 29 30 31	1 2 3 4 5 6 7 8 9 10 11 12 13 14 15 16 17 18 19 20 21 22 23 24 25 26 27 28 29 30 31	1 2 3 4 5 6 7 8 9 10 11 12 13 14 15 16 17 18 19 20 21 22 23 24 25 26 27 28 29 30 31	1 2 3 4 5 6 7 8 9 10 11 12 13 14 15 16 17 18 19 20 21 22 23 24 25 26 27 28 29 30 31	1 2 3 4 5 6 7 8 9 10 11 12 13 14 15 16 17 18 19 20 21 22 23 24 25 26 27 28 29 30 31	1 2 3 4 5 6 7 8 9 10 11 12 13 14 15 16 17 18 19 20 21 22 23 24 25 26 27 28 29 30 31	1 2 3 4 5 6 7 8 9 10 11 12 13 14 15 16 17 18 19 20 21 22 23 24 25 26 27 28 29 30 31	1 2 3 4 5 6 7 8 9 10 11 12 13 14 15 16 17 18 19 20 21 22 23 24 25 26 27 28 29 30 31	1 2 3 4 5 6 7 8 9 10 11 12 13 14 15 16 17 18 19 20 21 22 23 24 25 26 27 28 29 30 31	1 2 3 4 5 6 7 8 9 10 11 12 13 14 15 16 17 18 19 20 21 22 23 24 25 26 27 28 29 30 31	1 2 3 4 5 6 7 8 9 10 11 12 13 14 15 16 17 18 19 20 21 22 23 24 25 26 27 28 29 30 31	1 2 3 4 5 6 7 8 9 10 11 12 13 14 15 16 17 18 19 20 21 22 23 24 25 26 27 28 29 30 31	1 2 3 4 5 6 7 8 9 10 11 12 13 14 15 16 17 18 19 20 21 22 23 24 25 26 27 28 29 30 31	1 2 3 4 5 6 7 8 9 10 11 12 13 14 15 16 17 18 19 20 21 22 23 24 25 26 27 28 29 30 31	1 2 3 4 5 6 7 8 9 10 11 12 13 14 15 16 17 18 19 20 21 22 23 24 25 26 27 28 29 30 31									

COMPLETED ON SCHEDULE

22

December		November							October														
Week	M	T	W	T	F	S	S	Week	M	T	W	T	F	S	S	Week	M	T	W	T	F	S	S
10	9	Columbus Day / Yom Kippur						44	1	2	3	4				1	28						
10	24	United Nations Day						45	6	7	8	9	10	11	12	2	29						
10	31	Halloween						46	13	14	15	16	17	18	19	3	30						
11	7	Electron Day						47	20	21	22	23	24	25	26	4	31						
11	11	Vietnam Day						48	27	28	29	30				5							
11	23	Thanksgiving Day						49								6							

December		November							October														
Week	M	T	W	T	F	S	S	Week	M	T	W	T	F	S	S	Week	M	T	W	T	F	S	S
10	9	Columbus Day / Yom Kippur						44	1	2	3	4				1	28						
10	24	United Nations Day						45	6	7	8	9	10	11	12	2	29						
10	31	Halloween						46	13	14	15	16	17	18	19	3	30						
11	7	Electron Day						47	20	21	22	23	24	25	26	4	31						
11	11	Vietnam Day						48	27	28	29	30				5							
11	23	Thanksgiving Day						49								6							



OC PAB

Activity  
Checklist:

#	Date % Comp	Priority A B C D OK	Activity	D = Delegated for Action		
				Delegated to	Start Date	Due Date
1	100%	✓	ENVELOP SIZE/NO. CUFF.	R.B.	✓ 4/7	4/7
2		✓	ITEM CHECK LIST	R.B.	✓ 4/7	4/14
3		✓	ITEM SUMMARY	R.B.	✓ 4/7	4/14
4		✓	RCC CHECK LIST	R.B.	✓ 4/7	4/14
5	80%	✓	OPERATION - MATCH w/Flow Process - Equipment - TSP Times - MAND. Flow Time (hrs) - Skill Level (min, Req)	T.H.	✓ 4/3	4/12
6	50%	✓	MANPOWER - Qty - Hrs - Alt. Skill Core	E.S./T.D.	✓ 4/7	4/12
7	30%	✓	WORKLOAD - Floating Stock - Act. Prod by Air - Max WIP - Std. Hrs	L.M.	✓ 4/7	4/12
8	15%	✓	EQUIPMENT - Prev. Maint - Breakdown - % used by Other - Alternative	L.M.	✓ 4/6	4/13
9	50%	✓	DISASSEMBLE/ASSEMBLE	R.B.	✓ 4/7	4/10
10	50%	✓	PARALLEL	R.B.	✓ 4/7	4/10
11		✓	IN DATES	E.S.	✓ 4/7	6/7
12		✓	OUT DATES	E.S.	✓ 4/7	6/7
13			IE ASSESSMENT	R.B./T.H.	4/3	ON GOING

EARL'S Wish List.  
DECREASE - Flow Time  
- SPACE Req.  
- Labor Hrs.  
IMPROVE Ctl/ORG. STRUCT.  
INCREASE OUTPUT (EFF)

Daily Plan  
Week 15 103/262  
Thursdays  
13  
April 1989

March	Week	MTWTFSS	April	Week	MTWTFSS	May	Week	MTWTFSS
1	1	2 3 4 5	12	1	2 3 4 5	18	1	2 3 4 5 6 7
6	7	8 9 10 11 12	14	3	4 5 6 7 8 9	19	8	9 10 11 12 13 14
13	14	15 16 17 18 19	16	10	11 12 13 14 15 16	26	15	16 17 18 19 20 21
20	21	22 23 24 25 26 27	17	11	12 13 14 15 16 17	27	16	17 18 19 20 21 22
27	28	29 30 31	18	12	13 14 15 16 17 18	28	17	18 19 20 21 22 23

①	Schedule	OK	Contact	OK
8:	MODEL PRESENTATION			
9:	TO AB WORK CENTER TEAM			
10:	TOUR MABPAB Bldg 95			
11:	TOUR MABPFF Bldg 2121			
12:	TOUR NEW Bldg FOR MABPAB			
1:				
2:	DIVISION MAB Tom Jones BRANCH MABE Charles Sandhu			
3:				
4:				
5:				

OC MABPAB

# Activities Checklist

EARLY WISH LIST.

DECREASE - Flow Time  
- Space Req.  
- Labor Hr.

IMPROVE Ctl/deg. STRE.

INCREASE OUTPUT (EFF)

D = Delegated for Action						
Date	Priority	Activity	Delegated to	Start Date	Due Date	
1	100%	ENVELOP SIZE/NO. C.V. EF.	R.B.	4/7	4/7	
2		ITEM CHECK LIST	R.B.	4/7	4/14	
3		ITEM SUMMARY	R.B.	4/7	4/14	
4		RCC CHECK LIST	R.B.	4/7	4/14	
5	80%	OPERATION - MATCH w/ Flow Process - Equipment - TSP Times - MAND. Flow Time (hrs) - SKILL LEVEL (Min. Req.)	T.H.	4/3	4/12	
6	50%	MANPOWER - QTY - HRS - Alt. Skill Code	E.S./T.D.	4/7	4/12	
7	30%	WORKLOAD - Flow Time - Act. Peop. by Qtr - Max WIP - STD HRS	L.M.	4/7	4/12	
8	15%	EQUIPMENT - Prev. Maint - Breakdown - Used by Other - Alternative	L.M.	4/6	4/13	
9	50%	DISASSEMBLE/ASSEMBLE	R.B.	4/7	4/10	
10	50%	PARALLEL	R.B.	4/7	4/10	
11		IN DATES	E.S.	4/7	6/7	
12		OUT DATES	E.S.	4/7	6/7	
13		IE ASSESSMENT	R.B./T.H.	4/3	ON GOING	

Thursday  
13  
April 1989

## Daily Plan

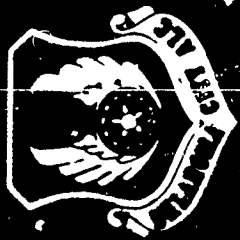
Week 15 103/262						
March	Week	MTWTFSS	April	Week	MTWTFSS	May
1	1	1 2 3 4	1	1	1 2 3 4 5 6	1
2	2	6 7 8 9 10 11 12	2	2	3 4 5 6 7 8 9	2
3	3	13 14 15 16 17 18 19	3	3	10 11 12 13 14 15 16	3
4	4	20 21 22 23 24 25 26	4	4	17 18 19 20 21 22 23	4
5	5	27 28 29 30 31	5	5	24 25 26 27 28 29 30	5

Week 15 103/262

Schedule		Contact	
OK		OK	
8:	MODEL PRESENTATION TO AB WORK CENTER TEAM		
9:	TOUR MABPAB Bldg 9S		
10:	TOUR MABPFF Bldg 2/24		
11:	TOUR NEW Bldg for MABPAB		
12:			
1:			
2:	DIVISION MAB Tom Jones BRANCH MABE CHARLIE SQUAD		
3:			
4:			
5:			



**DIRECTORATE OF MAINTENANCE**  
**RELOCATION OF**  
**BUILDING 95 SHEET METAL**



## RELOCATION OF B95 SHEET METAL

### BACKGROUND

- " SHEET METAL RELOCATED AFTER NOV 84 FIRE
- " DS WAREHOUSES AT 98% SATURATION
- " CC INSTRUCTED MA TO VACATE B95 BY SEPT 89
- " MA DIRECTED ESTABLISHMENT OF FACILITY  
PLANNING GROUP



## FACILITY PLANNING GROUP

### PLAN B - RELOCATION OF B95 SHEET METAL

Ø B3001 HIGHBAY, POST 52 THRU 74

- BLADE AREA MUST VACATE BY JUN 89
- ENGINE LINE MOVE BACK NORTH OF COL 74

*MA THREW THIS  
PLAN OUT.*



**MA RELOCATION OF  
BLDG 95 SHEET METAL**

**PROPOSAL: A**

**Ø LOCATION**

- BLDG 2101

**Ø PLAN**

- RELOCATE MA ORGANIZATIONS FROM B2101 (MAD, MAE, MAT) TO SEPARATE SMALLER LOCATIONS
- RELOCATE (MA) GROUND SPACE EQUIPMENT CONTRACTOR
- RELOCATE BLDG 95 SHEET METAL INTO ~~BLDG 2101~~ SF OF BLDG 2101



**MA RELOCATION OF  
BLDG 95 SHEET METAL**

**PLAN:**

**RELOCATE MA ORGANIZATIONS FROM B2101**

- MA GAINS ASSIGNMENT OF BLDG 3771 - 15,000 SF
- MA RELOCATES MAE TO BLDG 3771 - 15,000 SF
- MAD PLANT MANAGEMENT RELOCATES FABRICATION/WELDING SHOP TO BLDG 3773 - 18,000 SF
- MAE PROPULSION DIVISION RELOCATES ENG. RECLAMATION TO BLDG 3703 & 3001 - 21,000 SF TOTAL
- MAT ACCESSORIES DIVISION RELOCATES FOUNDRY TO BLDG 2129 - 2,700 SF

**OR 3001**



MA RELOCATION OF  
BLDG 95 SHEET METAL  
CONTINUED

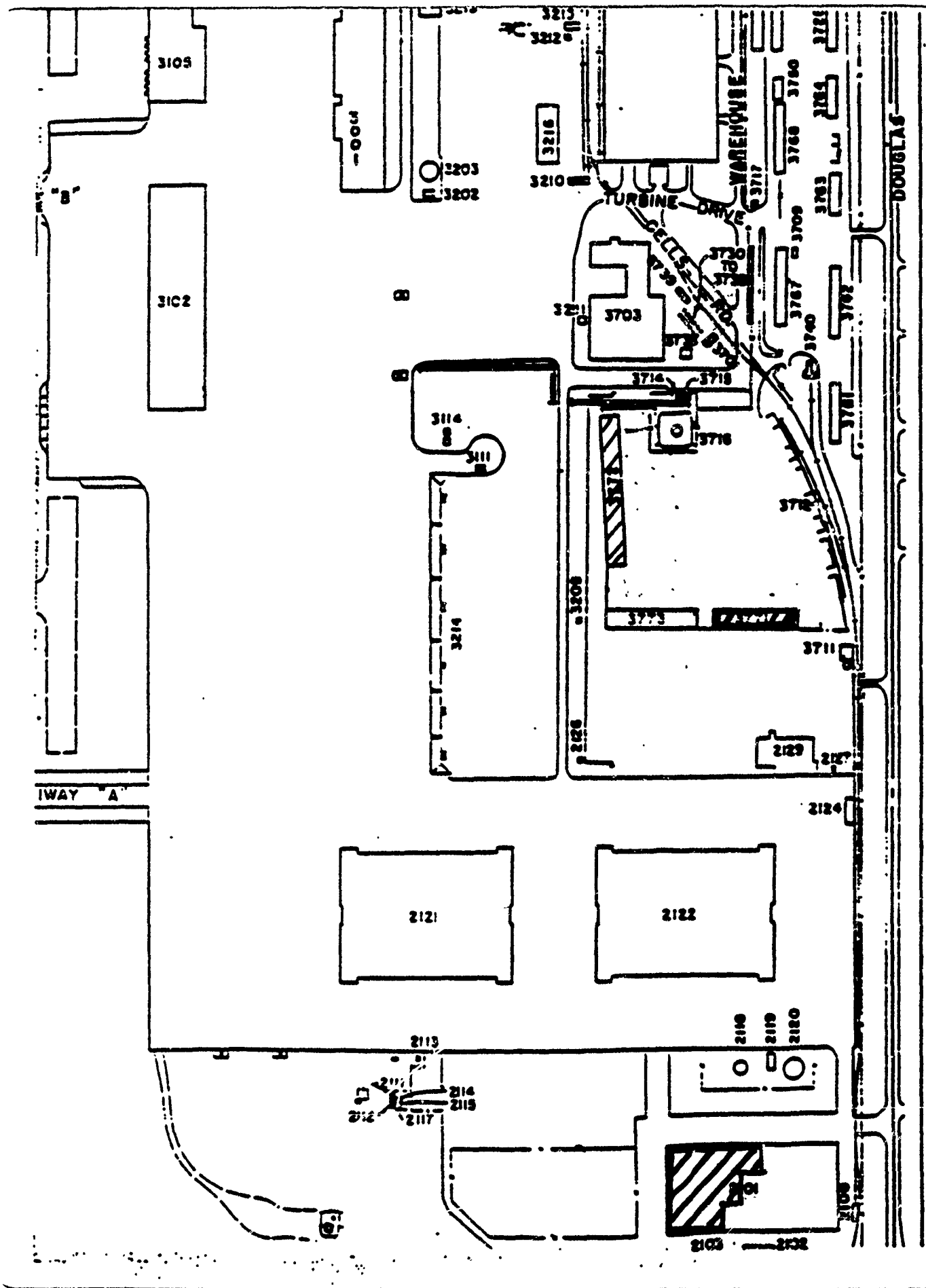
PLAN:

8

~~US AIR FORCE~~ INTO  
VACATED SPACE ~~BLDG 95~~ SEP 89 EST.  
COMPLETION DATE

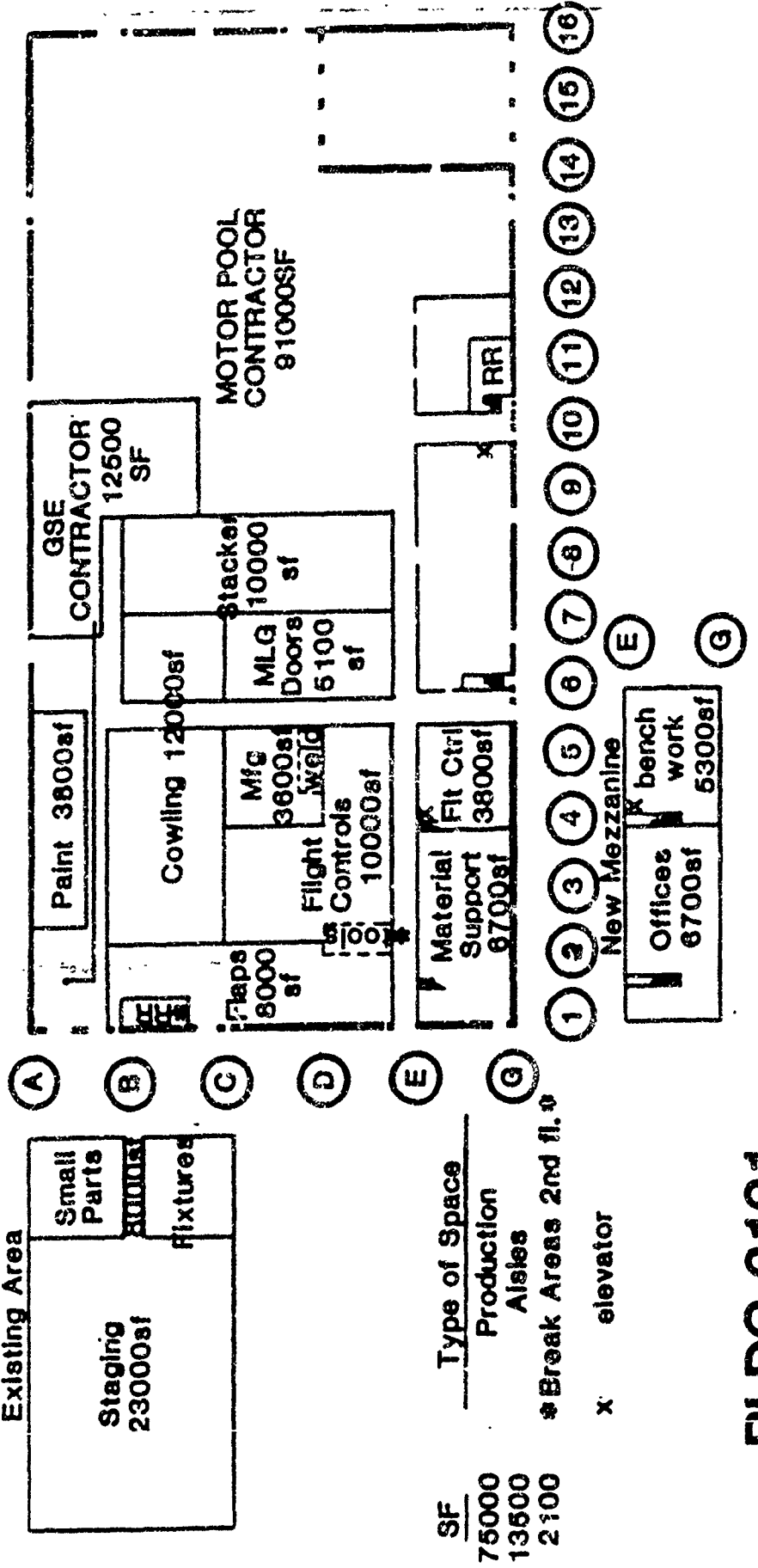
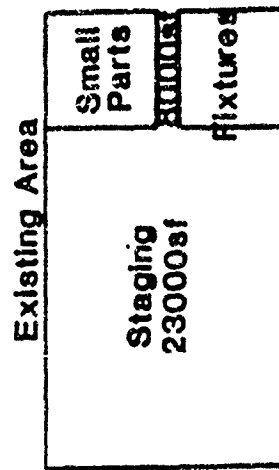
- SELF-HELP AND CONTRACT RELOCATION  
FROM BLDG 95





# PROPOSED AIRCRAFT SHEETMETAL

New Shed  
Supply Pickup 3000sf



BLDG 2101

SUBJECT UNDER REVIEW		FY89												DATE REVIEWED		REPORTING AGENCY & PROJECT MONITOR											
SHEET METAL RELOCATION																											
NO	MILESTONE ACTIVITIES AND EVENTS	PCT PROGRAM ACCOMPLISHED																									
		FCST	ACT	Q	N	D	J	F	M	A	M	J	J	A	S												
1	MA APPROVAL OF B2101 PLAN AND IMPLEMENTATION (OPR: MA)																										
2	SUBMIT 600P MAT (OPR: MAT)																										
3	SUBMIT 600P MAE (OPR: MAE)																										
4	SUBMIT 600P MAD (OPR: MAD)																										
5	REVIEW DRAWINGS FROM DIVISION(S), ORDER MATERIALS (OPR: MAD)																										
6	MAT SITE PREP OF B3001 (OPR: MAT)																										
7	MAE SITE PREP OF B3767 (OPR: MAE)																										
8	MAD SITE PREP OF B3771/B3773 (OPR: MAD)																										
9	MAT VACATE B2101 TO B2129 (OPR: MAT)																										
10	MAE VACATE B2101 TO B3767 (OPR: MAE)																										
11	MAD VACATE B2101 TO B3771/B3773																										
12	SUBMIT B2101 DESIGN & 600P SERVICE ORDER (OPR: MAB)																										

LEGEND: (Colors indicated for attention attraction)

ACTIVITY PLAN

EVENT TARGET

1/ (Ref 2) TARGET SLIPPAGES

PERCENTAGE OF ACTIVITY PLAN COMPLETED AS OF DATE

DATE COMPLETED

6813

**SUBJECT UNDER REVIEW**

DATE REVIEWED

REPORTING AGENCY &amp; PROJECT MONITORING

NO	MILESTONE ACTIVITIES AND EVENTS	PCT PROGRAM ACCOMPLISHED	
		FCST	ACT
13	REVIEW DRAWINGS FROM DIVISION FOR B2101 (OPR: MAD)		
14	WRITE SPECIFICATIONS & STATEMENT OF WORK (OPR: MAD)		
15	CONTRACT SOLICITATION & AWARD (OPR: MAD)		
16	PREP SITE AT B2101 (OPR: MAD/CONTRACTOR)		
17	RELOCATE FROM B95 TO B2101 (OPR: MAD)		

**LEGEND:** (Colors indicated for attention attraction) (Numbers if present are added at the end of each column TABLE TOPIC, 2001)

IN

1.

1

100

1

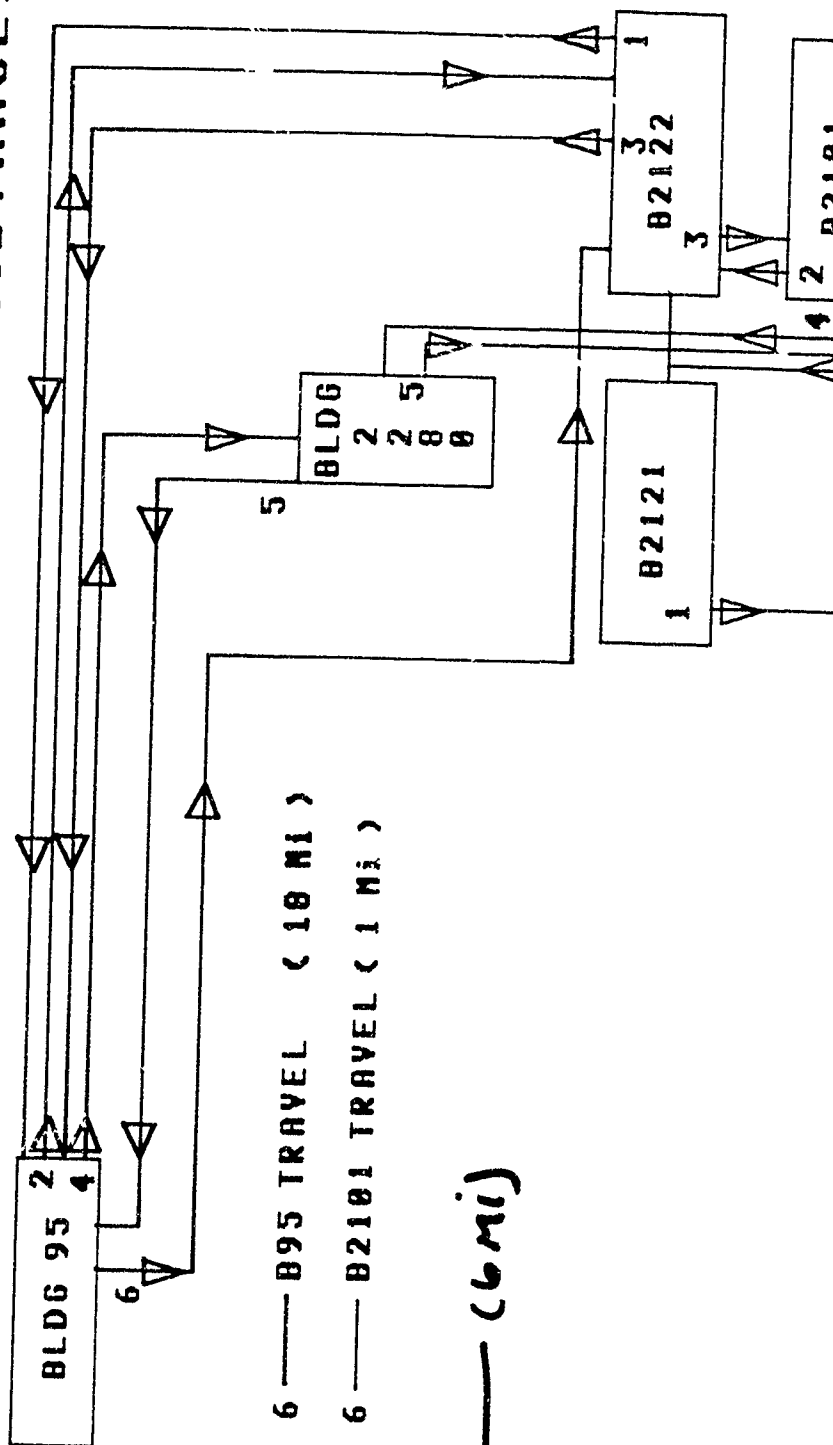
7. DEBENTURES OF 1936

*Dolls staff*  
67978



MA RELOCATION OF  
BLDG 95 SHEET METAL

LOCATION: B2101 VRS B95 TRAVEL DISTANCES



3-31-87 Engineering Notes - Tim Hall - Industrial Eng

Started on site at PE - RHC. Engineers on site today were: Blake Hixson, Henry Johnson, Ricardo Belones, Sadie McFarland and myself. We met with Bob Conover, planning chief at MHT, and Earl Stamps, planning chief at ACHB, and Gene Listerman, our AT contacts. A meeting was set up for 2 o'clock Monday afternoon with the same attendees plus some people from scheduling and planning.

We were assigned an office conference room ('The War Room') adjacent to Bob Conover's office. Since the rest of the team had spent 4 weeks in St. Louis learning everything they could about the project in another way and this was our first day back since December for us, I had some reading material to review for the rest of the day. Namely, the 'Case Notice' and the 'Case Notice Response' letters were reviewed by myself.

4-3-87 Monday

Chuck Gonzalez was started a two week assignment here today. Ricardo Belones, Chuck Gonzalez and myself spent most of the morning meeting with Earl Stamps, planning chief for ACHB and Henry Johnson, attorney planner. We discussed how we were planning to approach the ACHB's counter action efforts. Belones notified them that full so there had been a meeting and friendship study stated the offer had been agreed to. The ACHB's were requested to be completed and the assignment was completed.

②

(

Wed - 4/4/89

I spent the day Filling out flow process charts. Ricardo and the planners started on other forms

Thur - 4/6/89

Started ~~filling~~ putting together a package for one I.C.N. no. 151262. Interviewed mechanic for operation times and equipment involved with each operation. His name was Leon Brown.

Fri - 4/7/89

Started putting up profiles in folders and getting things arranged to meet with all mechanics.

Chuck Gonzalez, Ricardo Brown, Tony Mullins, and ~~myself~~ I met with Earl Stangs at 2 for a status of project report. Ricardo presented a list of things to be completed with the target completion date and the assigned responsible person. Earl reacted favorably to our approach and progress.

Sat - 4/8/89

Completed preparations for mechanics interviews. Made folders and completed blank operative profiles where the computer printouts had gaps.



Monday, April 10, 1989 and Tuesday, April 11, 1989

Larry Mullinax and I walked through the ship in bldg 95 and talked to all of the Fleet supervisors who identified their better mechanics for me to interview. I then interviewed the following mechanics associated with each PCN:

<u>Mechanic</u>	<u>Supervisor</u>	<u>PCN</u>
Billy Thompson	Steward	15113A
Eng Mundy	Steward	15025A
John Tutum	Jacobs	15119A
Reford Irre	"	15321A
Pat's Daniels	Brewer	15136A 15137A
Vernon Taylor	Jacobs	15140A
Manuel Flores	Lenox	15150A
Steve Farley	Jacobs	15175A
Jesse Spencer	Jacobs	15175A
Ralph Barrier	W <sup>Jack</sup> imberly	15188A 15189A 15191A 15192A
↓	↓	↓
Lydin Fletcher	Jack W <sup>imberly</sup>	15188A (Foreflo) 15189A 15191A 15192A
↓	↓	↓
David King	Lenox	15236A
Vicki Fry	"	15237A
Calvin Hackler	Brewer	15249A 15250A
↓	↓	↓

During the interviews I obtained the following information: (1) occurrence factor for each operation in a month; (2) skill level required for each operation.

(3) number of people needed to perform each operation, (4) amount of time <sup>required for</sup> each operation required to be performed, (5) percentages of when an operation is difficult or easy, with corresponding times, (6) equipment required during each operation, and (7) the amount of time the equipment is utilized during each operation.

Wed, 4/12/89

Don Maurer (T.O. 1 manager) and Mike McCoy (simulation manager), and ~~Henry Sigle~~ <sup>(marketing mgr)</sup> are here for two days. They spent this morning with Henry Johnson touring his BCCS and this afternoon touring Blake Hise's BCCS. Guy Felle returned today. Guy will take over Blake's position as site manager.

I started the process of getting transit times. It took longer than expected because there was clarification needed on just what time to use for transit time and because of the extra time required for the VLFs. Mike McCoy & Chuck Gonzales had a discussion on transit times and time backshops and after that things were set. I interviewed Larry Mullinax this afternoon and got all transit times (travel times between backshops) and operation times for operations in backshops.

Thursday 4/13/87

Today was spent in meetings and tours with Lou Navarro, and Mike McLoy, and Harry Steele. At 8 o'clock there was a meeting at Bldg 95 with MABPAB key personnel; Earl Stamps, (MABPAB planning unit chief) Janis Wood, (MABPAB unit chief), several MABPAB Floor supervisors, Larry Sullivan, MABPAB planning & RAB scheduler, a RAB engineer, Lou Navarro, Harry Steele, Mike McLoy, Chuck Gonzales, Ricardo Bolanos, and myself. At this meeting, Earl Stamps gave a pitch on his organization and who we were and what we were doing. Ricardo gave a status of the project report and Mike McLoy gave a summary pitch.

After this meeting, Lou Navarro, Harry Steele, Mike McLoy, Chuck Gonzales, Ricardo Bolanos, Earl Stamps and myself were given a tour of Bldg 95 by Janis Wood. After this tour, Earl Stamps reviewed the proposed layout for his facility at Bldg 201 with Lou Navarro and the rest of us, mainly Mike McLoy, answered questions that Janis Wood had on what the model could & can and cannot do.

At about 11:30 - 11:45 AM we like some group that toured Bldg 95) rode over to the other end of the base and toured Bldg 201, where RAB is scheduled to move in Oct.

Between 1 and 3 I tried to work on cleaning up the operation profile. At 3 PM we had a meeting with Col. Sauter, with chief. Our people included Lou Navarro, Mike McLoy, Harry Steele, Chuck Gonzales, Ricardo Bolanos, Larry Sullivan, and myself. The same presentation given at 2 PM was presented.

-7-

at this time. The main benefit of this meeting seemed to be the clarification of what the model cannot do.

Friday 4/14/59

I cleaned up the computer printouts and operation profiles. They are ready for input but Ricardo wants to hold them for our 'I.E. Assessment' next week.

Monday, 4/17/89

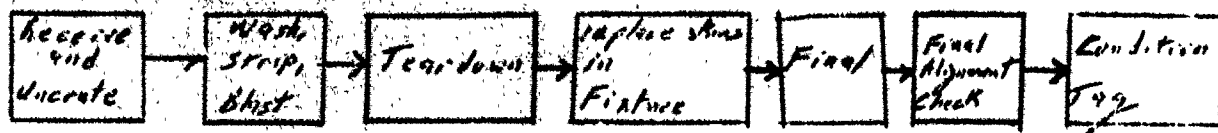
Interviewed Mr. Stewart, supervisor of M&B side cowl shop. He indicated that their main problem was availability of parts. The unavailability of new parts hampers the flow process tremendously, according to him. Key points are as follows:

- ✓ M&B is required to keep a 15 day supply of parts on hand in the Bldg 25 area, but are often out of critical parts.
- ✓ If M&B is out, and the part is somewhere else in the base, it takes 3-4 hrs to get the part.
- ✓ If a part has to be ordered it takes months for it to come in.
- ✓ Most of the time parts are 'robbed' from other workings.

A focus study is recommended to develop an inventory system that will consistently keep a 15 day supply on hand. One suggestion was to have the parts in a 'kit' for each cowl, with the unused portion returned to M&B for incorporation into other kits.

Interviewed Ino Blundy, mechanic on LH side cowl. The side cowl comes in to storage, goes through tear-down, then goes into the fixture for skin repair/replacement, then goes into Final for completion. In Final excess skin is trimmed, some parts such as clips are installed, and all over time is completed. After final the cowl goes into the fixture for a final alignment check.

A block diagram of this process is as follows:



Some areas of concern and potential quick fixes are discussed below:

- The Tear down phase cannot be worked in sequence by the W.C.D
- More light is needed in the Fixture while working up under the feet.
- Rivets - the rivets ~~must~~ have to be kept frozen in order to keep soft. After they thaw, they harden & cannot be bucked. Presently, I'm Cindy keeps dry ice in a tray of all rivets she needs. So the rivets stay cold until installed. ~~A method~~ A standardized method of doing this should be established. The Freezer is too far from the work area @ the present time to run and get whatever rivets are needed.
- Ideas - small freezers in work area
- stdized trays & block of dry ice issued to each mechanic
- The inspection technique is visual inspection. Are there other more comprehensive, objective teching
- Air pressure is a problem - water and oil get in the lines and it often operates at about 60% pressure. Rivets cannot be bucked with partial pressure.
- Human Factors - It gets very hot in the shop in the summer and very cold in the winter. Fans should be installed in the walls during the summer to drive the air in circulation.

should be installed in the new location, if it is not already planned.

- Process delays - air pressure, parts shortage, heat in summer. Very frequent breaks are necessitated, cold in winter.
- Environmental assessments/impacts - There is inadequate ventilation in the shop. During the summer a blue cloud of jet exhaust fumes builds up in the area. (They are <sup>located</sup> close to the end of the runway.) Dust clouds build up also. Again, a ventilation fan is needed to ventilate the area.
- Epi/Workplace layout - At the present time, it is often difficult to transport a cowl from the storage area to the work area because of obstructions. The new location should be designed to have a clear path from storage to the work areas.

I interviewed Billy Thompson, mech for BH side cowl and gathered the following additional information:

- A third Fixture is needed. Two fixtures are currently in place and it is the bottleneck in the process. The model should test for an extra fixture and determine the cost savings. An extra fixture is needed for LH side cowl also. If a part is needed while the cowl is in the fixture, then there is really a process delay.
- They have to establish between the parts & the machine who owned it. They send a request in with each part they request.

RF/FS  
experimentation

-11-

with the mechanics stamp number on it and a log number of the part itself. They can pinpoint who worked on what part if a part comes back defective. This is very commendable and should be implemented in all of PAB and command wide for that matter.

Going back to my interview with Mr. Steward, he gave me a 'MISTH critical / Super critical' status report that lists parts that they are waiting for. His group (side cowl) had one item on the super critical list (work stoppage) and 12 items on the critical list. He can't finish work because of these items. And it was indicated that this was a typical list.

### Summary

- ✓ Focus Study - develop a system that will consistently maintain a 15 day supply
- ✓ QF - move light on Fixture, underneath cowl
- ✓ RF - standardize procedure for keeping rivets from freezing
- ✓ HF - Human Factors - install ventilating fans to reduce heat and to ventilate jet exhaust fumes and dust out of the shop.
- ✓ QF - add a third Fixture to LH & RH side cowl to ease bottleneck - use model to experiment



4/18/89 Tuesday  
MAT Meeting

Our group had a meeting with MAT area managers. Bob Conover, MAT Planning manager, <sup>and</sup> Gene Heitman, AF Contract manager, were among the people leading up the AF at the meeting. Our group numbers nine at the present time including Guy Fallo, Henry Johnson, Blake Hixcox, Salve ~~McFarland~~, Ricardo Salinas, myself, and three new people ~~that~~ that started yesterday.

Bob Conover started the meeting by summarizing the agenda. Gene Heitman then presented a brief history of the Technology Insertion program. Guy Fallo then presented the Forms that we will be asking the AF personnel to complete and the items on the Forms were discussed.

I.E. Assessment

I interviewed Jack Wimberly, supervisor of flap ship, and Ralph Barover, mechanic <sup>working</sup> in the same area. Again, the main problem to surface was the shortage of parts: parts such as screws & skins, parts that are always used on every part often run out. It was expressed to me as a communication problem between scheduling, <sup>etc.</sup>, planning, production & upper mgmt. Sometimes a contract will expire before another one replaces it.

The inspection technique is visual. Better lighting is needed for finding the cracks, corrosion, etc.

Dust builds up in the summer which along with excessive heat, decreases productivity.

Another problem was discussed was damage to the part in transit. On the floor at the time of the interview, I saw where the leading edge of a flap had been ripped. This damage occurred between the time the part was removed from the line and when it was ~~delivered~~ delivered.

on the shop floor. A study to determine the frequency and extent of <sup>in</sup>transit damage is recommended.

Summary:

- ✓ Bottlenecks identified as parts shortage - Focus study recommended in 4/17/84 notes.
- ✓ Q/F - better lighting is needed for visual inspection.
- ✓ Q/F - Improve ventilation to reduce heat and to ventilate dust out of the area. Several stationary fans are currently used.
- ✓ Focus Study - determine frequency and extent of intransit damage to parts.

4/19/57 Wednesday

-14-

There was an informal meeting @ 7:15 AM between Earl Stamps, Harry Mullins, Ricardo Belones, and myself. Two decisions were made. The equipment in the machine shop will be reflected on the operation profile as well as the equipment profile. These equipment are not used as part of the regular <sup>process</sup> but are used often enough, for manufacturing out-of-stock items, to be profiled. These will be profiled by entering a single line on each profile with an average time that the equipment was used for that part. Three work cells work in the shop.

The second decision was to include work stations, or workbenches, on the operation and equipment profile. I made a list of PCN's <sup>from</sup> the 80/20 list and interviewed each supervisor to obtain the number of workbenches available for each PCN. Then a code no. was assigned for each group of workbenches. On the operation profile the code is entered on each operation in P/B where the part is not in the fixture. The equipment profile will reflect the quantity of workbenches available.

1989 **1st Overview-Day**

**MASPHAL - EARL STRAINS (RMS Unit Chief)**

**SHEET METAL C-135**

**R. Bolanos / T. Hall**

Day	MTWTFSS	4.88 Percent
1		1.0
2		1.0
3		1.0
4		1.0
5		1.0
6		1.0
7		1.0
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12		1.0
13		1.0
14		1.0
15		1.0
16		1.0
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19		1.0
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21		1.0
22		1.0
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25		1.0
26		1.0
27		1.0
28		1.0
29		1.0
30		1.0
31		1.0

Day	MTWTFSS	5.14 Member's Day	5.21 Annual of some Day	5.27 Memorial Day
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	April				May				June				July			
	4/7	4/12	4/19	4/26	Week 14	Week 15	Week 16	Week 17	Week 18	Week 19	Week 20	Week 21	Week 22	Week 23	Week 24	Week 25
KICK-DEE S&L																
ALC																
DATA COLLECTION ALC																
PREPARE: OPERATIONS	80%	95%	100%	100%	100%	100%	100%	100%	100%	100%	100%	100%	100%	100%	100%	100%
DISPATCH	50%	100%	100%	100%	100%	100%	100%	100%	100%	100%	100%	100%	100%	100%	100%	100%
WATERLOO	30%	100%	100%	100%	100%	100%	100%	100%	100%	100%	100%	100%	100%	100%	100%	100%
EQUIPMENT	15%	90%	100%	100%	100%	100%	100%	100%	100%	100%	100%	100%	100%	100%	100%	100%
DISPATCH/ALC	50%	100%	100%	100%	100%	100%	100%	100%	100%	100%	100%	100%	100%	100%	100%	100%
PREPARE	50%	100%	100%	100%	100%	100%	100%	100%	100%	100%	100%	100%	100%	100%	100%	100%
TYLOR DRESS	10%	10%	30%	40%	100%	100%	100%	100%	100%	100%	100%	100%	100%	100%	100%	100%
CONTROL DOCUMENTS																
ENCLOSURE	100%	100%	100%	100%	100%	100%	100%	100%	100%	100%	100%	100%	100%	100%	100%	100%
ITEM CHECK LIST	10%	30%	100%	100%	100%	100%	100%	100%	100%	100%	100%	100%	100%	100%	100%	100%
ITEM SUMMARY	10%	30%	100%	100%	100%	100%	100%	100%	100%	100%	100%	100%	100%	100%	100%	100%
RCC CHECK LIST	10%	30%	100%	100%	100%	100%	100%	100%	100%	100%	100%	100%	100%	100%	100%	100%
WLD HISTORY DATA			20%	75%	100%	100%	100%	100%	100%	100%	100%	100%	100%	100%	100%	100%
DATA PROCESSING																
PREPARE ALC				50%	100%	100%	100%	100%	100%	100%	100%	100%	100%	100%	100%	100%
FLAT FILE S&L				50%	100%	100%	100%	100%	100%	100%	100%	100%	100%	100%	100%	100%
DATA VALIDATIONS S&L				50%	80%	100%	100%	100%	100%	100%	100%	100%	100%	100%	100%	100%
SIMULATION RUN S&L																
MODEL VALIDATIONS S&L/ALC																
BRANSTORMING ALC																
EXPERIMENTATION S&L																

☐ = ☐  
☐ = ☐

## Activities Checklist

### Earl's Wish List.

DECREASE - Flow Time  
- Splice Req.  
- Labor Hr.

Improve ctrl/deg. Steve.  
Increase output (eff)

## Appendix I

**OT**

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## Only Plan

10/20/2022

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Schwache

## Contact



# MODEL PRESENTATIONS

TO AD WORK CENTER TEL

THE MARCH 1965

TOUR MARCH 21/22

**TOUR NEW Bldg for PAPER**

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Division MAB Tem Jones

**BRANCH MADE CHECKS SAME**

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[illegible]

1000

OC MABPAB

FOC/CR	Date	% Comp	Priority	Activity	Delegated to	Start Date	Due Date	D = Delegated for Action
1	100%	✓	✓	ENVELOP size for encl.	R.B.	✓ 4/7	4/7	
2		✓		Item check list	R.B.	✓ 4/7	4/14	
3		✓		Item Summary	R.B.	✓ 4/7	4/14	
4		✓		RCC Check List	R.B.	✓ 4/7	4/14	
5	80%	✓		OPERATION - MACH w/Elect. Fusion - Equipment - TSP Times - MACH. Flow Time (hrs) - SKILL LEVEL (man Rep)	T.H.	✓ 4/3	4/12	
6	50%	✓		MANPOWER - mty - Hrs - Alt. Skill Sets	E.S./E.D.	✓ 4/7	4/12	
7	30%	✓		WORKLOAD - Elements Stress - Act. Pwr by Gr - Max V.I.P - STD. Hrs	L.M.	✓ 4/7	4/12	
8	15%	✓		EQUIPMENT - Pass. Maint - Breakdown - Lower by Other - Alternative	L.M.	✓ 4/6	4/13	
9	50%	✓		DISASSEMBLE/ASSEMBLE	R.B.	✓ 4/7	4/10	
10	50%	✓		PARALLEL	R.B.	✓ 4/7	4/10	
11		✓		IN DATES	E.S.	✓ 4/7	6/7	
12		✓		OUT DATES	E.S.	✓ 4/7	6/7	
13				IE ASSESSMENT	RB/TH	4/3		ON FILE

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		1 <sup>st</sup>	DS	2 <sup>nd</sup>	DS	3 <sup>rd</sup>	DS	4 <sup>th</sup>	DS
MBPFF	ZS	4	3 1	2	2 0	1	1 0	1	1 0
	AS	24	22 4	19	16 3	11	9 2	14	12 2
	3S	14	12 2	11	9 2	9	8 1	7	6 1
	WS	20	17 3	32	27 5	25	21 4	33	28 5
	YS	<u>39</u>	33 <u>6</u> 16	<u>39</u>	33 <u>6</u> 16	<u>28</u>	24 <u>4</u> 11	<u>19</u>	16 <u>3</u> 11 - 54
Total		103		103		74		74	

		DS	DS	DS	DS	DS	DS	DS	DS
MBPAB	AS	27	25 2	12	11 1	8	7 1	14	13 1
	BS	29	27 2	28	26 2	40	37 3	35	32 3
	CS	18	17 1	20	18 2	27	25 2	19	17 2
	DS	35	32 3	18	17 1	6	6 0	4	4 0
	ES	43	40 3	48	44 4	65	60 5	50	46 4
	FS	<u>53</u>	49 4	<u>52</u>	48 4	<u>62</u>	57 5	<u>55</u>	51 4
Total		205		178		208		177	
			<u>15</u>		<u>14</u>		<u>16</u>		<u>14</u>

MBPFF		1 <sup>st</sup>	2 <sup>nd</sup>	3 <sup>rd</sup>	4 <sup>th</sup>
	5	0	0	0	0
ZS	8	1	0	0	0
	10	2	2	1	1
	5	3	3	1	2
AS	8	5	3	2	3
	10	14	10	6	7
	5	2	1	1	1
3S	8	3	2	2	1
	10	7	6	5	4
	5	3	4	4	5
WS	8	4	6	4	6
	10	18	17	13	17
	5	6	6	4	3
Y'S	8	7	7	5	3
	10	20	20	15	10
	5	1	1	1	1
GS	8	5	5	3	3
	10	10	10	7	7
		<hr/>	<hr/>	<hr/>	<hr/>
		103	103	74	74

MBPFF

	1 <sup>st</sup>	2 <sup>nd</sup>	3 <sup>rd</sup>	4 <sup>th</sup>
ZS	04 882.43	02 344.67	01 275.49	01 344.67
	04			
AS	25 8,709.60	18 4,052.00	15 3,055.10	19 4,522.20
	25			
3S	19 3,742.90	11 2,966.90	12 2,397.30	19 2,090.30
	19			
WS	19 4,360.96	38 7,113.54	34 6,964.96	45 10,450.49
4S	38 2,554.00	38 2,554.00	38 2,448.60	20 5,997.80
Totals	22,567.39	22,530.61	20,389.00	23,345.31

MBPAB

AS	10,575.50	8,998.50	7,966.00	8,193.00
	13	13	09	08
BS	11,135.00	10,709.00	10,582.00	10,463.00
	14		19	
CS	12,113.20	12,005.10	12,025.00	11,237.10
	20		31	22
DS	21,093.00	16,746.00	16,749.90	15,674.40
	26	29	30	38
ES	20,815.10	19,195.10	25,516.10	21,309.10



		1 <sup>st</sup>	2 <sup>nd</sup>	3 <sup>rd</sup>	4 <sup>th</sup>
15009A	ZS	20.61	30.87	10.87	30.87
15010	ZS	-	-	-	-
15011	ZS	-	-	-	-
15012	ZS	-	-	-	-
15013	ZS	138.46	138.46	69.23	138.46
15014	ZS	501.36	125.34	125.34	125.34
15017	AS	24.00	15.00	12.00	18.00
15020	AS	24.00	15.00	12.00	18.00
15021	AS	46.40	29.00	23.20	38.80
15022	AS	46.40	29.00	23.20	38.80
15023	AS	-	436.00	243.00	243.00
15026	AS	192.00	120.00	96.00	144.00
15027	AS	192.00	120.00	96.00	144.00
15028	AS	192.00	120.00	96.00	144.00
15029	AS	192.00	120.00	96.00	144.00
15030	AS	192.00	120.00	96.00	144.00
15031	AS	192.00	120.00	96.00	144.00
15059	BS	-	-	-	76.10
15070	BS	-	-	-	-
15073	BS	343.80	573.00	573.00	573.00
15074	BS	1,192.00	953.60	953.60	953.60
15075	BS	953.60	573.00	476.70	476.70
15076	BS	573.00	343.80	343.80	-
17297	WS	390.88	249.30	195.40	293.16
17298	WS	390.88	249.30	195.40	293.16
17299	WS	390.88	249.30	195.40	293.16
17300	WS	390.88	249.30	195.40	293.16
17301	WS	390.88	249.30	195.40	293.16
17302	WS	390.88	249.30	195.40	293.16
17303	WS	390.88	249.30	195.40	293.16
62055	AS	315.80	157.90	157.90	293.16
74495	WS	8,554.00	8,558.00	7,698.60	6,980.10
74450 Jo					
74962	AS	4,097.04	2,860.65	2,048.52	3,027.78
Total		20,567.39	20,532.65	20,384.00	23,317.31

WGS	159	92
WG 10	9	59
WG 5	8	32
WG 8	8	09
WG 10	8	54
	13	09
WGS	23	
WG 5	1	10
WG 8	1	21
WG 10	15	00
	22	95
WG 5	1	00
WG 8	8	31
WG 10	8	00
	13	15
	25	
WGS	5	
WG 5	1	00
WG 8	1	00
WG 10	1	00
	3	00

F988

	<del>OCT</del>	MABAB	MABPF	
1ST QTR	OCT	255	103	1ST QTR
2ND QTR	JAN	178	103	2ND QTR
	<del>MAY</del>	<del>167</del>	<del>74</del>	
3RD QTR	MAY	208	74	<del>208-74</del> 3RD QTR
	<del>JUN</del>	<del>174</del>	<del>74</del>	
4TH QTR	JUN	177	74	177-74 4TH QTR

IdH

1ST	5.6	5.5	
2 <del>1st</del>	5.7	5.7	
3 Rd	5.9	5.8	
4th	5.8	4.6	?

Current - % of 5s - 8s - 10s



MBPAB  
Assigned  
TE WNEI

Days			
WG 5	35	.22	
WG 8	29	.19	
WG 10	<u>93</u>	.59	
	157		.92

Swing			
WG 5	5	.38	
WG 8	1	.08	
WG 10	<u>7</u>	.54	
	13		.08

WS	4		
No tech	<u>25</u>		
	201		

IPFF

DAYS			
WG 5	12	.17	
WG 8	15	.21	
WG 10	<u>45</u>	.62	
	72		.85

Swing			
WG 5	1	.07	
WG 8	4	.31	
WG 10	<u>8</u>	.62	
	13		.15
	<u>85</u>		
WS	5		
No tech	<u>4</u>		
	94		

6837 JAF

ACT FY 88

**NOTE:**

ALC: OC  
Y/D  
DATE: SAS

DATE:

RCC: MABPAB

0:46 FRIDAY, MARCH 24, 1939 1  
SHEET OF

1

**U:40 SHEET** **FRIDAY** **OF**

SK CODE	DESCRIPTN	QTR	QUANTITY AVAILABLE			AVAILABLE HRS (PER SHIFT)		
			WORK WEEK	WEEK END	HOLIDAY	WORK WEEK	WEEK END	HOLIDAY
1	2	3	1	2	3	1	2	3

[illegible]

333

AS 3 37

15 4 37

2-140

5 2 40

5 3 37

S	4	37	Typ	2
5				

5

§ 1 21

2 22  
-4- 19.4

3 21

5 4 22

43

2 44

3 44

1

1 67

F488-1 277

522 275

3273

276

(FY 89)

SK CODE	DESCRIPTN	QTR	QUANTITY AVAILABLE			HOLIDAY			AVAILABLE HRS (PER SHIFT)			HOLIDAY		
			1	2	3	1	2	3	1	2	3	1	2	3
ES		2	66						6.2					
ES		3	66						6.1					
ES		4	70						6.1					
FS		1	66						6.1					
FS		2	64						6.2					
FS		3	65						6.1					
FS		4	66						6.1					

1/21

1071-  
72117

7-117

contraction's control  
by Civil Eng. to  
up to right line

4211

[illegible]



Q FALLO  
R. Bolani

MABPAB FIXTURES

TI DELVP. CODES  
FLIGHT CONTROLS

EQUIP CODE NO.

NAME

PART. NO.

QTY.

APPLICATI

F 335-01	FILLET FLAP	SC65-1062T1		E3A/135
" 02	RUDDER	590CJ1130	1	E3A/135
FE3A 01	INBD FLAP	SC65-1063T1	1	E3A
" 02	L'H/RH ELEVATOR	SC5-96190T1	1	E3A
F135- 01	L'H/RH ELEVATOR	590CJ1120	1	135
F 335-03	INBD AILERON	590CJ1010	3	E3A/135
" 04	OTBD MAIN FLAP	590CJ1030	1	E3A/135
F 135-02	INBD MAIN FLAP	590CJ1030	1	135
F 335-05	OTBD SPOILER	590CJ1060	1	E3A/135
" 07	OTBD AILERON	590CJ1000	3	E3A/135
F-335 10	Fore Flap Holding	801-892	4	
" 11	DOORS			
F 335-08	OTBD MLG	590CJ1110	4	E3A/135
" 09	INBD MFG	590CJ1100	4	E3a/135

MISC

F 135-03	Hog Nose Fairing	65-10607-46	1	135
" 04	OTBD ENG STRUT	590CJ1150	1	135
" 05	INBD ENG STRUT	590CJ1140	1	135
" 06	BOTTOM PANEL TF33 P9	FAJ64-8327-621	1	135
" 07	TAIL CONE	7627259	1	135
" 08	KNEE CAP FAIRING	TJ5-85654	1	135
" 09	BOOM POD FAIRING		1	135
" 10	NOSE WHEEL FAIRING	2FAJ5-73139-1	1	135
" 11	NOSE WHEEL FAIRING	FRJ5-73139-1	1	135
" 12	NOSE WHEEL FAIRING	FAJ5-73139-1	1	135
" 18	BOOM TAIL CONE	600CJ809	3	135

COWLING

F33A-03	RH SIDE COWL	SC65-25401	1	E3A
" 04	LH SIDE COWL	SC65-2549T1	1	E3A
F135-13	RH SIDE COWL J57	3AJ5-85638	2	135
" 14	LH SIDE COWL J57	3AJ5-85637	2	135
" 15	RH SIDE COWL TF33P5	005-64-8327-488	1	135
" 16	L'H SIDE COWL TF33P5	005-64-8327-487	1	135
FE3A- 05	NOSE COWL	204-70099-3ASMJ	1	E3A
" 06	NOSE COWL	204-70099-TRMJ	1	E3A
F135 -17	NOSE COWL J57	AJ5-85655	1	135

TI DEVL. CODES

B-52  
MABPFF FIXTURES

<u>EQUIP. CODE NO.</u>	<u>NAME</u>	<u>PART NO.</u>	<u>QTY</u>
FB 52-01	ELEV/RUDDER BALANCE	RP046	1
02	BOMB BAY DOOR (LARGE)	FME35-30600-3	2
03	BOMB BAY DOOR (LARGE)	FME35-30600-1	2
04	BOMB BAY DCOR (LARGE)	FME35-30600-2	2
05	BOMB BAY DOOR (SMALL)	AJ5-48467-3	1
06	BOMB BAY DOOR (SMALL)	AJ5-46867-4	2
07	BOMB BAY DOOR (SMALL)	AJ5-46868-28	1
08	BOMB BAY DOOR (SMALL)	AJ5-46868-27	1
FB 52-09	BOMB BAY DOOR (SMALL)	AJ5-46867-3	1

# MABPAB EQUIPMENT

EQUIP. CODE NO.	NAME	MODEL	QUANTITY
E 135-01	Bending MACHINE (HAND)	416	1
" 02	LARGE BAND SAWS		2
" 03	ROTEX PUNCH PRESS		1
" 04	DRILL' (FLOOR MODEL)	1200-118	1
" 05	GRINDER FLOOR MODEL, (2WHEEL ELECT)		1
" 06	PRESS BRAKE (CHICAGO STEEL CO.)	80023	1
" 07	POWER SQUARING MACHINE	002741	1
" 08	PRESS BRAKE	4560G	1
" 09	SMALL METAL SHEAR	241-C	1
" 10	SMALL DRILL PRESS		1
" 11	GRINDER 1WHEEL,(FLOOR MODEL)	WF6566	1
" 12	PUNCH PRESS	P41P	1
" 13	SANDER (BELT) FLOOR MOD.		1
" 15	BENDING MACHINE (HAND)	BB-316	1

B-52

MABPFF EQUIPMENT

<u>EQUIP. CODE NO.</u>	<u>NAME</u>	<u>MODEL #TYPE</u>	<u>QTY.</u>
EB 52-01	DOUBLE SANDER DISK (FLOOR MODEL)		1
02	DRILL PRESS (FLOOR MODEL)		4
03	GRINDING MACHINE	WISSOTA E8M	1
04	WELDER	MILLER 330ST	1
05	BRAKE, MECH		1
06	BRAKE, MECH FORMING ROLLER	0617	2
07	BRAKE, HAND	NATIONAL	2
08	METAL STREACHER (FLOOR MOD)		1
09	PRESS ARBOR	FAMCO	2
10	PUNCH, MECH	ROTEX	1
11	POWER SHEAR	MASPERI CM500A	1
12	DIMPLER	300	1
13	BRAKE PRESS	65M75	1
14	DOALL SAW	3613-2	1

# SKILL CODES

## MABPAB

_____	*AS	LEFT HAND SIDE COWL
_____	*BS	RIGHT HAND SIDE COWL
_____	*CS	NOSE COWL
_____	*DS	FLAPS
_____	*ES	FLIGHT CONTROLS
_____	*FS	MISC

## MABPFF

_____	*AS	SPOILERS, HATCHES, TIP GREAR, POP-UP
_____	*WS	ANTENNA, SUPPLY B/B DOORS
_____	*YS	FLAPS, RUDDERS, ELEVATORS.
_____	*3S	NOSE COWL, SIDE COWL
_____		PDM

## MABPCA

_____	*WL	EQUIPMENT CLEANERS
-------	-----	--------------------

## MABPCB

_____	*B3	PAINTERS
-------	-----	----------

## MABPCD

_____	*MQ	MOVERS
_____	*CQ	CRANE OPERATORS
_____	*EQ	CHECKERS

## AA

SYSTEMS (ELECTRIC)

Feb                      No. 111

15175  $\frac{1}{2}$

3

~~1757, 1758, 1759~~

151754

5

*[Handwritten signature]*

15. 7-10-1974

~~100-152-8773-4154-27~~

15. 72 - 1.2 322.2 72

100/53-2 101/51-2

151017 102 00 100

71-3 7153-3 7154-3 7215

1512 - 1513 1514

100-1 107153-4 107151-4 107150-

1. 1900

~~11-1-1915 12-1-1915~~

Fr. f/25

1512.6 - 44.3 15152.6

1921-1922

151

152364

4

~~276-1, 276-2, 276-3, 276-4~~

192274

12-1-72

1

247 - 11-11-11

15250

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11.11.55

P. H.                      M. H.  
1500.54                      10

Code No. Assignment

<del>25-1</del>	X	<del>25-6</del>
<del>25-2</del>	X	<del>25-7</del>
<del>25-3</del>	3	<del>25-8</del>
<del>25-4</del>		<del>25-9</del>
<del>25-5</del>		<del>25-10</del>

1511.24                      16

<del>113-1</del>	<del>113-6</del>	<del>113-11</del>	<del>113-12</del>
<del>113-2</del>	<del>113-7</del>	<del>113-13</del>	<del>113-14</del>
<del>113-3</del>	<del>113-8</del>	<del>113-15</del>	
<del>113-4</del>	<del>113-9</del>		
<del>113-5</del>	<del>113-10</del>		

1511.24                      7

113-1, 113-2, 113-3, 113-4

1512.04 & 1530.04                      4

120-1, 120-2, 120-3, 120-4

1513.04 & 1513.04

113-1, 113-2, 113-3, 113-4

1514.04                      5

113-1, 113-2, 113-3, 113-4

1515.04                      16

113-1, 113-2, 113-3, 113-4, 113-5, 113-6, 113-7, 113-8, 113-9, 113-10, 113-11, 113-12, 113-13, 113-14, 113-15, 113-16

**1-13**



AIRCRAFT SECTION NO.	DRAWING TITLE	DWG NO.
11	WING CENTER SECTION ASSY	5-73111
12	INBOARD WING ASSY	5-89312
13	OUTBOARD WING ASSY	5-89300
14	INBOARD WING LE INSTL	5-73114
15	OUTBOARD WING LE INSTL	5-73115
16	INBOARD WING TE INSTL	5-73116
17	OUTBOARD WING TE INSTL	5-73117
19	WINGTIP INSTL	5-73119
30	WING SPOILER INSTL	5-73130
31	INBOARD FLAP INSTL	5-73131
32	OUTBOARD FLAP INSTL	5-73132
33	INBOARD AILERON INSTL	5-73133
34	OUTBOARD AILERON INSTL	5-73134
41	BODY INSTL - SECTION 41	5-71741
43	BODY INSTL - SECTION 43	5-71743
46	BODY INSTL - SECTION 46	5-71746
48	BODY INSTL - SECTION 48	5-71748
61	MAIN LANDING GEAR - INSTL	5-83045
	MAIN LANDING GEAR INSTL <b>F</b>	458-56100
62	NOSE LANDING GEAR INSTL	5-83046
71	COWL INSTL <b>A</b>	50-3371
	COWL INSTL <b>H</b>	65-10609
	COWL INSTL <b>O</b> <b>I</b>	65C18556, 65C18603, 458-56021

AIRCRAFT SECTION NO.	DRAWING TITLE	DWG NO.
72	INBOARD STRUT INSTL <b>A</b>	5-85613
	INBOARD STRUT INSTL <b>B</b>	65-18892
	INBOARD STRUT INSTL <b>B D</b>	35-35325
	INBOARD STRUT INSTL <b>G I</b>	65C18500
74	OUTBOARD STRUT INSTL <b>A</b>	5-85614
	OUTBOARD STRUT INSTL <b>R</b>	65-18893
	OUTBOARD STRUT INSTL <b>B D</b>	35-35326
	OUTBOARD STRUT INSTL <b>C E</b>	65C18500
81	STABILIZER CENTER SECTION INSTL	5-71781
82	STABILIZER INSTL <b>A</b>	5-71782
	STABILIZER INSTL <b>B D</b> (EXTENDED)	69-12778
	STABILIZER INSTL (EXTENDED) <b>B C D E</b>	35-35322
83	STABILIZER LE INSTL <b>A</b>	5-71783
	STABILIZER LE INSTL (EXTENDED) <b>B C D E</b>	65-16737
84	ELEVATOR BALANCE ASSY	5-71784
85	DORSAL FIN INSTL	5-71785
86	VERTICAL TAIL INSTL	65-8624
78	RUDDER BALANCE ASSY	50-9788
88	RUDDER ASSY	65-3495
89	FIN TIP ASSY	50-11379
95	RUDDER VATOR <b>I</b>	5-96169

## NOTE

- A** J67-43 OR J67-59 TURBOJET ENGINES.
- B** TF33-P-6, TF33-P-6, OR TF33-PW-102 TURBOFAN ENGINES.
- C** F108-CF-100 TURBOFAN ENGINES.
- D** AIRCRAFT AFTER T.O. 1C-135-1135.
- E** AIRCRAFT AFTER T.O. 1C-135(K)A-1112.
- F** AIRCRAFT WITH AIR REFUELING BOOM.

Figure 1-3. Major Structural Group Breakdown (Sheet 4 of 4)



1. 2. 3. 4. 5. 6. 7. 8. 9. 10. 11. 12. 13. 14. 15. 16. 17. 18. 19. 20. 21. 22. 23. 24. 25. 26. 27. 28. 29. 30. 31. 32. 33. 34. 35. 36. 37. 38. 39. 40. 41. 42. 43. 44. 45. 46. 47. 48. 49. 50. 51. 52. 53. 54. 55. 56. 57. 58. 59. 60. 61. 62. 63. 64. 65. 66. 67. 68. 69. 70. 71. 72. 73. 74. 75. 76. 77. 78. 79. 80. 81. 82. 83. 84. 85. 86. 87. 88. 89. 90. 91. 92. 93. 94. 95. 96. 97. 98. 99. 100. 101. 102. 103. 104. 105. 106. 107. 108. 109. 110. 111. 112. 113. 114. 115. 116. 117. 118. 119. 120. 121. 122. 123. 124. 125. 126. 127. 128. 129. 130. 131. 132. 133. 134. 135. 136. 137. 138. 139. 140. 141. 142. 143. 144. 145. 146. 147. 148. 149. 150. 151. 152. 153. 154. 155. 156. 157. 158. 159. 160. 161. 162. 163. 164. 165. 166. 167. 168. 169. 170. 171. 172. 173. 174. 175. 176. 177. 178. 179. 180. 181. 182. 183. 184. 185. 186. 187. 188. 189. 190. 191. 192. 193. 194. 195. 196. 197. 198. 199. 200. 201. 202. 203. 204. 205. 206. 207. 208. 209. 210. 211. 212. 213. 214. 215. 216. 217. 218. 219. 220. 221. 222. 223. 224. 225. 226. 227. 228. 229. 230. 231. 232. 233. 234. 235. 236. 237. 238. 239. 240. 241. 242. 243. 244. 245. 246. 247. 248. 249. 250. 251. 252. 253. 254. 255. 256. 257. 258. 259. 260. 261. 262. 263. 264. 265. 266. 267. 268. 269. 270. 271. 272. 273. 274. 275. 276. 277. 278. 279. 280. 281. 282. 283. 284. 285. 286. 287. 288. 289. 290. 291. 292. 293. 294. 295. 296. 297. 298. 299. 300. 301. 302. 303. 304. 305. 306. 307. 308. 309. 310. 311. 312. 313. 314. 315. 316. 317. 318. 319. 320. 321. 322. 323. 324. 325. 326. 327. 328. 329. 330. 331. 332. 333. 334. 335. 336. 337. 338. 339. 340. 341. 342. 343. 344. 345. 346. 347. 348. 349. 350. 351. 352. 353. 354. 355. 356. 357. 358. 359. 360. 361. 362. 363. 364. 365. 366. 367. 368. 369. 370. 371. 372. 373. 374. 375. 376. 377. 378. 379. 380. 381. 382. 383. 384. 385. 386. 387. 388. 389. 390. 391. 392. 393. 394. 395. 396. 397. 398. 399. 400. 401. 402. 403. 404. 405. 406. 407. 408. 409. 410. 411. 412. 413. 414. 415. 416. 417. 418. 419. 420. 421. 422. 423. 424. 425. 426. 427. 428. 429. 430. 431. 432. 433. 434. 435. 436. 437. 438. 439. 440. 441. 442. 443. 444. 445. 446. 447. 448. 449. 450. 451. 452. 453. 454. 455. 456. 457. 458. 459. 460. 461. 462. 463. 464. 465. 466. 467. 468. 469. 470. 471. 472. 473. 474. 475. 476. 477. 478. 479. 480. 481. 482. 483. 484. 485. 486. 487. 488. 489. 490. 491. 492. 493. 494. 495. 496. 497. 498. 499. 500. 501. 502. 503. 504. 505. 506. 507. 508. 509. 510. 511. 512. 513. 514. 515. 516. 517. 518. 519. 520. 521. 522. 523. 524. 525. 526. 527. 528. 529. 530. 531. 532. 533. 534. 535. 536. 537. 538. 539. 540. 541. 542. 543. 544. 545. 546. 547. 548. 549. 550. 551. 552. 553. 554. 555. 556. 557. 558. 559. 560. 561. 562. 563. 564. 565. 566. 567. 568. 569. 570. 571. 572. 573. 574. 575. 576. 577. 578. 579. 580. 581. 582. 583. 584. 585. 586. 587. 588. 589. 590. 591. 592. 593. 594. 595. 596. 597. 598. 599. 600. 601. 602. 603. 604. 605. 606. 607. 608. 609. 610. 611. 612. 613. 614. 615. 616. 617. 618. 619. 620. 621. 622. 623. 624. 625. 626. 627. 628. 629. 630. 631. 632. 633. 634. 635. 636. 637. 638. 639. 640. 641. 642. 643. 644. 645. 646. 647. 648. 649. 650. 651. 652. 653. 654. 655. 656. 657. 658. 659. 660. 661. 662. 663. 664. 665. 666. 667. 668. 669. 670. 671. 672. 673. 674. 675. 676. 677. 678. 679. 680. 681. 682. 683. 684. 685. 686. 687. 688. 689. 690. 691. 692. 693. 694. 695. 696. 697. 698. 699. 700. 701. 702. 703. 704. 705. 706. 707. 708. 709. 710. 711. 712. 713. 714. 715. 716. 717. 718. 719. 720. 721. 722. 723. 724. 725. 726. 727. 728. 729. 730. 731. 732. 733. 734. 735. 736. 737. 738. 739. 740. 741. 742. 743. 744. 745. 746. 747. 748. 749. 750. 751. 752. 753. 754. 755. 756. 757. 758. 759. 760. 761. 762. 763. 764. 765. 766. 767. 768. 769. 770. 771. 772. 773. 774. 775. 776. 777. 778. 779. 780. 781. 782. 783. 784. 785. 786. 787. 788. 789. 790. 791. 792. 793. 794. 795. 796. 797. 798. 799. 800. 801. 802. 803. 804. 805. 806. 807. 808. 809. 810. 811. 812. 813. 814. 815. 816. 817. 818. 819. 820. 821. 822. 823. 824. 825. 826. 827. 828. 829. 830. 831. 832. 833. 834. 835. 836. 837. 838. 839. 840. 84

[illegible]

... 1980 ...

14. AND OTHERS:

11. 11. 11.

[illegible]

THE NATIONAL CREDIT VALUE RECORDING  
AND CREDIT VALUE

ALL INFORMATION CONTAINED HEREIN IS UNCLASSIFIED  
DATE 08-20-2008 BY 60322 UCBAW

|           |             |
|-----------|-------------|
| PL 112-96 | NOT PRESENT |
| PL 112-97 | NOT PRESENT |

PLUG ALL HOLES IN ROOF & EXTERIOR  
PAINT STRIPPER FROM LOW END INTO  
INTERIOR OF WALL.

REPORT OF 1961

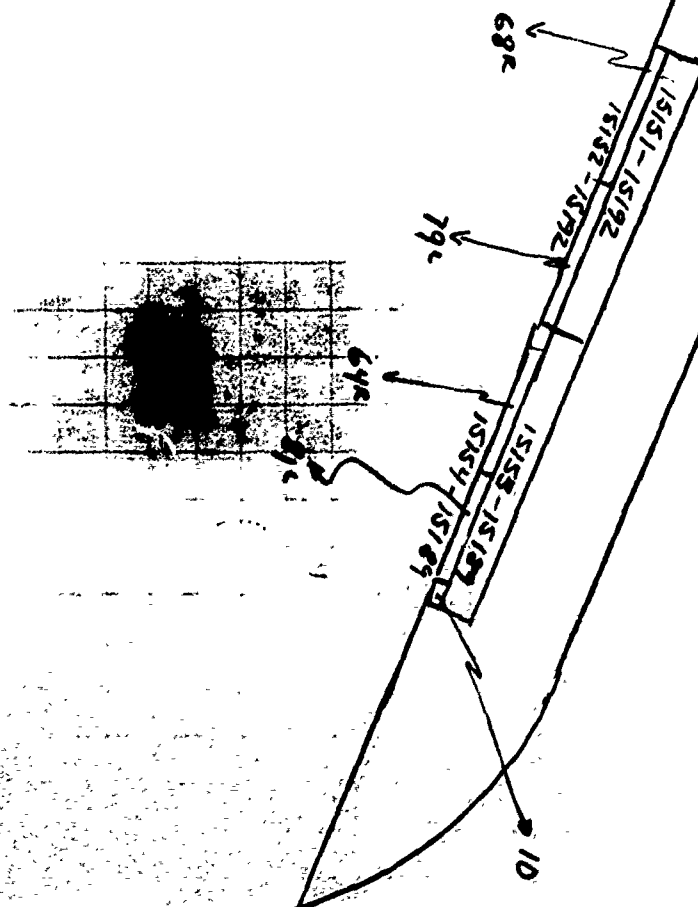
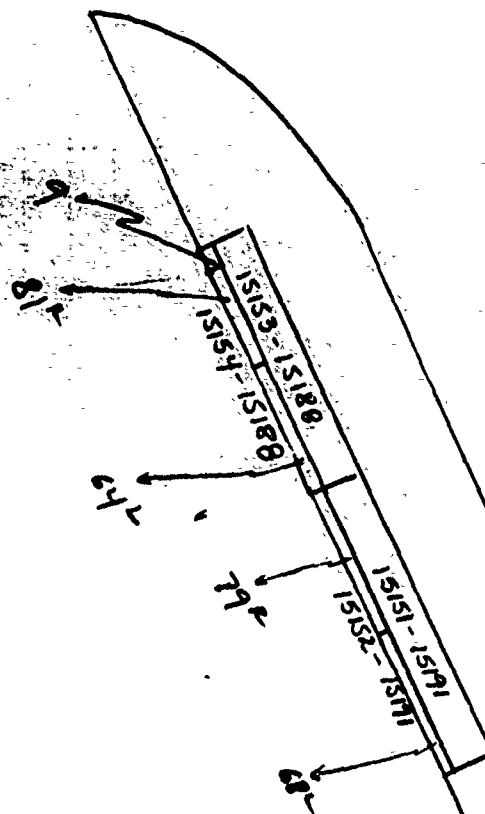
CLEAN & STRIP PAINT FROM FLAP  
CONCLUDING FLAP TRACK TO 123 Jaws  
move TO 10350.

NOTE: ON FDD LINE, CIPHERED, FROM  
COUNTRIES THAT ARE NOT A CONTRACTING  
COUNTRY, INDICATE THE NAME OF THE  
COUNTRY OF ORIGIN OF THE MESSAGE  
BEFORE THE MESSAGE.

7-20-64 10:00 AM 100-44388-1000

**Laboratory Director:** \_\_\_\_\_  
**Date:** \_\_\_\_\_

2019年12月10日



# SHOP FLOW DAY STANDARD

Reference AFLCR 66-11

CONTROL NO. \_\_\_\_\_

DATE \_\_\_\_\_

$$\text{Shop Flow Days (Std. calendar days)} = \frac{A((B / C) + D + E)}{F}$$

Where :

A = CONVERSION FACTOR, Changing workdays to calendar days.

5 day week = 1.46

6 day week = 1.21

7 day week = 1.03

A = \_\_\_\_\_

B = END ITEM STD HRS, expressed in hours, to two decimal places.

Note 1. When an operation with a labor standard takes place concurrent to a process support or unique process support operation (factors D or E below), use only the longer time.

Note 2. If the same operation is performed on the same part at the same time by multiple workers, divide the total standard time by the number of workers.

B = \_\_\_\_\_

C = RCC CONSTANT, Direct labor hours, expressed as a percentage of total hours available. Subtract indirect labor factors for duty codes .24, .25, .26, and .29 from 1.00. Reference GO37G-EHI-MI-MEH. Round off answer to four decimal places.

C = \_\_\_\_\_

D = PROCESS SUPPORT, expressed in hours, to two decimal places.

An average time value for each end item, for transportation time between RCCs, packing, unpacking, and awaiting Maintenance time.

D = \_\_\_\_\_

E = UNIQUE PROCESS SUPPORT, expressed in hours, to two decimal places. An average time value for each end item, for processes, such as plating, heat treating, welding, painting, etc. E = \_\_\_\_\_

F = SHIFT HOURS, expressed in whole hours. Normally 8 hours in peacetime. Peacetime process or test times that exceed 8 hours are an exception (e.g. plating, heat treating, etc.). If the number of shifts are temporarily changed (3 months or less), the number of flow days should not be modified.

F = \_\_\_\_\_

$$\text{Flow days} = \frac{A((B / C) + D + E)}{F}$$

FD = \_\_\_\_\_

28 Feb 89

Al,

Attached is the shop rate information that you asked me to provide. I've also included a list of the routing symbols and their associated unit names. Note that on the computer output routing symbols are reduced from the normal MABPAB to MBPAB.

You also asked that I determine the amount of maskant utilized per year. Personnel in the MIC report that a quantity of forty gallons per month or four hundred and eighty per year is utilized.



GENE W. LEITERMAN  
OC-ALC TI Program Manager

FY 89  
OC-ALC  
RCC RATES

DATE : 13-Mar-89  
FILE : OCRATE

| RCC    | DIRECT<br>LABOR | DIRECT<br>MAT'L | OTHER<br>DIRECT | OVHD IND<br>MAT'L | OVHD<br>OTHER | G & A | TOTAL  | LESS<br>DIR MAT'L |
|--------|-----------------|-----------------|-----------------|-------------------|---------------|-------|--------|-------------------|
| MABPAB | 19.86           | 14.61           | 0.00            | 5.34              | 11.01         | 5.34  | 56.16  | 41.55             |
| MABPFF | 19.65           | 3.46            | 0.00            | 1.67              | 9.05          | 5.34  | 39.17  | 35.71             |
| MAEPSG | 16.79           | 0.00            | 0.00            | 2.92              | 11.11         | 5.19  | 36.01  | 36.01             |
| MATPAA | 17.40           | 58.69           | 0.00            | 1.33              | 11.81         | 5.19  | 94.42  | 35.73             |
| MATPAB | 18.08           | 122.09          | 0.00            | 2.34              | 13.19         | 5.19  | 160.89 | 38.80             |
| MATPAT | 19.71           | 0.00            | 0.00            | 1.23              | 16.55         | 5.19  | 42.68  | 42.68             |
| MATPCA | 18.17           | 39.11           | 0.00            | 2.94              | 14.53         | 5.19  | 79.94  | 40.83             |
| MATPCB | 16.96           | 81.85           | 0.00            | 1.87              | 14.59         | 5.19  | 120.46 | 38.61             |
| MATPCC | 17.87           | 49.10           | 0.00            | 1.28              | 9.92          | 5.19  | 83.36  | 34.26             |
| MATPCD | 17.86           | 45.43           | 0.00            | 1.60              | 15.75         | 5.19  | 85.83  | 40.40             |
| MATPCM | 17.16           | 0.00            | 0.00            | 1.19              | 13.51         | 5.19  | 37.05  | 37.05             |
| MATPFA | 18.33           | 11.92           | 0.00            | 1.36              | 13.92         | 5.19  | 50.72  | 38.80             |
| MATFFE | 18.31           | 12.21           | 0.00            | 1.27              | 11.85         | 5.19  | 48.83  | 36.62             |
| MATPFF | 18.42           | 19.74           | 0.00            | 1.26              | 18.44         | 5.19  | 63.05  | 43.31             |
| MATPHA | 18.78           | 53.16           | 0.00            | 1.84              | 13.35         | 5.19  | 92.32  | 39.16             |
| MATPHB | 18.69           | 100.30          | 0.00            | 1.84              | 12.65         | 5.19  | 138.67 | 38.37             |
| MATPHE | 17.51           | 0.00            | 0.00            | 1.84              | 13.38         | 5.19  | 37.92  | 37.92             |
| MATPIA | 18.13           | 35.55           | 0.00            | 2.61              | 14.99         | 5.19  | 76.47  | 40.92             |
| MATPIN | 18.90           | 5.79            | 0.00            | 3.08              | 16.15         | 5.19  | 49.11  | 43.32             |
| MATPIN | 21.17           | 1.30            | 0.00            | 2.44              | 23.07         | 5.19  | 53.17  | 51.87             |
| MATPIN | 19.28           | 39.86           | 0.00            | 3.47              | 14.19         | 5.19  | 81.99  | 42.13             |

OC-ALC  
RCC CODES

|       |  |
|-------|--|
| MBPAB | Sheetmetal Backshop Unit                       |
| MBPFF | MISTR Sheetmetal Unit                          |
| MTPAA | Cabin Pressure Regulator & Valve Unit          |
| MTPAB | Turbine Powered Access & Missile Maint Unit    |
| MTPAT | Air Accessories Testing Unit                   |
| MTPCA | Electrical Accessories Unit                    |
| MTPCB | Accessories Unit                               |
| MTPCC | Electro-Mechanical Accessories Unit            |
| MTPCD | Governor, Misc Eng Access Overhaul & Test Unit |
| MTPCM | Machine Unit                                   |
| MTPFA | Automatic Pilot Unit                           |
| MTFFE | Engine Instrument Unit                         |
| MTPFF | Flight Control Unit                            |
| MTPHA | General Transmission Overhaul Unit             |
| MTPHB | Specialized Transmission Overhaul Unit         |
| MTPHE | Machine Shop Unit                              |
| MTPIA | Sheetmetal Unit                                |
| MTPIM | Machine Shop Unit                              |
| MTPIN | Numeric Control Unit                           |
| MTPIW | General Welding Unit                           |
| MEPSG | Plating Unit                                   |



RCC: MABPAB

[illegible]

MABFABWL-PP  
REQ. MLW

OC

WORKLOAD PROFILE  
TINKER, AFB OKLAHOMA CITY, OK.

4/28/1989  
RCC = MABPAB

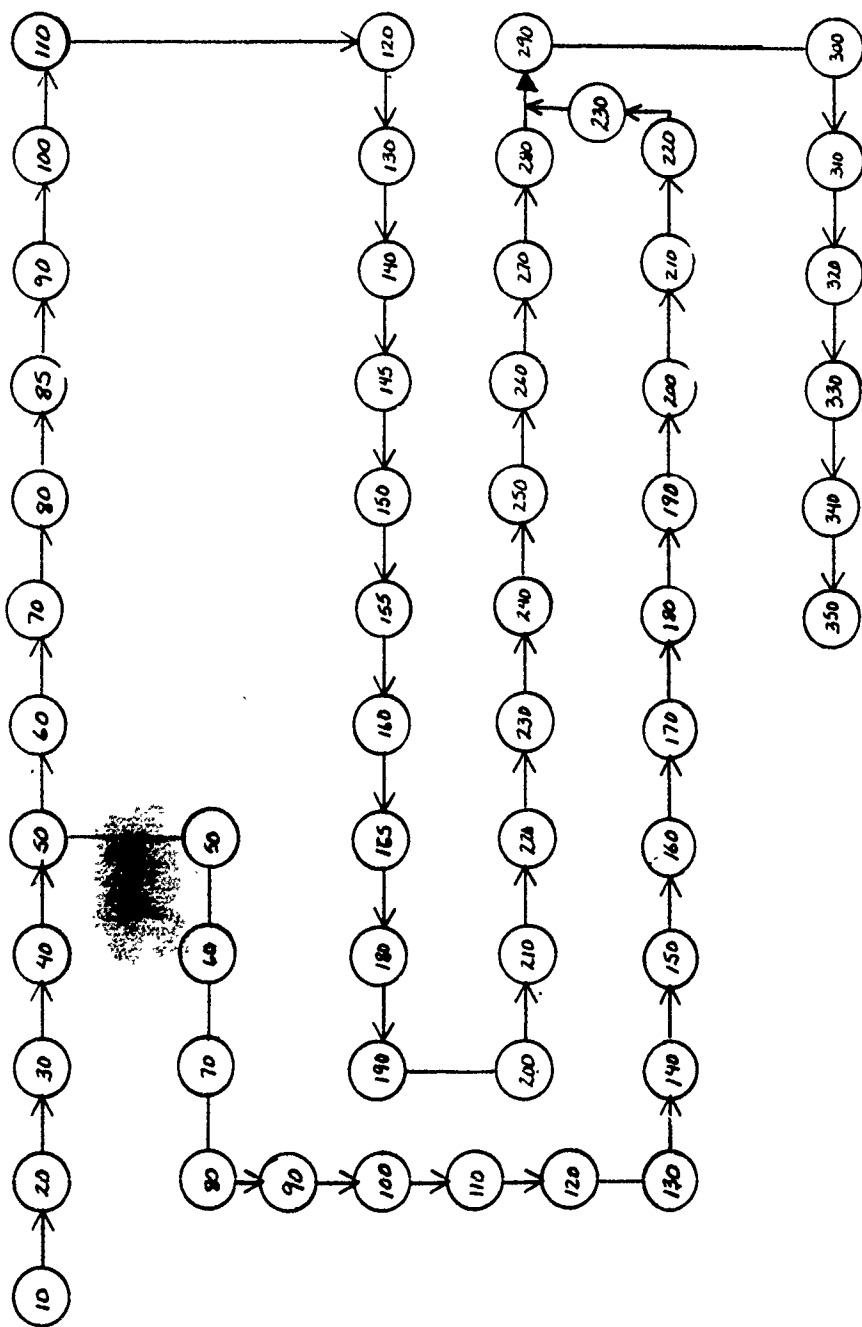
| ITEM NUMBER | AIRCRAFT<br>MODEL | WCD     | W | FLT<br>STK | ACTUAL<br>Q1 | Q2 | PROD./QTR<br>Q3 | Q4 | EN<br>UN | MAX<br>WIP | STD<br>HOURS | BO/20<br>WT |
|-------------|-------------------|---------|---|------------|--------------|----|-----------------|----|----------|------------|--------------|-------------|
| 15025A      | C-135             | 15025A  | 4 |            | 56           | 55 | 54              | 75 |          | 30         | 163.5        | 19.8        |
| 15113A      | C-135             | 15113A  | 4 |            | 60           | 60 | 53              | 70 |          | 44         | 147.7        | 18.1        |
| 15119A      | C-135             | 15119A  | 4 |            | 13           | 16 | 20              | 20 |          | 8          | 89.8         | 3.1         |
| 15321A      | C-135             | 15321A  | 4 |            | 13           | 16 | 20              | 20 |          | 8          | 90.2         | 3.1         |
| 15126A      | C-135             | 15126A  | 4 |            | 13           | 16 | 20              | 20 |          | 10         | 88.7         | 3.1         |
| 15300A      | C-135             | 15126AA | 4 |            | 13           | 16 | 20              | 20 |          | 10         | 98.3         | 3.4         |
| 15136A      | C-135             | 15136A  | 4 |            | 13           | 18 | 23              | 22 |          | 8          | 79.2         | 3.0         |
| 15137A      | C-135             | 15136AA | 4 |            | 13           | 16 | 23              | 21 |          | 8          | 79.2         | 2.9         |
| 15140A      | C-135             | 15140A  | 4 |            | 1            | 0  | 4               | 40 |          | 16         | 51.7         | 1.2         |
| 15150A      | C-135             | 15150A  | 4 |            | 25           | 25 | 38              | 66 |          | 34         | 85.2         | 6.6         |
| 15175A      | C-135             | 15175A  | 4 |            | 25           | 12 | 8               | 26 |          | 14         | 73.9         | 2.7         |
| 15178A      | C-135             | 15178A  | 4 |            | 36           | 50 | 59              | 75 |          | 14         | 13.0         | 2.1         |
| 15188A      | C-135             | 15153A  | 4 |            | 13           | 13 | 15              | 17 |          | 16         | 120.7        | 3.5         |
| 15189A      | C-135             | 15153AA | 4 |            | 13           | 15 | 15              | 17 |          | 16         | 120.7        | 3.7         |
| 15188ASUB1  | C-135             | 15154A  | 4 | 2          |              |    |                 |    |          | 50         | 15.0         | 1.8         |
| 15189ASUB1  | C-135             | 15154AA | 4 | 2          |              |    |                 |    |          | 50         | 15.0         | 1.8         |
| 15191A      | C-135             | 15151A  | 4 |            | 11           | 11 | 16              | 17 |          | 14         | 118.7        | 3.3         |
| 15192A      | C-135             | 15151AA | 4 |            | 6            | 6  | 10              | 17 |          | 16         | 118.7        | 2.3         |
| 15191ASUB1  | C-135             | 15152A  | 4 | 2          |              |    |                 |    |          | 50         | 15.0         | 1.7         |
| 15192ASUB1  | C-135             | 15152AA | 4 | 2          |              |    |                 |    |          | 50         | 15.0         | 1.2         |
| 15236A      | C-135             | 15236A  | 4 |            | 6            | 10 | 9               | 9  |          | 8          | 121.6        | 2.1         |
| 15237A      | C-135             | 15237A  | 4 |            | 8            | 8  | 8               | 8  |          | 2          | 28.6         | 0.5         |
| 15249A      | C-135             | 15249A  | 4 |            | 13           | 18 | 23              | 20 |          | 6          | 110.5        | 4.1         |
| 15250A      | C-135             | 15249AA | 4 |            | 13           | 18 | 23              | 20 |          | 6          | 111.0        | 4.2         |
| 15237ASUB1  | C-135             | 15236B  | 4 | 2          |              |    |                 |    |          | 2          | 28.6         | 0.5         |

OC - MABPAB

| PCN        | WCD     |
|------------|---------|
| *****      | *****   |
| 15025A     | 15025A  |
| 15113A     | 15113A  |
| 15119A     | 15119A  |
| 15126A     | 15126A  |
| 15136A     | 15136A  |
| 15137A     | 15136AA |
| 15140A     | 15140A  |
| 15150A     | 15150A  |
| 15175A     | 15175A  |
| 15178A     | 15178A  |
| 15188A     | 15153A  |
| 15188ASUB1 | 15154A  |
| 15189ASUB1 | 15154AA |
| 15189A     | 15153AA |
| 15191A     | 15151A  |
| 15191ASUB1 | 15152A  |
| 15192A     | 15151AA |
| 15192ASUB1 | 15152AA |
| 15236A     | 15236A  |
| 15237ASUB1 | 15236B  |
| 15237A     | 15237A  |
| 15249A     | 15249A  |
| 15250A     | 15249AA |
| 15300A     | 15126AA |
| 15321A     | 15119AA |

# MABPAB EQUIPMENT

| EQUIP. CODE NO. | NAME                                   | MODEL     | QUANTITY |
|-----------------|--|-----------|----------|
| E 135-01        | Bending MACHINE (HAND)                 | 416       | 1        |
| " 02            | LARGE BAND SAWS                        |           | 2        |
| " 03            | ROTEX PUNCH PRESS                      |           | 1        |
| " 04            | DRILL (FLOOR MODEL)                    | 1200-118  | 1        |
| " 05            | GRINDER FLOOR MODEL,<br>(2WHEEL ELECT) |           | 1        |
| " 06            | PRESS BRAKE (CHICAGO<br>STIFFL CO.)    | 80823     | 1        |
| " 07            | TOWER SQUARING MACHINE                 | 002741    | 1        |
| " 08            | PRESS BRAKE                            | 4560G     | 1        |
| " 09            | SMALL METAL SHEAR                      | 241-C     | 1        |
| " 10            | SMALL DRILL PRESS                      |           | 1        |
| " 11            | GRINDER 1WHEEL, (FLOOR<br>MODEL)       | WF6566    | 1        |
| " 12            | PUNCH PRESS                            | P41P      | 1        |
| " 13            | SANDER (BELT) FLOOR MOD.               |           | 1        |
| " 15            | BENDING MACHINE (HAND)                 | BB-316    | 1        |
| " 16            | DIMPLING MACHINE                       | AT25655   | 1        |
| 17              | PORTABLE ELEVATOR                      | 1518-R5   | 1        |
| 18              | AIR HOIST 1 Ton                        | S2T18-205 | 1        |
| 19              | AIR HOIST 1 Ton                        | S2T18-205 | 1        |
| 20              | ELECTRONIC PROG                        | SQ 200    | 1        |
| 21              | METAL FORMER                           | 381D      | 1        |
| 22              | METAL SHEAR (HAND)                     | 107-12-78 | 1        |
| 23              | SHRINKING/STRETCHING MACHINE           | 8028      | 1        |
| 24              | ARBOR (HAND)                           | 0685      | 1        |



MABPABEQ.PP  
REQ. MLW

OC

EQUIPMENT PROFILE  
TINKER, AFB OKLAHOMA CITY, OK.

4/28/1989  
RCC = MABPAB

| EQUIP<br>CODE | EQUIP<br>DESCR | QUANT<br>S1 | AVAIL<br>S2 | PREV<br>S3 | MAINT<br>FRQ | TIME<br>S | UNSCHE<br>D TBF | MTTR | %<br>NOT | ENVELOPE ALT<br>MIN MAX EQUIP |
|---------------|----------------|-------------|-------------|------------|--------------|-----------|-----------------|------|----------|-------------------------------|
| E135-01       | BENDMACH       | 1           |             | 90         | 1            | 0.20      |                 |      | 43       |                               |
| E135-02       | BAND SAW       | 1           |             | 120        | 1            | 0.50      |                 |      | 43       |                               |
| E135-02       | BAND SAW       |             |             | 120        | 1            | 0.50      |                 |      | 43       |                               |
| E135-03       | PUNCHPRES      | 1           |             | 90         | 1            | 1.50      |                 |      | 43       |                               |
| E135-03       | PUNCHPRES      |             |             | 90         | 1            | 0.50      |                 |      | 43       |                               |
| E135-04       | DRILL/FM       | 1           |             | 90         | 1            | 0.50      |                 |      | 43       |                               |
| E135-05       | GRINDER/F      | 1           |             | 180        | 1            | 0.50      |                 |      | 43       |                               |
| E135-05       | GRINDER/F      |             |             | 90         | 1            | 0.50      |                 |      | 43       |                               |
| E135-06       | PRESSBRK       | 1           |             | 180        | 1            | 0.50      |                 |      | 43       |                               |
| E135-06       | PRESSBRK       |             |             | 90         | 1            | 0.50      |                 |      | 43       |                               |
| E135-07       | POWER SQ       | 1           |             | 60         | 1            | 0.30      |                 |      | 43       |                               |
| E135-07       | POWER SQ       |             |             | 360        | 1            | 0.50      |                 |      | 43       |                               |
| E135-07       | POWER SQ       |             |             | 600        | 1            | 1.00      |                 |      | 43       |                               |
| E135-07       | POWER SQ       |             |             | 180        | 1            | 0.50      |                 |      | 43       |                               |
| E135-08       | PRESSBRK       | 1           |             | 120        | 1            | 1.00      |                 |      | 43       |                               |
| E135-09       | METALSHEA      | 1           |             | 90         | 1            | 0.20      |                 |      | 43       |                               |
| E135-10       | SMDRILPRE      | 1           |             | 120        | 1            | 0.50      |                 |      | 43       |                               |
| E135-12       | PUNCHPR/S      | 1           |             | 120        | 1            | 0.50      |                 |      | 43       |                               |
| E135-12       | PUNCHPRES      |             |             | 90         | 1            | 0.20      |                 |      | 43       |                               |
| E135-13       | SANDER/FM      | 1           |             | 180        | 1            | 1.00      |                 |      | 43       |                               |
| E135-15       | BENDMACH       | 1           |             | 90         | 1            | 0.20      |                 |      | 43       |                               |
| E135-16       | DIMPMACH       | 1           |             | 365        | 1            | 1.00      |                 |      | 43       |                               |
| E135-16       | DIMPMACH       |             |             | 180        | 1            | 1.00      |                 |      | 43       |                               |
| E135-17       | PORTELEVA      | 1           |             | 30         | 1            | 0.50      |                 |      | 43       |                               |
| E135-17       | PORTELEVA      |             |             | 90         | 1            | 1.00      |                 |      | 43       |                               |
| E135-17       | PORTELEVA      |             |             | 180        | 1            | 1.50      |                 |      | 43       |                               |
| E135-18       | AIRHOIST       | 1           |             | 1          | 1            | 0.10      |                 |      | 43       |                               |
| E135-19       | AIRHOIST       | 1           |             | 1          | 1            | 0.10      |                 |      | 43       |                               |
| E135-20       | ELEC PROG      | 1           |             | 365        | 1            | 1.00      |                 |      | 43       |                               |
| E135-21       | METAL FOR      | 1           |             | 90         | 1            | 0.20      |                 |      | 43       |                               |
| E135-22       | METALSHEA      | 1           |             | 90         | 1            | 0.20      |                 |      | 43       |                               |
| E135-23       | SHRINKMAC      | 1           |             | 90         | 1            | 0.20      |                 |      | 43       |                               |
| E135-24       | ARBOR          | 1           |             | 90         | 1            | 0.20      |                 |      | 43       |                               |
| F335-01       | FILLETFLA      | 1           |             | 365        | 1            | 32.00     |                 |      | 43       |                               |
| F335-02       | RUDDER         | 1           |             | 365        | 1            | 32.00     |                 |      | 43       |                               |
| FE3A-01       | INBD FLAP      | 1           |             | 365        | 1            | 32.00     |                 |      | 43       |                               |
| FE3A-02       | RL/H ELEV      | 1           |             | 365        | 1            | 32.00     |                 |      | 43       |                               |
| F135-01       | RL/H ELEV      | 1           |             | 365        | 1            | 32.00     |                 |      | 43       |                               |
| F335-03       | INBD AILE      | 3           |             | 365        | 1            | 32.00     |                 |      | 43       |                               |
| F335-04       | OTBDMNFLA      | 1           |             | 365        | 1            | 32.00     |                 |      | 43       |                               |

|         |            |    |     |   |       |
|---------|------------|----|-----|---|-------|
| F335-05 | DISPOIL    | 1  | 365 | 1 | 32.00 |
| F335-07 | AIL        | 3  | 365 | 1 | 32.00 |
| F335-08 | OT MLG     | 4  | 365 | 1 | 32.00 |
| F335-09 | INBD MLG   | 4  | 365 | 1 | 32.00 |
| F135-03 | HOGNOSE    | 1  | 365 | 1 | 32.00 |
| F135-04 | OTBDENGST  | 1  | 365 | 1 | 32.00 |
| F135-05 | INBDENGST  | 1  | 365 | 1 | 32.00 |
| F135-06 | BOT/PANEL  | 1  | 365 | 1 | 32.00 |
| F135-07 | TAIL CONE  | 1  | 365 | 1 | 32.00 |
| F135-08 | KNEE FAIR  | 1  | 365 | 1 | 32.00 |
| F135-09 | BOMPODFAI  | 1  | 365 | 1 | 32.00 |
| F135-10 | N/WFAIRIN  | 1  | 365 | 1 | 32.00 |
| F135-11 | N/WFAIRIN  | 1  | 365 | 1 | 32.00 |
| F135-12 | N/WFAIRIN  | 1  | 365 | 1 | 32.00 |
| F135-18 | BOMTA/CON  | 3  | 365 | 1 | 32.00 |
| FE3A-03 | RHSIDECOW  | 1  | 365 | 1 | 32.00 |
| FE3A-04 | LHSIDECOW  | 1  | 365 | 1 | 32.00 |
| F135-13 | RHSIDECOW  | 2  | 365 | 1 | 56.00 |
| F135-14 | LHSIDECOW  | 2  | 365 | 1 | 56.00 |
| F135-15 | RHSIDECOW  | 1  | 365 | 1 | 32.00 |
| F135-16 | LHSIDECOW  | 1  | 365 | 1 | 32.00 |
| FE3A-05 | NNOSE COWL | 1  | 365 | 1 | 32.00 |
| FE3A-06 | NNOSE COWL | 1  | 365 | 1 | 32.00 |
| F135-17 | NNOSE COWL | 1  | 365 | 1 | 32.00 |
| 25      | BENCH      | 10 |     |   |       |
| 113     | BENCH      | 16 |     |   |       |
| 119     | BENCH      | 4  |     |   |       |
| 126     | BENCH      | 4  |     |   |       |
| 136     | BENCH      | 4  |     |   |       |
| 140     | BENCH      | 5  |     |   |       |
| 150     | BENCH      | 16 |     |   |       |
| 175     | BENCH      | 3  |     |   |       |
| 178     | BENCH      | 5  |     |   |       |
| 188153  | BENCH      | 12 |     |   |       |
| 188154  | BENCH      | 6  |     |   |       |
| 236     | BENCH      | 4  |     |   |       |
| 237     | BENCH      | 1  |     |   |       |
| 249     | BENCH      | 5  |     |   |       |

MABPABDA.PP  
REQ. MLW

OC

DISASSEMBLY/ASSEMBLY PROFILE  
TURNER, AFB OKLAHOMA CITY, OK.

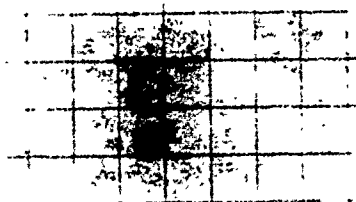
4/28/1989  
RCC = MABPAB

| * * *  | TOP | ASSEMBLY | * * * | WCD     | WDATE | REM | OPN | INS | OPN | * * * | ITEM       | NUMBER | * * * | SUBASSEMBLY | * * * | WCD     | WDATE | * * * | S |
|--------|-----|----------|-------|---------|-------|-----|-----|-----|-----|-------|------------|--------|-------|-------------|-------|---------|-------|-------|---|
| 15188A |     |          |       | 15153A  | 88055 | 20  | 310 | 310 | 310 |       | 15188ASUB1 |        |       | 15154A      |       | 15154A  | 88055 |       | I |
| 15189A |     |          |       | 15153AA | 88055 | 20  | 310 | 310 | 310 |       | 15189ASUB1 |        |       | 15154AA     |       | 15154AA | 88055 |       | N |
| 15191A |     |          |       | 15151A  | 88055 | 20  | 310 | 310 | 310 |       | 15191ASUB1 |        |       | 15152A      |       | 15152A  | 88055 |       | N |
| 15192A |     |          |       | 15151AA | 88055 | 20  | 310 | 310 | 310 |       | 15192ASUB1 |        |       | 15152AA     |       | 15152AA | 88055 |       | N |
| 15236A |     |          |       | 15236A  | 88055 | 50  | 290 | 290 | 290 |       | 15237ASUB1 |        |       | 15236B      |       | 15236B  | 88069 |       | N |



"SEE WCD / FLOW PROCESS

CHART DOCUMENTATION BOOK



# Power Plant

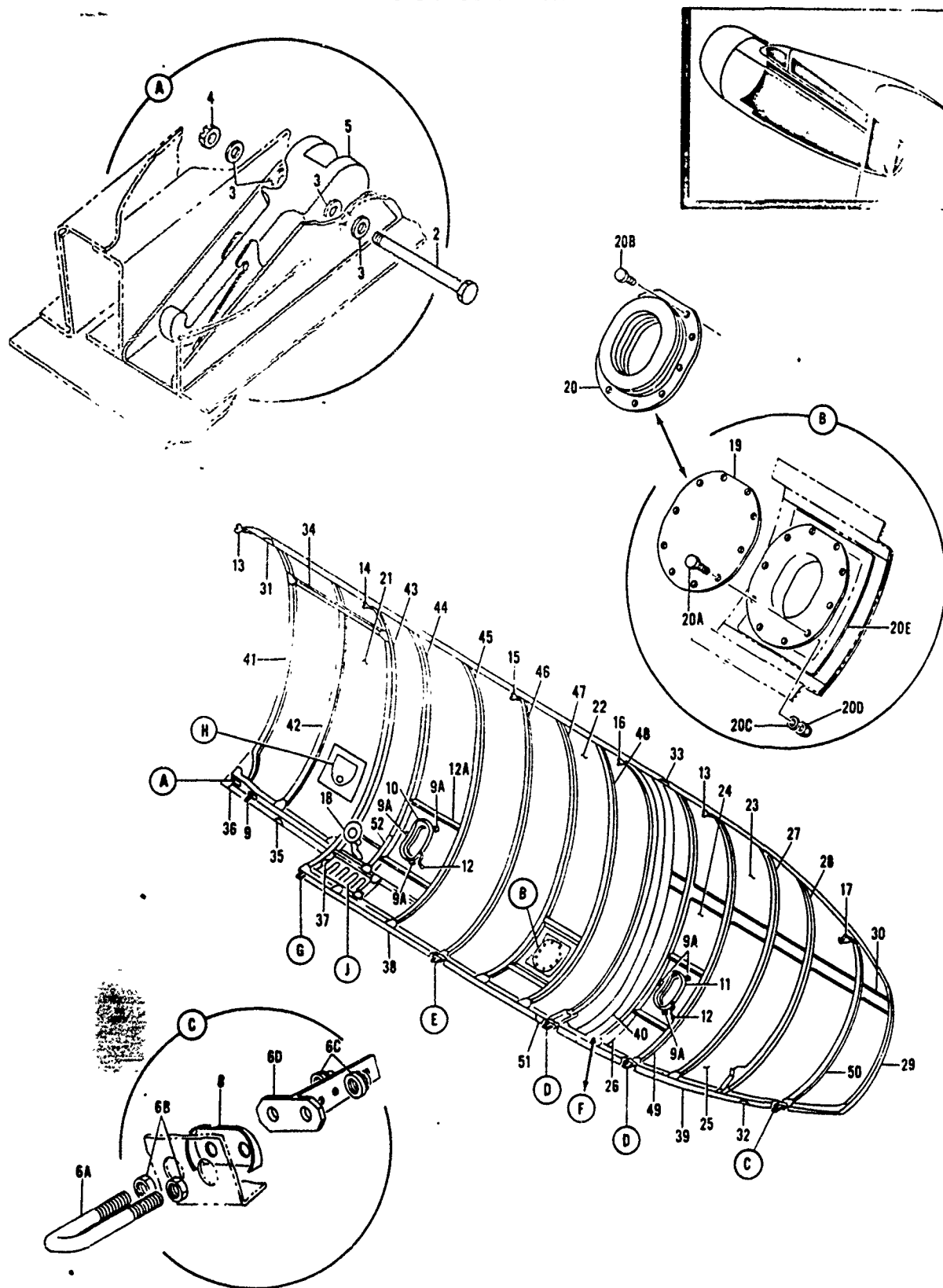


Figure 1102. Engine Nacelle Right-Hand Side Cowl Panel Assembly (Sheet 1 of 2)  
2-2890 Change 80

# FLOW PROCESS CHART

MABPAB

SUBJECT SIDE COWL PANEL - RH

DATE 4/4/89

PCN: 15113A

WCD: 15113A

WCDDATE: 88054

CHART BEGINS OPERATION 10 REC + UNCRATE

1 of 3

CHART ENDS " 940 CONDITION TAG PREPARED BY: R BOLANOS

| SYMBOLS | DESCRIPTION                                       | SYMBOLS | DESCRIPTION                           |
|---------|---|---------|---------------------------------------|
| 10      | RECEIVE & UNCRATE<br>2122 MABPAB                  | 210     | REP. FRAME #4                         |
|         | DELAY   | 220     | " " #5                                |
|         | MOVE TO WASH                                      | 230     | " " #6                                |
| 20      | WASH<br>MABPCA                                    | 240     | " " #7                                |
| 30      | STRIP   | 250     | " " #8                                |
| 40      | BLAST<br>DELAY<br>MOVE TO SHEETMETAL<br>95 MABPAB | 260     | " " #9                                |
|         | DELAY   | 270     | " " #10                               |
| 50      | VISUAL INSPECT                                    | 280     | " " #11                               |
|         | DELAY   | 290     | " " #12                               |
| 65      | TEARDOWN<br>DISASS                                | 300     | ASSEMBLE 60-4921 to 631               |
| 70      | REMOVE CORROSION                                  | 310     | REP FRAME #13                         |
|         | MOVE TO WELDING<br>3001 MATP IW                   | 320     | " #14                                 |
|         | DELAY   | 330     | " #15                                 |
| 75      | WELD  | 340     | REP. ANGLES                           |
|         | MOVE TO SHEETMETAL<br>95 MABPAB                   | 350     | BELLOWS SEALS                         |
|         | DELAY   | 360     | " "                                   |
| 80      | ASSEMBLE DOUBLER<br>& PLATE                       | 370     | DRILL 1, 2, 3, 4, 5,                  |
| 100     | REPAIR LONGERON 46<br>50% OF RIVETS               | 380     | REP. SKINS 1, 2, 3, 4, 5              |
| 110     | " " 84<br>50% OF RIVETS                           | 390     | PLACE COWLING ON FIXTURE              |
| 120     | " " 47<br>50% OF RIVETS                           | 400     | CLEAN & APPLY CORROSION<br>PROTECTIVE |
| 130     | ASSEMBLE 75 to 99                                 | 410     | REP. LONGERON 81                      |
| 140     | REPAIR LONGERON 99                                | 420     | REPAIR & ASSEMBLE #11 FRO             |
| 150     | ASSEMBLE 75 to 91                                 | 430     | POSITION #12 FRAME                    |
| 160     | REPAIR LONGERON 91                                | 440     | " #13 " ASSY.                         |
| 170     | " " 62  | 450     | " #14 "                               |
| 180     | " " FRAME #1                                      | 455     | " #15 "                               |
| 190     | " " #2  | 460     | REMOVE/REPLACE 15                     |
| 200     | " " #3  | 470     | POSITION #16                          |
|         |   | 480     | " #17                                 |

STEP 90 DELETED  
ON WCD/08ASS

# FLOW PROCESS CHART

MABPAB

SUBJECT SIDE COWL PANEL RH

DATE 4/4/89

PCN: 15113A WCD: 15113A WCDDATE: AB054

CHART BEGINS

2 of 3

CHART ENDS

PREPARED BY: R. B. B. B.

| SYMBOLS     | DESCRIPTION                             | SYMBOLS     | DESCRIPTION                              |
|-------------|---|-------------|--|
| 490 ● ◇ □ ▽ | POSITION # 18                           | 650 ● ◇ □ ▽ | FINAL INSTALL #28 DOUBLER 100% OF RIVETS |
| 500 ● ◇ □ ▽ | REMOVE + REPLACE #19                    | 655 ● ◇ □ ▽ | " " 99 LONGERON                          |
| 505 ● ◇ □ ▽ | POSITION #19                            | 660 ● ◇ □ ▽ | FIN. INSTALL #88 DOUBLER                 |
| 510 ● ◇ □ ▽ | POSITION # 20                           | 665 ● ◇ □ ▽ | " 91                                     |
| 515 ● ◇ □ ▽ | " " 21                                  | 670 ● ◇ □ ▽ | " #62 LONGERON                           |
| 520 ● ◇ □ ▽ | REM + REPLACE 21 of FRAME 39 ASSY       | 675 ● ◇ □ ▽ | " #2 FRAME                               |
| 525 ● ◇ □ ▽ | POSITION #22                            | 680 ● ◇ □ ▽ | " #3 FRAME                               |
| 530 ● ◇ □ ▽ | #23                                     | 685 ● ◇ □ ▽ | " #4 FRAME                               |
| 540 ● ◇ □ ▽ | # 24                                    | 690 ● ◇ □ ▽ | " #5 FRAME                               |
| 545 ● ◇ □ ▽ | REMOVE/REPLACE #24                      | 700 ● ◇ □ ▽ | " #6 FRAME                               |
| 550 ● ◇ □ ▽ | # 25                                    | 705 ● ◇ □ ▽ | " #7 FRAME                               |
| 560 ● ◇ □ ▽ | REPLACE # 1 SKIN                        | 710 ● ◇ □ ▽ | " #8 FRAME                               |
| 565 ● ◇ □ ▽ | " #2 SKIN                               | 715 ● ◇ □ ▽ | " #9 FRAME                               |
| 570 ● ◇ □ ▽ | " #3 SKIN                               | 720 ● ◇ □ ▽ | " #10 "                                  |
| 575 ● ◇ □ ▽ | " #4 SKIN                               | 725 ● ◇ □ ▽ | " #11 "                                  |
| 580 ● ◇ □ ▽ | " #5 SKIN                               | 730 ● ◇ □ ▽ | " #12 "                                  |
| 585 ● ◇ □ ▽ | SPLICE # 26                             | 735 ● ◇ □ ▽ | " #13 "                                  |
| 590 ● ◇ □ ▽ | BELLOWS                                 | 740 ● ◇ □ ▽ | " #14 "                                  |
| 595 ● ◇ □ ▽ | DOUBLER (REP/RPL)                       | 745 ● ◇ □ ▽ | " #15 "                                  |
| 600 ● ◇ □ ▽ | LOUVER                                  | 750 ● ◇ □ ▽ | REP/RPL FIREDOOR PAN 53                  |
| 605 ● ◇ □ ▽ | STARTER CARTRIDGE DOOR (REPAIR/REPLACE) | 755 ● ◇ □ ▽ | IN. ALL FIRE EXTINGUISHER DOOR           |
| 610 ● ◇ □ ▽ | REPLACE T ANGLES                        | 760 ● ◇ □ ▽ | R/R FIREDOOR PAN 52                      |
| 615 ● ◇ □ ▽ | REMOVE COWL FROM FIXTURE                | 765 ● ◇ □ ▽ | INSTALL FIRE EXTINGUISHER DOOR           |
| 620 ● ◇ □ ▽ | FINAL ASSEMBLY (NO TIME USE)            | 767 ○ ◇ □ ▽ | INSPECT                                  |
| 625 ● ◇ □ ▽ | INSTALL LONGERON 31 100% OF RIVETS      | 770 ● ◇ □ ▽ | R/R SPRING CLIPS                         |
| 630 ● ◇ □ ▽ | " " 37                                  | 775 ● ◇ □ ▽ | INSTALL VENT ASSY                        |
| 635 ● ◇ □ ▽ | " " 48                                  | 780 ● ◇ □ ▽ | INSTALL C/E SPEED DRIVER                 |
| 640 ● ◇ □ ▽ | " " 34                                  | 785 ● ◇ □ ▽ | INSTALL STARTER CARTRIDGE                |
| 645 ● ◇ □ ▽ | " " 47                                  | 790 ● ◇ □ ▽ | INSTALL STAINLESS STEEL PLATES           |

# FLOW PROCESS CHART

SUBJECT SIDE COWL PANEL R H

DATE 4/4/8

PCN: 15113A WCD: 15113A WCD DATE: 88055

CHART BEGIN: \_\_\_\_\_

CHART ENDS \_\_\_\_\_

PREPARED BY: R. Bolanos

3 of

| SYMBOLS       | DESCRIPTION                            | SYMBOLS       | DESCRIPTION           |
|---------------|--|---------------|-----------------------|
| 775 ● ◇ D □ ▽ | INSTALL CAP COVER                      | 940 ● ◇ D □ ▽ | COMPLETE CONSTRUCTION |
| 800 ● ◇ D □ ▽ | INSTALL DRAIN CAP                      | ○ ◇ D □ ▽     |                       |
| 805 ● ◇ D □ ▽ | INSTALL 3umpers                        | ○ ◇ D □ ▽     |                       |
| 810 ● ◇ D □ ▽ | " OIL BREATHER                         | ○ ◇ D □ ▽     |                       |
| 815 ● ◇ D □ ▽ | " PLATE S6                             | ○ ◇ D □ ▽     |                       |
| 820 ● ◇ D □ ▽ | " " 72                                 | ○ ◇ D □ ▽     |                       |
| 825 ● ◇ D □ ▽ | " SKIN #1                              | ○ ◇ D □ ▽     |                       |
| 830 ● ◇ D □ ▽ | " " 2                                  | ○ ◇ D □ ▽     |                       |
| 835 ● ◇ D □ ▽ | " " 3                                  | ○ ◇ D □ ▽     |                       |
| 840 ● ◇ D □ ▽ | " " 4                                  | ○ ◇ D □ ▽     |                       |
| 845 ● ◇ D □ ▽ | " " 5                                  | ○ ◇ D □ ▽     |                       |
| 850 ● ◇ D □ ▽ | " LACHES                               | ○ ◇ D □ ▽     |                       |
| 855 ● ◇ D □ ▽ | " HINGES #1 HOOK                       | ○ ◇ D □ ▽     |                       |
| 860 ● ◇ D □ ▽ | " " #2 "                               | ○ ◇ D □ ▽     |                       |
| 865 ● ◇ D □ ▽ | " " #3 "                               | ○ ◇ D □ ▽     |                       |
| 870 ● ◇ D □ ▽ | " " #4 "                               | ○ ◇ D □ ▽     |                       |
| 875 ● ◇ D □ ▽ | " " #5 "                               | ○ ◇ D □ ▽     |                       |
| 880 ● ◇ D □ ▽ | " " SPEAR                              | ○ ◇ D □ ▽     |                       |
| 890 ● ◇ D □ ▽ | DRILL ALL DRAIN HOLE                   | ○ ◇ D □ ▽     |                       |
| 895 ● ◇ D □ ▽ | INSTALL CLIPS AS REQ                   | ○ ◇ D □ ▽     |                       |
| 900 ● ◇ D □ ▽ | INSPECT COWLING                        | ○ ◇ D □ ▽     |                       |
| 905 ● ◇ D □ ▽ | SHAVE ALL HIGH RIVETS                  | ○ ◇ D □ ▽     |                       |
| 910 ○ ◇ D □ ▽ | INSPECT COWLING ALIGNMENT. ON FIXTURE  | ○ ◇ D □ ▽     |                       |
| 915 ● ◇ D □ ▽ | TRIM SKIN                              | ○ ◇ D □ ▽     |                       |
| 920 ● ◇ D □ ▽ | INSTALL ALIGNMENT PLATES & PINS        | ○ ◇ D □ ▽     |                       |
| ○ ◇ D □ ▽     | MOVE TO PAINT 2280 MABPCB              | ○ ◇ D □ ▽     |                       |
| 930 ● ◇ D □ ▽ | FINAL WASH, & TREAT FOR CORROSION      | ○ ◇ D □ ▽     |                       |
| 935 ● ◇ D □ ▽ | PAINT INTERIOR/EXT. INSTALL STANCHIONS | ○ ◇ D □ ▽     |                       |
| ○ ◇ D □ ▽     | MOVE TO SHEET METAL 95 MABPOB          | ○ ◇ D □ ▽     |                       |

| FIGURE & INDEX NO. | PART NUMBER     | DESCRIPTION  | QUANTITY PER ASSY | CODE |
|--------------------|-----------------|--|-------------------|------|
| 1101-              | 5-85637 -15025A | PANEL ASSY, LEFT HAND SIDE COWL, ENGINE NACELLE (FOR. . .<br>NHA SEE FIG. 1100)  | REF               | A    |
|                    | 35-32371-1      | PANEL ASSY, LEFT HAND SIDE COWL, ENGINE NACELLE (FOR. . .<br>NHA SEE FIG. 1100)  | REF               | A    |
| 1                  | 99836           | . PIN, COWL FASTNR (61864) (BACP18A5) . . . . .  | 1                 | A    |
| 2                  | 98265-2-.170    | . STUD, COWL FASTNR (61864) (BACS21B5FH17) . . . . .   | 1                 | A    |
| 3                  | 99947P.130      | . SPRING, COWL FASTNR, FLTG (61864) (BACS20A5P) . . . . .  | 1                 | A    |
| 4                  | MS20253-2-475   | . PIN . . . . .  | 1                 | A    |
| 5                  | 5-85637-114     | . HINGE, CONTINUOUS HALF, LEFT HAND SIDE COWL, ENGINE . .<br>NACELLE (ALTERED FROM MS20257H5-550)                          | 1                 | A    |
| 6                  | 5-85637-115     | . HINGE, CONTINUOUS HALF, LEFT HAND SIDE COWL, ENGINE . .<br>NACELLE (ALTERED FROM MS20257H5-600)                          | 1                 | A    |
| 7                  | 5-85637-112     | . DOOR ASSY, PANEL, LEFT HAND SIDE COWL, ENGINE NACELLE .  | 1                 | A    |
| 8                  | 90-7988         | . SEAL, MOLDED RUBBER, ENGINE OIL TANK OIL SCUPPER. . . .<br>(SPEC MIL-R-6855 CLASS I GRADE 40, 40 DUROMETER)              | 1                 | A    |
| 8A                 | 5-85637-82      | . DUCT ASSY, PANEL, LEFT HAND SIDE COWL, ENGINE NACELLE .  | 1                 | A    |
| 9                  | NAS1103-23W     | . BOLT (FOR REPLACEMENT ORDER NAS1103-23) . . . . .  | 1                 | A    |
| 10                 | NAS1103-24W     | . BOLT (FOR REPLACEMENT ORDER NAS1103-24) . . . . .  | 1                 | A    |
| 11                 | NAS1103-22W     | . BOLT (FOR REPLACEMENT ORDER NAS1103-22) . . . . .  | 3                 | A    |
| 12                 | NAS1103-21W     | . BOLT (FOR REPLACEMENT ORDER NAS1103-21) . . . . .  | 1                 | A    |
| 13                 | AN960D10L       | . WASHER. . . . .  | 24                | A    |
| 14                 | AN320-3         | . NUT . . . . .  | 6                 | A    |
| 15                 | H28-3           | . LATCH ASSY, TOGGLE HOOK, ENGINE NACELLE COWL PANEL. . .<br>(83014) (ALTERNATE 24L1-3 (71286)) (BOEING SPEC<br>10-2731-4) | 1                 | A    |
| 16                 | H28-2           | . LATCH ASSY, TOGGLE HOOK, ENGINE NACELLE COWL PANEL. . .<br>(83014) (ALTERNATE 24L1-2 (71286)) (BOEING SPEC<br>10-2731-2) | 2                 | A    |
| 17                 | H28-1           | . LATCH ASSY, TOGGLE HOOK, ENGINE NACELLE COWL PANEL. . .<br>(83014) (ALTERNATE 24L1 (71286)) (BOEING SPEC<br>10-2731-1)   | 2                 | A    |
| 18                 | H40-1           | . LATCH ASSY, TOGGLE HOOK, ENGINE NACELLE COWL PANEL. . .<br>(83014) (ALTERNATE 26L1 (71286)) (BOEING SPEC<br>10-2731-3)   | 1                 | A    |
| 19                 | 60-4019         | . PIN, SHEAR, ENGINE NACELLE COWL PANEL (WHEN EXHAUSTED .<br>USE 66-4025)  | 1                 | A    |
| 19                 | 66-4025         | . PIN, SHEAR, ENGINE NACELLE COWL PANEL . . . . .<br>(ATTACHING PARTS)   | 1                 | A    |
|                    | NAS679A4W       | . NUT . . . . .  | 1                 | A    |
| 20                 | 3-74649         | . PIN, SHEAR, COWL. . . . .  | 2                 | A    |
| 20A                | 3-74649         | . PIN, SHEAR, COWL. . . . .  | 2                 | A    |
| 20B                | 66-18062-1      | . PIN, ALIGNING, ENGINE NACELLE COWL PANEL. . . . .<br>(ATTACHING PARTS)   | 2                 | A    |
|                    | AN960D416       | . WASHER. . . . .  | 4                 | A    |
|                    | NAS679A4W       | . NUT . . . . .  | 4                 | A    |
| 21                 | 5-96762         | . HOOK, HINGE, NACELLE COWLING. . . . .  | 2                 | A    |
| 22                 | 5-96766         | . HOOK, HINGE, NACELLE COWLING. . . . .  | 1                 | A    |
| 23                 | 5-96766-1       | . HOOK, HINGE, NACELLE COWLING. . . . .  | 1                 | A    |
| 24                 | 5-96766-2       | . HOOK, HINGE, NACELLE COWLING. . . . .<br>(ATTACHING PARTS)   | 1                 | A    |
|                    | AN5-10A         | . BOLT (ALTERNATE BACB30NE5-9). . . . .  | 4                 | A    |
|                    | NAS1105-9W      | . BOLT (ALTERNATE NAS1105-9). . . . .  | 1                 | A    |
|                    | AN960-516L      | . WASHER. . . . .  | 10                | A    |
|                    | MS21042L5       | . NUT (REPLACES NAS679A5) . . . . .  | 5                 | A    |
|                    | AN3-7A          | . BOLT (FOR REPLACEMENT ORDER BACB30NF3-8). . . . .  | 5                 | A    |
|                    | AN960-10L       | . WASHER. . . . .  | 5                 | A    |
|                    | NAS679A3W       | . NUT . . . . .  | 5                 | A    |
| 24A                | AN7510F2        | . NAMEPLATE . . . . .  | 1                 | A    |
| 25                 | 5-96719         | . HINGE, SPEAR, ENGINE NACELLE COWL PANEL (FOR I/W INFO .<br>SEE 5-96719-2)  | 1                 | A    |
| 25                 | 5-96719-2       | . HINGE SPEAR, ENGINE NACELLE COWL PANEL. . . . .<br>(ATTACHING PARTS)   | 1                 | A    |
|                    | AN4-10A         | . BOLT (ALTERNATE BACB30NE4-9). . . . .  | 1                 | A    |
|                    | AN960-416       | . WASHER. . . . .  | 1                 | A    |
|                    | AN960-416L      | . WASHER. . . . .  | 1                 | A    |
|                    | MS21042-4       | . NUT (REPLACES AN363-428). . . . .  | 1                 | A    |
|                    | AN3-7A          | . BOLT (FOR REPLACEMENT ORDER BACB30NF3-8). . . . .  | 1                 | A    |
|                    | AN960-10        | . WASHER. . . . .  | 1                 | A    |
|                    | AN960-10L       | . WASHER. . . . .  | 1                 | A    |
|                    | NAS679A3W       | . NUT . . . . .  | 1                 | A    |

# Power Plant

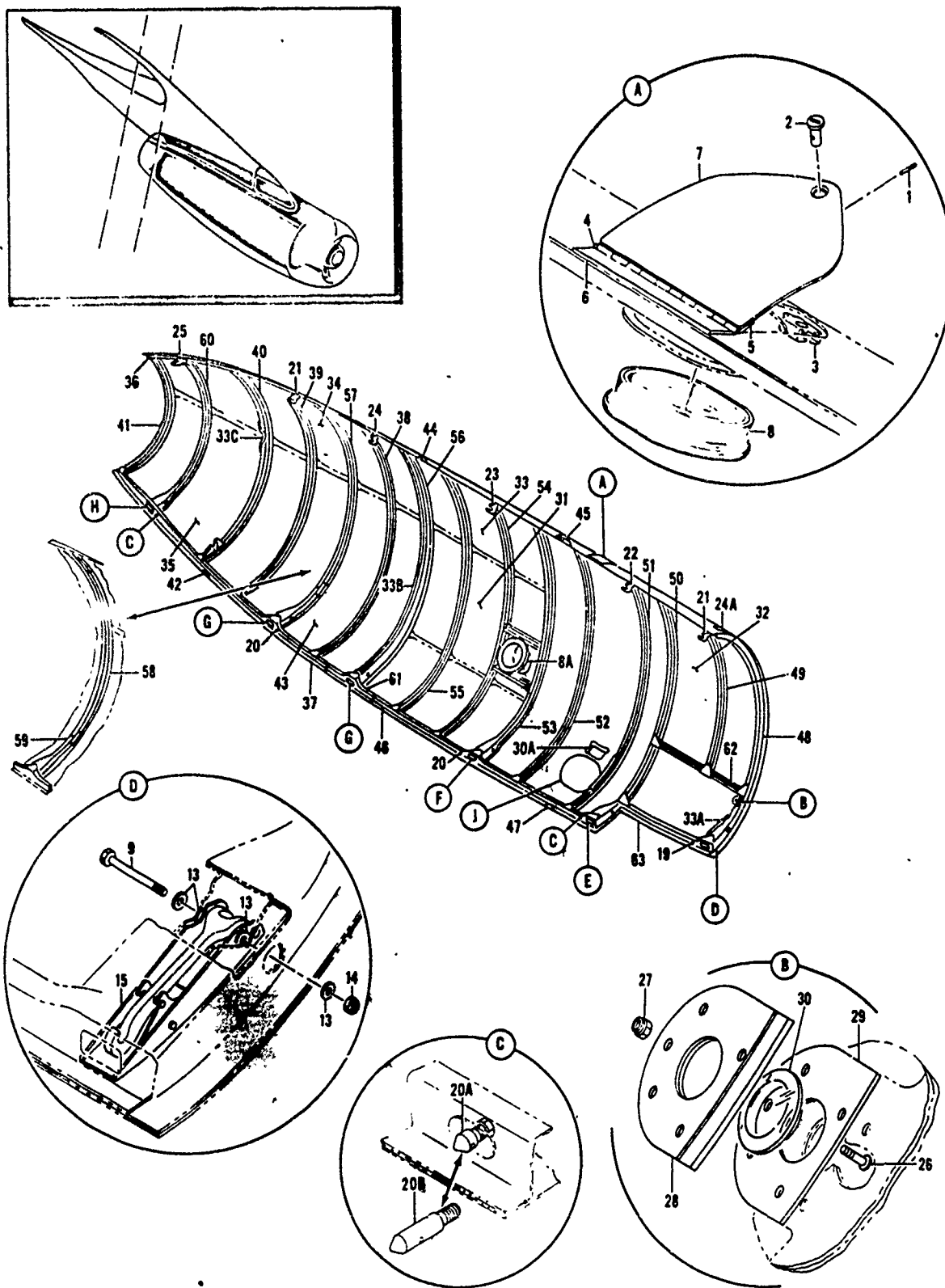


Figure 1101. Engine Nacelle Left Hand Side Cowl Panel Assembly (Sheet 1 of 2)

## Power Plant

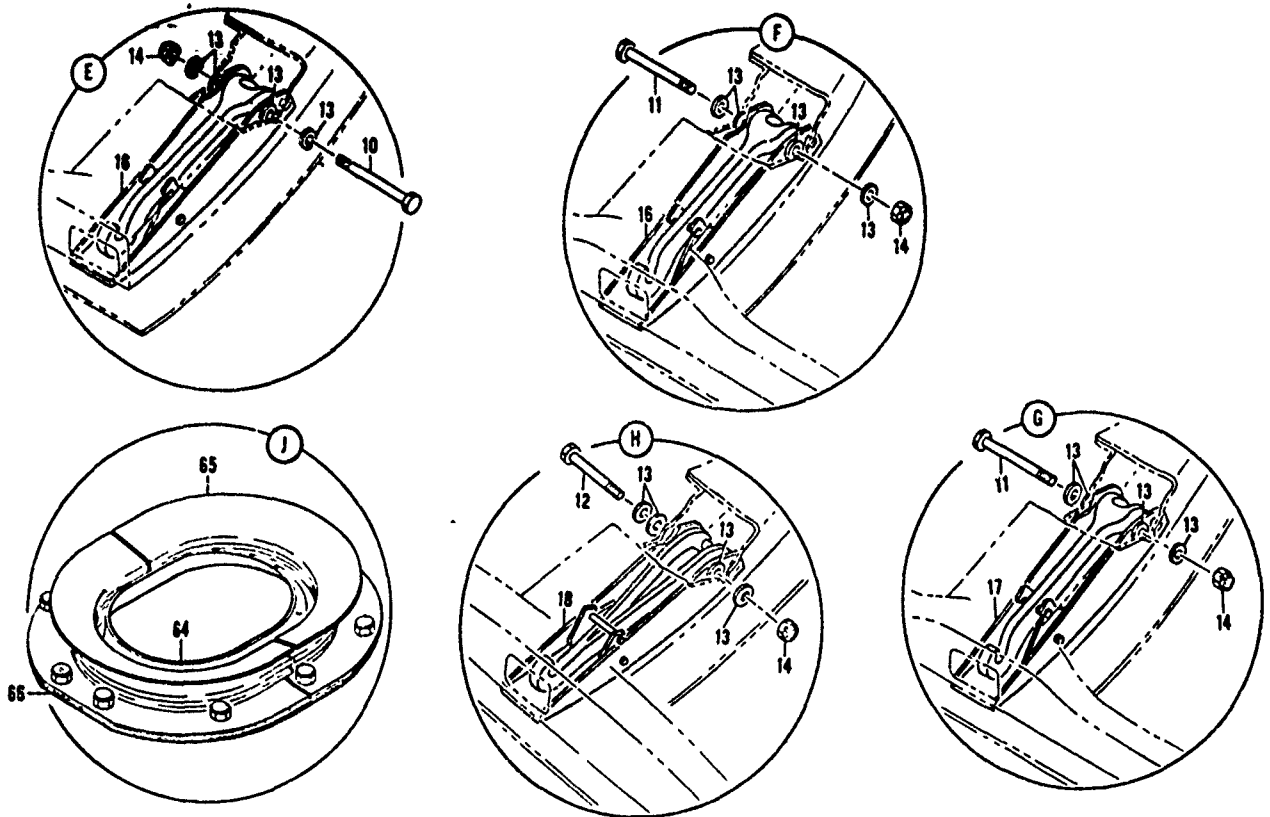


Figure 1101. Engine Nacelle Left Hand Side Cowl Panel Assembly (Sheet 2 of 2)

| FIGURE &<br>INDEX NO. | PART NUMBER   | DESCRIPTION |   |   |   |   |   |   | UNITS<br>PER<br>ASSY | USE<br>ON<br>CODE |
|-----------------------|---------------|-------------|---|---|---|---|---|---|----------------------|-------------------|
|                       |               | 1           | 2   | 3 | 4 | 5 | 6 | 7 |                      |                   |
| 1101-                 |               |             |   |   |   |   |   |   |                      |                   |
| 26                    | NAS514P1032-8 | .           | SCREW . . . . .   |   |   |   |   |   | 5                    | A                 |
| 27                    | NAS679A3W     | .           | NUT . . . . .   |   |   |   |   |   | 5                    | A                 |
| 28                    | 5-85637-126   | .           | RETAINER ASSY, PANEL, LEFT HAND SIDE COWL, ENGINE . . . . |   |   |   |   |   | 1                    | A                 |
|                       |               |             | NACELLE   |   |   |   |   |   |                      |                   |
| 29                    | 5-85637-128   | .           | RING, FILLER, LEFT HAND SIDE COWL PANEL, ENGINE . . . .   |   |   |   |   |   | 1                    | A                 |
|                       |               |             | NACELLE   |   |   |   |   |   |                      |                   |
| 30                    | 66-3355       | .           | WINDOW, SIGHTING, AIR BOTTLE GAGE, ENGINE NACELLE . . . . |   |   |   |   |   | 1                    | A                 |
| 30A                   | BACM10L1DWY   | .           | METAL-CAL, LEGEND . . . . .                               |   |   |   |   |   | 1                    | B                 |
| 31                    | 5-85637-6     | .           | SKIN, PATCH, LEFT HAND SIDE COWL PANEL, ENGINE. . . . .   |   |   |   |   |   | 1                    | A                 |
|                       |               |             | NACELLE   |   |   |   |   |   |                      |                   |
| 32                    | 5-85637-1     | .           | SKIN, FORWARD, LEFT HAND SIDE COWL PANEL, ENGINE. . . .   |   |   |   |   |   | 1                    | A                 |
|                       |               |             | NACELLE   |   |   |   |   |   |                      |                   |
| 33                    | 5-85637-2     | .           | SKIN, MIDDLE, LEFT HAND SIDE COWL PANEL, ENGINE . . . .   |   |   |   |   |   | 1                    | A                 |
|                       |               |             | NACELLE   |   |   |   |   |   |                      |                   |
| 33A                   | 5-85637-120   | .           | FRAME ASSY, PANEL, LEFT HAND SIDE COWL, ENGINE. . . . .   |   |   |   |   |   | 1                    | A                 |
|                       |               |             | NACELLE   |   |   |   |   |   |                      |                   |
| 33B                   | 5-85637-91    | .           | FRAME ASSY, PANEL, LEFT HAND SIDE COWL, ENGINE. . . . .   |   |   |   |   |   | 1                    | A                 |
|                       |               |             | NACELLE   |   |   |   |   |   |                      |                   |
| 33C                   | 60-4921       | .           | ANGLE, REINFORCING, ENGINE NACELLE COWLING. . . . .       |   |   |   |   |   | 1                    | A                 |
|                       | 5-85637-68    | .           | FRAME AND SKIN ASSY, PANEL LH SIDE COWL ENGINE. . . . .   |   |   |   |   |   | 1                    | A                 |
|                       |               |             | NACELLE   |   |   |   |   |   |                      |                   |
|                       | 5-85637-136   | .           | FRAME AND SKIN ASSY, PANEL, LEFT HAND SIDE COWL, . . . .  |   |   |   |   |   | 1                    | A                 |
|                       |               |             | ENGINE NACELLE  |   |   |   |   |   |                      |                   |
| 34                    | 5-85637-4     | .           | SKIN, UPPER AFT, LEFT HAND SIDE COWL PANEL, ENGINE. . . . |   |   |   |   |   | 1                    | A                 |
|                       |               |             | NACELLE   |   |   |   |   |   |                      |                   |
| 35                    | 5-85637-5     | .           | SKIN, AFT, LEFT HAND SIDE COWL PANEL, ENGINE. . . . .     |   |   |   |   |   | 1                    | A                 |
|                       |               |             | NACELLE   |   |   |   |   |   |                      |                   |



Section II  
Group Assembly Parts List

T.O. 1C-135A-4

| FIGURE &<br>INDEX NO. | PART NUMBER | DESCRIPTION  | UNITS<br>PER<br>ASSY | USE<br>ON<br>CODE |
|-----------------------|-------------|--|----------------------|-------------------|
|                       |             | 1 2 3 5 6 7  |                      |                   |
| 1101-                 |             |  |                      |                   |
| 36                    | 5-85637-8   | . . LONGERON, UPPER AFT, LEFT HAND SIDE COWL PANEL, . . .<br>ENGINE NACELLE  | 1                    | A                 |
| 37                    | 5-85637-10  | . . LONGERON, LOWER AFT, LEFT HAND SIDE COWL PANEL, . . .<br>ENGINE NACELLE  | 1                    | A                 |
| 38                    | 5-85637-20  | . . FRAME, PANEL STATION 180.00, LEFT HAND SIDE COWL, . .<br>ENGINE NACELLE  | 1                    | A                 |
| 39                    | 5-85637-22  | . . FRAME, PANEL STATION 200.00, LEFT HAND SIDE COWL, . .<br>ENGINE NACELLE  | 1                    | A                 |
| 40                    | 5-85637-23  | . . FRAME, PANEL STATION 210.00, LEFT HAND SIDE COWL, . .<br>ENGINE NACELLE  | 1                    | A                 |
| 41                    | 5-85637-25  | . . FRAME, PANEL STATION 235.00, LEFT HAND SIDE COWL, . .<br>ENGINE NACELLE  | 1                    | A                 |
| 42                    | 5-85637-37  | . . DOUBLER, PANEL, LEFT HAND SIDE COWL, ENGINE NACELLE .                    | 1                    | A                 |
| 43                    | 5-85637-3   | . SKIN, LOWER AFT, LEFT HAND SIDE COWL PANEL, ENGINE. . .<br>NACELLE         | 1                    | A                 |
|                       | 5-85637-98  | . LONGERON ASSY, PANEL, LEFT HAND SIDE COWL, ENGINE . . .<br>NACELLE         | 1                    | A                 |
| 44                    | 5-85637-7   | . . LONGERON, UPPER FORWARD, LEFT HAND SIDE COWL PANEL, .<br>ENGINE NACELLE  | 1                    | A                 |
| 45                    | 5-85637-27  | . . DOUBLER, PANEL, LEFT HAND SIDE COWL, ENGINE NACELLE .                    | 1                    | A                 |
|                       | 5-85637-100 | . LONGERON ASSY, PANEL, LEFT HAND SIDE COWL, ENGINE . . .<br>NACELLE         | 1                    | A                 |
| 46                    | 5-85637-9   | . . LONGERON, LOWER FORWARD, LEFT HAND SIDE COWL PANEL. .<br>ENGINE NACELLE  | 1                    | A                 |
| 47                    | 5-85637-33  | . . DOUBLER, PANEL, LEFT HAND SIDE COWL, ENGINE NACELLE .                    | 1                    | A                 |
|                       | 5-85637-59  | . FRAME ASSY, PANEL, LEFT HAND SIDE COWL, ENGINE. . . .<br>NACELLE           | 1                    | A                 |
| 48                    | 5-85637-11  | . . FRAME, PANEL STATION 89.50, LEFT HAND SIDE COWL, . . .<br>ENGINE NACELLE | 1                    | A                 |
| 49                    | 5-85637-12  | . FRAME, PANEL STATION 100.43, LEFT HAND SIDE COWL, . . .<br>ENGINE NACELLE  | 1                    | A                 |
|                       | 5-85637-60  | . FRAME ASSY, PANEL, LEFT HAND SIDE COWL, ENGINE. . . .<br>NACELLE           | 1                    | A                 |
| 50                    | 5-85637-13  | . . FRAME, PANEL STATION 112.50, LEFT HAND SIDE COWL. . .<br>ENGINE NACELLE  | 1                    | A                 |
|                       | 5-85637-81  | . FRAME ASSY, PANEL, LEFT HAND SIDE COWL, ENGINE. . . .<br>NACELLE           | 1                    | A                 |
| 51                    | 5-85637-14  | . . FRAME, PANEL STATION 120.00, LEFT HAND SIDE COWL. . .<br>ENGINE NACELLE  | 1                    | A                 |
| 52                    | 5-85637-15  | . FRAME, PANEL STATION 131.50, LEFT HAND SIDE COWL. . . .<br>ENGINE NACELLE  | 1                    | A                 |
|                       | 5-85637-61  | . FRAME ASSY, PANEL, LEFT HAND SIDE COWL, ENGINE. . . .<br>NACELLE           | 1                    | A                 |
| 53                    | 5-85637-16  | . . FRAME, PANEL STATION 142.80, LEFT HAND SIDE COWL, . .<br>ENGINE NACELLE  | 1                    | A                 |
| 54                    | 5-85637-17  | . FRAME, PANEL STATION 152.75, LEFT HAND SIDE COWL, . . .<br>ENGINE NACELLE  | 1                    | A                 |
| 55                    | 5-85637-18  | . FRAME, PANEL STATION 161.50, LEFT HAND SIDE COWL, . . .<br>ENGINE NACELLE  | 1                    | A                 |
|                       | 5-85637-62  | . FRAME ASSY, PANEL, LEFT HAND SIDE COWL, ENGINE. . . .<br>NACELLE           | 1                    | A                 |
| 56                    | 5-85637-19  | . . FRAME, PANEL STATION 171.20, LEFT HAND SIDE COWL, . .<br>ENGINE NACELLE  | 1                    | A                 |
|                       | 5-85637-63  | . FRAME ASSY, PANEL, LEFT HAND SIDE COWL, ENGINE. . . .<br>NACELLE           | 1                    | A                 |
| 57                    | 5-87637-21  | . . FRAME PANEL STATION 190.00 LEFT HAND SIDE COWL, . . .<br>ENGINE NACELLE  | 1                    | A                 |
| 58                    | 5-85637-814 | . . FRAME, PANEL STATION 190.00, LEFT HAND SIDE COWL, . .<br>ENGINE NACELLE  | 1                    | A                 |

| FIGURE &<br>INDEX NO. | PART NUMBER   | DESCRIPTION  | 1 2 3 4 5 6 7 |  |  |  |  |  |  | UNITS<br>PER<br>ASSY | USE<br>ON<br>COU |
|-----------------------|---------------|--|---------------|--|--|--|--|--|--|----------------------|------------------|
|                       |               |  |               |  |  |  |  |  |  |                      |                  |
| 1101-<br>59           | 5-85637-815   | . . FRAME, PANEL STATION 190.00, LEFT HAND SIDE COWL, . .<br>ENGINE NACELLE                                  |               |  |  |  |  |  |  | 1                    | A                |
|                       | 5-85637-64    | . FRAME ASSY, LEFT HAND SIDE COWL, ENGINE NACELLE . . . .<br>(WHEN EXHAUSTED USE 5-85637-137)                |               |  |  |  |  |  |  | 1                    | A                |
|                       | 5-85637-137   | . FRAME ASSY, PANEL, LEFT HAND SIDE COWL, ENGINE. . . . .<br>NACELLE   |               |  |  |  |  |  |  | 1                    | A                |
| 60                    | 5-85637-134   | . . FRAME, PANEL STATION 225.00, LEFT HAND SIDE COWL, . .<br>ENGINE NACELLE                                  |               |  |  |  |  |  |  | 1                    | A                |
|                       | 5-85637-113   | . SEGMENT ASSY, LONGERON, LEFT HAND SIDE COWL PANEL, . . .<br>ENGINE NACELLE                                 |               |  |  |  |  |  |  | 1                    | A                |
| 61                    | 5-85637-32    | . . SEGMENT, LONGERON, LEFT HAND SIDE COWL PANEL, . . . .<br>ENGINE NACELLE                                  |               |  |  |  |  |  |  | 1                    | A                |
| 62                    | 5-85637-89    | . LONGERON, PANEL, LEFT HAND SIDE COWL, ENGINE NACELLE. .  |               |  |  |  |  |  |  | 1                    | A                |
|                       | 5-85637-99    | . LONGERON ASSY, PANEL, LEFT HAND SIDE COWL, ENGINE . . .<br>NACELLE   |               |  |  |  |  |  |  | 1                    | A                |
| 63                    | 5-85637-88    | . . LONGERON, PANEL, LEFT HAND SIDE COWL, ENGINE. . . . .<br>NACELLE   |               |  |  |  |  |  |  | 1                    | A                |
| 64                    | 90-3343-2     | . DUCT, FUEL AIR STARTER EXHAUST. . . . .<br>(ATTACHING PARTS)   |               |  |  |  |  |  |  | 1                    | A                |
|                       | NAS514P1032-6 | . SCREW . . . . .  |               |  |  |  |  |  |  | 10                   | A                |
|                       | MS21042L3     | . NUT . . . . .  |               |  |  |  |  |  |  | 10                   | A                |
| 65                    | 1200874-10    | . SEAL ASSY, FUEL AIR STARTER EXHAUST BELLOWS (98769) . .<br>(BAC SPEC NO. 10-2748-11) (OPTIONAL 65-32834-1) |               |  |  |  |  |  |  | 1                    | A                |
| 66                    | 69-22576-1    | . SEAL, STARTER EXHAUST EXIT GASKET . . . . .  |               |  |  |  |  |  |  | 1                    | A                |
|                       |               | A 2201 THRU 2299, 3001 THRU 3015<br>B 2201 THRU 2299<br><br>ALSO SEE FIGURE 1132                             |               |  |  |  |  |  |  |                      |                  |

# FLOW PROCESS CHART

SUBJECT Left Hand Side Cowl

DATE 4/4/89

PCN: 15025A WCD: 15025A WCDDATE: 88054

CHART BEGINS Operation 10

CHART ENDS Operation 990

PREPARED BY: Tim Hall

| SYMBOLS | DESCRIPTION                         | SYMBOLS | DESCRIPTION                          |
|---------|-------------------------------------|---------|--------------------------------------|
| 010     | Receive and Unload<br>2122 MABPCD   | 250     | Repair or replace<br>Frame #15       |
|         | Delay                               | 260     | Replace clips as required            |
|         | Move to MABPCA                      |         | Delay                                |
|         | 2122 MABPCA                         |         | Move to 3001                         |
|         | Delay                               |         | 3001 MATPAW                          |
| 020     | Wash interior & exterior            |         | Delay                                |
| 030     | Strip all paint                     | 270     | Weld as required                     |
| 040     | Abrasive blast                      |         | Delay                                |
|         | Delay                               |         | Move to Bldg 95                      |
|         | Move to Bldg 95                     |         | 95 MABPAB                            |
|         | Delay                               |         | Delay                                |
| 050     | Visual inspection                   | 280     | Repair or replace<br>Longeron (-8)   |
| 065     | Teardown                            | 290     | Install Spring Clip<br>60-2566-40    |
| 070     | Remove & Treat Corrosion            | 300     | Repair or replace<br>Longeron        |
| 080     | Remove Hooks & Latches              | 310     | Install Hooks                        |
| 090     | Remove Fuel Starter<br>Exhaust Assy | 320     | Replace sc91                         |
| 100     | Repair or replace<br>Frame #2       | 330     | Replace Door Frame (-11)             |
| 110     | Repair or replace<br>Longeron       | 340     | Repair door Assy -112                |
| 120     | Repair or replace<br>Frame #3       | 345     | Repair Longeron -10                  |
| 130     | Repair or replace<br>Frame #4       | 350     | Repair or replace Longeron<br>(-113) |
| 140     | Repair or replace<br>Frame #5       | 360     | Repair or replace Longeron<br>(-100) |
| 150     | Repair or replace<br>Frame #6       | 370     | Repair or replace Latches            |
|         | Repair or replace<br>Frame #7       | 380     | Install Pin Plates                   |
|         | Repair or replace<br>Frame #8       | 390     | Remove steel mounting<br>plate (-77) |
| 160     | " "                                 | 400     | Repair or replace Duct               |
| 170     | Firewall Assy                       | 410     | Replace basket                       |
| 180     | Fireseal                            | 420     | Replace seal bellows                 |
| 190     | " "                                 | 430     | Replace vent                         |
| 200     | Frame #10                           | 440     | Replace duct Assy                    |
| 210     | Frame #11                           | 450     | Remove #1 Frame                      |
| 220     | Frame #12                           | 460     | Replace Longeron -99                 |
| 230     | Frame #13                           | 470     | Drill skins out as<br>required       |
| 240     | Frame #14                           |         |                                      |

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12. ORIG/PROD NR 13. QUANTITY 14. PROD SECTION/ROC 15. DATE SCHD 16. DATE COMP

15025A 1 MBPAB 89093

\*\*\*\*\*

17. PART NUMBER 19. ITEM SERIAL NR 18/12. TECH DATA/OPTIONAL

35-32371-1 1 SOW OC1560FL-82-174

\*\*\*\*\*

10. MODEL/DESIGN/SERIES 11. STOCK NR 1.0. 1-1A 1

135 1560005205602FL 1.0. 1-1-2

\*\*\*\*\*

13. MISC 14. NOON/END ITEM NOON 1.0. 1C-135(K)A-3-4

1 LEFT HAND SIDE COWL 1.0. 1C-135(K)A-3-4

\*\*\*\*\*

LARRY MULLINAX/MABLEBS/65268

\*\*\*\*\*

15. DISP-16. PDN/

\*\*\*\*\*

17. WORK TO BE ACCOMPLISHED 18. MECH 19. 20. 21. 22.

|      |       |  |  |   |   |
|------|-------|--|--|---|---|
| 2122 | 010   | RECEIVE AND UNCRATE SIDE COWL. NOTE:       |  |   |   |
|      | MBPAB | OBSERVE CAUTION THAT SIDE COWL IS          |  |   |   |
|      |       | NOT DAMAGED DURING UNCRATING.              |  |   |   |
| 2122 | 020   | WASH INTERIOR AND EXTERIOR IAW             |  | / | / |
|      | MBPCA | 1.0. 1C-135(K)A-3-4 PARA 11-7              |  |   |   |
|      |       | AND SOW OC1560-82-174.                     |  |   |   |
| 2122 | 030   | STRIP ALL INTERIOR AND EXTERIOR            |  | / | / |
|      | MBPCA | PAINT FROM SIDE COWL IAW 1.0.              |  |   |   |
|      |       | 1C-135(K)A-3-4. PARA 11-15 & SOW           |  |   |   |
|      |       | OC1560-82-174.                             |  |   |   |
| 2122 | 040   | ABRASIVE BLAST SIDE COWL IAW 1.0.          |  | / | / |
|      | MBPCA | 1C-135(K)A-3-4 UIC 9 AND 1.0.              |  |   |   |
|      |       | 1-1-2.                                     |  |   |   |
| 95   | 050   | ACCOMPLISH VISUAL INSPECTION IAW           |  | / | / |
|      | MBPAB | SOW 82-174                                 |  |   |   |
| 95   | 065   | TEARDOWN                                   |  | / | / |
|      | MBPAB | NOTE: DEPOT OVERHAUL OF J-57 LEFT          |  |   |   |
|      |       | HAND SIDE COWL WILL BE DONE                |  |   |   |
|      |       | IN ACCORDANCE WITH INSTRUCTIONS            |  |   |   |
|      |       | CONTAINED IN SOW OC1560-82-174             |  |   |   |
|      |       | AND 1C-135(K)A-3-4.                        |  |   |   |
| 95   | 070   | REMOVE CORROSION AND APPLY                 |  | / | / |
|      | MBPAB | CORROSION PROTECTIVE FINISH TO             |  |   |   |
|      |       | ALL REWORKED SURFACES IAW 1.0.             |  |   |   |
|      |       | 1C-135(K)A-3-4 AND 1.0. 1-1-2              |  |   |   |
| 95   | 080   | REMOVE HOOKS AND LATCHES                   |  | / | / |
|      | MBPAB | REQ'D _____ NOT REQ'D _____                |  |   |   |
| 95   | 090   | REMOVE FUEL STARTER EXHAUST ASSY           |  | / | / |
|      | MBPAB | P/N 90-3343-2                              |  |   |   |
|      |       | REQ'D _____ NOT REQ'D _____                |  |   |   |
| 95   | 100   | FRAME #2 (-12)                             |  | / | / |
|      | MBPAB | REPAIR _____ REPLACE _____ NOT REQ'D _____ |  |   |   |
| 95   | 110   | LONGERON (-89)                             |  | / | / |
|      | MBPAB | REPAIR _____ REPLACE _____ NOT REQ'D _____ |  |   |   |

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# FLOW PROCESS CHART

SUBJECT Left Hand Side Cowling

DATE 4/4/89

PCN: 1502SAWCD: 1502SAWCD DATE: 89081

CHART BEGINS \_\_\_\_\_

CHART ENDS \_\_\_\_\_

PREPARED BY: Tim Hall

770 'step deleted'

| SYMBOLS       | DESCRIPTION                                       | SYMBOLS       | DESCRIPTION  |
|---------------|---|---------------|--|
| 480 ● ◊ ◊ ◊ ◊ | Place Cowling in Fixture                          | 760 ● ◊ ◊ ◊ ◊ | Attach (-99) longeron to angle of -59 & -60 Frames       |
| 490 ● ◊ ◊ ◊ ◊ | Replace -99 Longerons                             | 780 ● ◊ ◊ ◊ ◊ | Install tabs at end of -100 & -99 longerons              |
| 500 ● ◊ ◊ ◊ ◊ | Replace #1 Frame, doubler and latch throat        | 790 ● ◊ ◊ ◊ ◊ | Install -80S guide plate to -60 frame                    |
| 510 ● ◊ ◊ ◊ ◊ | Attach -89 longeron to -60 frame                  | 800 ● ◊ ◊ ◊ ◊ | Install alignment pins & plates in longerons             |
| 520 ● ◊ ◊ ◊ ◊ | Repair or replace #1 Latch                        | 810 ● ◊ ◊ ◊ ◊ | Drill rivet patterns in new longerons                    |
| 521 ● ◊ ◊ ◊ ◊ | Replace #1 Hook S-96762                           | 820 ● ◊ ◊ ◊ ◊ | Double countersink & install rivets in longerons         |
| 530 ● ◊ ◊ ◊ ◊ | Replace Hinge Spur S-96719                        | 830 ● ◊ ◊ ◊ ◊ | Install tabs at end of -98 longerons                     |
| 540 ● ◊ ◊ ◊ ◊ | Tack Doublers to Longerons                        | 840 ● ◊ ◊ ◊ ◊ | Send excess rivet butts on interior of longerons to -55f |
| 550 ● ◊ ◊ ◊ ◊ | Locate & tack Fuel air exhaust 983V               | 850 ● ◊ ◊ ◊ ◊ | Install rivets & spacers aft end of longeron             |
| 560 ● ◊ ◊ ◊ ◊ | Tack -111 duct frame in place                     | 860 ● ◊ ◊ ◊ ◊ | Countersink & install rivets in all new skins            |
| 570 ● ◊ ◊ ◊ ◊ | Remove & replace -1 skin                          | 930 ● ◊ ◊ ◊ ◊ | Install bumpers, aft of -25 frame                        |
| 580 ● ◊ ◊ ◊ ◊ | Trim -1 skin                                      | 940 ● ◊ ◊ ◊ ◊ | Inspect cowling  |
| 590 ● ◊ ◊ ◊ ◊ | Remove & replace -6 skin                          | 950 ● ◊ ◊ ◊ ◊ | Shave all high rivets in skins                           |
| 600 ● ◊ ◊ ◊ ◊ | Remove & replace -2 skin                          | 960 ● ◊ ◊ ◊ ◊ | Place cowling in alignment fixture                       |
| 610 ● ◊ ◊ ◊ ◊ | Remove & replace Vent Louver                      | ○ ◊ ◊ ◊ ◊     | Delay  |
| 620 ● ◊ ◊ ◊ ◊ | Remove & replace -810 Doubler                     | ○ ◊ ◊ ◊ ◊     | Move to Bldg 2280  |
| 630 ● ◊ ◊ ◊ ◊ | Remove & replace -4 skin                          | ○ ◊ ◊ ◊ ◊     | 2280 MABPAB  |
| 640 ● ◊ ◊ ◊ ◊ | Remove & replace -3 skin                          | ○ ◊ ◊ ◊ ◊     | Delay  |
| 650 ● ◊ ◊ ◊ ◊ | Remove & replace -5 skin                          | 970 ● ◊ ◊ ◊ ◊ | Final Wash and Treat for corrosion                       |
| 660 ● ◊ ◊ ◊ ◊ | Shut rivets in -59, -60, -61, -62, -63, -24 Frame | 980 ● ◊ ◊ ◊ ◊ | Paint interior & exterior                                |
| 670 ● ◊ ◊ ◊ ◊ | Treat corrosion                                   | ○ ◊ ◊ ◊ ◊     | Delay  |
| 680 ● ◊ ◊ ◊ ◊ | Drill drain holes in cowling                      | ○ ◊ ◊ ◊ ◊     | Move to MABPAB 95  |
| 690 ● ◊ ◊ ◊ ◊ | Drill alignment pin holes                         | ○ ◊ ◊ ◊ ◊     | MABPAB   |
| 700 ● ◊ ◊ ◊ ◊ | Remove cowling from fixture                       | ○ ◊ ◊ ◊ ◊     | Delay  |
| 710 ● ◊ ◊ ◊ ◊ | Trim all skins                                    | 990 ● ◊ ◊ ◊ ◊ | Condition T72  |
| 720 ● ◊ ◊ ◊ ◊ | Drill Rivet Pattern in new longeron               | ○ ◊ ◊ ◊ ◊     |  |
| 730 ● ◊ ◊ ◊ ◊ | Install Doubler's rivet pattern in -99 longerons  | ○ ◊ ◊ ◊ ◊     |  |
| 740 ● ◊ ◊ ◊ ◊ | Install clips @ latch openings                    | ○ ◊ ◊ ◊ ◊     |  |
| 750 ● ◊ ◊ ◊ ◊ | Attach clip to frame (-57)                        | ○ ◊ ◊ ◊ ◊     |  |

710  
N/A  
(Final)

STATION/OP NO. 117.WORK TO BE ACCOMPLISHED 118.MECH119"F"120"Q"

|      |       |                                       |  |   |   |
|------|-------|---------------------------------------|--|---|---|
| 95   | 120   | FRAME #3 (-60)                        |  | / | / |
|      | MBPAB | REPAIR_____REPLACE_____NOT REQ'D_____ |  |   |   |
| 95   | 130   | FRAME #4 (-81)                        |  | / | / |
|      | MBPAB | REPAIR_____REPLACE_____NOT REQ'D_____ |  |   |   |
| 95   | 140   | FRAME #5 (-15)                        |  | / | / |
|      | MBPAB | REPAIR_____REPLACE_____NOT REQ'D_____ |  |   |   |
| 95   | 150   | FRAME #6 (-16)                        |  | / | / |
|      | MBPAB | REPAIR_____REPLACE_____NOT REQ'D_____ |  |   |   |
| 95   | 160   | FRAME #7 (-17)                        |  | / | / |
|      | MBPAB | REPAIR_____REPLACE_____NOT REQ'D_____ |  |   |   |
| 95   | 170   | FRAME #8 (-18)                        |  | / | / |
|      | MBPAB | REPAIR_____REPLACE_____NOT REQ'D_____ |  |   |   |
| 95   | 180   | FIREWALL ASSEMBLY (-62)               |  | / | / |
|      | MBPAB | REPAIR_____REPLACE_____NOT REQ'D_____ |  |   |   |
| 95   | 190   | FIRESEAL (-91)                        |  | / | / |
|      | MBPAB | REPAIR_____REPLACE_____NOT REQ'D_____ |  |   |   |
| 95   | 200   | FRAME #10 (-20)                       |  | / | / |
|      | MBPAB | REPAIR_____REPLACE_____NOT REQ'D_____ |  |   |   |
| 95   | 210   | FRAME #11 (-63)                       |  | / | / |
|      | MBPAB | REPAIR_____REPLACE_____NOT REQ'D_____ |  |   |   |
| 95   | 220   | FRAME #12 (-22)                       |  | / | / |
|      | MBPAB | REPAIR_____REPLACE_____NOT REQ'D_____ |  |   |   |
| 95   | 230   | FRAME #13 (-23)                       |  | / | / |
|      | MBPAB | REPAIR_____REPLACE_____NOT REQ'D_____ |  |   |   |
| 95   | 240   | FRAME #14                             |  | / | / |
|      | MBPAB | REPAIR_____REPLACE_____NOT REQ'D_____ |  |   |   |
| 95   | 250   | FRAME #15                             |  | / | / |
|      | MBPAB | REPAIR_____REPLACE_____NOT REQ'D_____ |  |   |   |
| 95   | 260   | REPLACE CLIPS AS REQUIRED             |  | / | / |
|      | MBPAB |                                       |  |   |   |
| 3001 | 270   | WELD AS REQUIRED. REF T.O.1-1A-1      |  | / | / |
|      | MTPIW | REQ'D_____NOT REQ'D_____              |  |   |   |
|      |       | WELDING DONE AT POST K-76.            |  |   |   |
| 95   | 280   | LONGERON (-8)                         |  | / | / |
|      | MBPAB | REPAIR_____REPLACE_____NOT REQ'D_____ |  |   |   |
| 95   | 290   | INSTALL SPRING CLIP P/N 60-2066-4     |  | / | / |
|      | MBPAB | REQ'D_____NOT REQ'D_____              |  |   |   |
| 95   | 300   | LONGERON (-98)                        |  | / | / |
|      | MBPAB | REPAIR_____REPLACE_____NOT REQ'D_____ |  |   |   |

|    |       |                                     |  |   |   |
|----|-------|-------------------------------------|--|---|---|
| 95 | 310   | INSTALL HOOKS                       |  | / | / |
|    | MBPAB | #2 5-96762 REQ'D____NOT REQ'D____   |  |   |   |
|    |       | #3 5-96766-1 REQ'D____NOT REQ'D____ |  |   |   |
|    |       | #4 5-96766-2 REQ'D____NOT REQ'D____ |  |   |   |
|    |       | #5 5-96762 REQ'D____NOT REQ'D____   |  |   |   |
|    |       | #6 SPEAR 5-96719                    |  |   |   |
|    |       | REQ'D____NOT REQ'D____              |  |   |   |
| 95 | 320   | SEAL, 90-7988                       |  | / |   |
|    | MBPAB | REPLACE____NOT REQ'D____            |  |   |   |
| 95 | 330   | DOOR FRAME (-111)                   |  | / |   |
|    | MBPAB | REPLACE____NOT REQ'D____            |  |   |   |
| 95 | 340   | DOOR ASSEMBLY (-112)                |  | / | / |
|    | MBPAB | REPAIR____REPLACE____NOT REQ'D____  |  |   |   |
| 95 | 345   | LONGERON (-10)                      |  | / | / |
|    | MBPAB | REPAIR____REPLACE____NOT REQ'D____  |  |   |   |
| 95 | 350   | LONGERON (-113)                     |  | / | / |
|    | MBPAB | REPAIR____REPLACE____NOT REQ'D____  |  |   |   |
| 95 | 360   | LONGERON (-100)                     |  | / |   |
|    | MBPAB | REPAIR____REPLACE____NOT REQ'D____  |  |   |   |
| 95 | 370   | INSTALL LATCHES                     |  | / | / |
|    | MBPAB | #2 H-28-2                           |  |   |   |
|    |       | REPAIR____REPLACE____NOT REQ'D____  |  |   |   |
|    |       | #3 H-28-2                           |  |   |   |
|    |       | REPAIR____REPLACE____NOT REQ'D____  |  |   |   |
|    |       | #4 H-28-1                           |  |   |   |
|    |       | REPAIR____REPLACE____NOT REQ'D____  |  |   |   |
|    |       | #5 H-28-1                           |  |   |   |
|    |       | REPAIR____REPLACE____NOT REQ'D____  |  |   |   |
|    |       | #6 H-40-1                           |  |   |   |
|    |       | REPAIR____REPLACE____NOT REQ'D____  |  |   |   |
| 95 | 380   | INSTALL PIN PLATES                  |  | / | / |
|    | MBPAB | REQ'D____NOT REQ'D____              |  |   |   |
| 95 | 390   | REMOVE STEEL MOUNTING PLATE (-77)   |  | / | / |
|    | MBPAB | REQ'D____NOT REQ'D____              |  |   |   |
| 95 | 400   | DUCT, 90-3343-2                     |  | / | / |
|    | MBPAB | REPAIR____REPLACE____NOT REQ'D____  |  |   |   |
| 95 | 410   | GASKET, 69-22576 1                  |  | / | / |
|    | MBPAB | REPLACE____NOT REQ'D____            |  |   |   |





(CONTINUED)



|   |     |       |                                      |           |  |  |   |   |  |
|---|-----|-------|--------------------------------------|-----------|--|--|---|---|--|
| *****   |     |       |                                      |           |  |  |   |   |  |
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| 15.DISC-16.FDR/   |     |       |                                      |           |  |  |   |   |  |
| STATION/OP NO. 117.WORK TO BE ACCOMPLISHED 113. RECH 12" 120" 120"    |     |       |                                      |           |  |  |   |   |  |
|   |     | REQ'D |                                      | NOT REQ'D |  |  |   |   |  |
| 95  | 850 | MBPAB | INSTALL RIVETS AND SPACERS AT AFT    |           |  |  | / | / |  |
|   |     |       | END OF LONG RUN                      |           |  |  |   |   |  |
|   |     |       | (43) REQ'D                           |           |  |  |   |   |  |
|   |     |       | (10) NOT REQ'D                       |           |  |  |   |   |  |
| 95  | 860 | MBPAB | COUNTERSINK & INSTALL RIVETS IN ALL  |           |  |  | / | / |  |
|   |     |       | NEW LIPS                             |           |  |  |   |   |  |
| 95  | 950 | MBPAB | INSTALL BUMPERS, AFT SIDE OF         |           |  |  | / | / |  |
|   |     |       | (25) FRAME                           |           |  |  |   |   |  |
|   |     |       | REQ'D                                |           |  |  |   |   |  |
|   |     |       | NOT REQ'D                            |           |  |  |   |   |  |
| 95  | 940 | MBPAB | INSPECT COUPLING AND ENSURE THAT ALL |           |  |  | E | / |  |
|   |     |       | RIVETS ARE INSTALLED IN FRAMES,      |           |  |  |   |   |  |
|   |     |       | FINGERPOPS, CLIPS, DOUBLERS, ETC.    |           |  |  |   |   |  |
| 95  | 950 | MBPAB | SHAVE ALL HIGH RIVETS IN SKINS       |           |  |  | / | / |  |
| 95  | 960 | MBPAB | PLACE COUPLING IN ALIGNMENT          |           |  |  | E | / |  |
|   |     |       | FLTURE, ACCOMPLISH ALIGNMENT CHECK,  |           |  |  |   |   |  |
|   |     |       | MOVE TO MBPCB                        |           |  |  |   |   |  |
| 2280  | 970 | MBPCB | FINAL WASH AND TREAT FOR CORROSION   |           |  |  | / | / |  |
| 2280  | 980 | MBPCB | PAINT INTERIOR AND EXTERIOR, INSTALL |           |  |  | / | / |  |
|   |     |       | EXTERIOR STENCILS PER SOW 82-174     |           |  |  |   |   |  |
|   |     |       | MOVE TO MBPAB                        |           |  |  |   |   |  |
| 95  | 990 | MBPAB | WORK COMPLETE, CONDITION TAG &       |           |  |  | E | / |  |
|   |     |       | IDENTIFY IW MAOI 65-1 DATED 9 MAY 77 |           |  |  | / |   |  |
|   |     |       | NOTE: ANY WORK PERFORMED AND NOT     |           |  |  |   |   |  |
|   |     |       | COVERED BY THIS DOCUMENT             |           |  |  |   |   |  |
|   |     |       | WILL BE NUMBERED AND RECORDED        |           |  |  |   |   |  |
|   |     |       | BELOW.                               |           |  |  |   |   |  |
|   |     |       | MABEBS L. MULLINAX 3-22-89           |           |  |  |   |   |  |
|   |     |       | MBPAB L. STEWARD 3-22-89             |           |  |  |   |   |  |
|   |     |       | MAQBF T. HAYES 3-22-89               |           |  |  |   |   |  |
|   |     |       | MABSCS H. NGUYEN 3-22-89             |           |  |  |   |   |  |

| FIGURE &<br>INDEX NO. | PART NUMBER    | DESCRIPTION  | UNITS<br>PER<br>ASSY | USE<br>ON<br>CODE |
|-----------------------|----------------|--|----------------------|-------------------|
|                       |                | 1 2 3 4 5 6 7  |                      |                   |
| 1102-                 | 5-85638 15113A | PANEL ASSY, RIGHT HAND SIDE COWL, ENGINE NACELLE (FOR . . .<br>NHA SEE FIG. 1100)  | REF                  | A                 |
|                       | 35-52370-1     | PANEL ASSY, RIGHT HAND SIDE COWL, ENGINE NACELLE (FOR . . .<br>NHA SEE FIG. 1100)  | 1                    | A                 |
|                       | 7727042-10     | PANEL ASSY, RIGHT HAND SIDE COWL, ENGINE NACELLE (FOR . . .<br>NHA SEE FIG. 1100)  | 1                    | A                 |
| 1                     | (DELETED)      |  |                      |                   |
| 2                     | NAS1103-23DW   | . BOLT (FOR REPLACEMENT ORDER BACB3ONE3D23) . . . . .  | 1                    | A                 |
| 3                     | AN960D10L      | . WASHER. . . . .  | 4                    | A                 |
| 4                     | AN320-3        | . NUT (FOR REPLACEMENT ORDER BACN10JD103) . . . . .  | 1                    | A                 |
| 5                     | H28-3          | . LATCH ASSY, TOGGLE HOOK, ENGINE NACELLE COWL PANEL. . . .<br>(83014) (ALTERNATE 24L1-3 (71286)) (BOEING SPEC<br>10-2731-4)   | 1                    | A                 |
| 5A                    | 9-66304        | . U-BOLT, LATCH, ENGINE NACELLE COWL. . . . .<br>(ATTACHING PARTS)   | 4                    | A                 |
| 5B                    | AN316-5R       | . NUT . . . . .  | 8                    | A                 |
| 6                     | H29523-5       | . NUT, 12 PT, EXT WRENCHING, SELF-LKG 450°F (15653) . . . .<br>(ALTERNATES FN22A524 (03680) LH3393-054 (72962)<br>VN406A054 (92215)) (BACN10BL5L) (FOR REPLACEMENT<br>ORDER 66796-524 (03680) (BACN10GW5)) | 8                    | A                 |
| 6A                    | 9-66304        | . U-BOLT, LATCH, ENGINE NACELLE COWL. . . . .<br>(ATTACHING PARTS)   | 1                    | A                 |
| 6B                    | AN316-5R       | . NUT . . . . .  | 2                    | A                 |
| 6C                    | H29523-5       | . NUT, 12 PT EXT WRENCHING, SELF-LKG°F (15653) . . . . .<br>(ALTERNATES FN22A524 (03680) LH3393-054 (72962)<br>VN406A054 (92215)) (BACN10BL5L) (FOR REPLACEMENT<br>ORDER 66796-524 (03680) (BACN10GW5))    | 2                    | A                 |
| 6D                    | 90-3261-2      | . FITTING, ATTACHMENT, U-BOLT, NACELLE COWL PANEL . . . . .  | 1                    | A                 |
| 6E                    | 90-3261        | . FITTING, ATTACHMENT, U-BOLT, NACELLE COWL PANEL . . . . .  | 2                    | A                 |
| 6F                    | 90-3251-1      | . FITTING, ATTACHMENT, U-BOLT, NACELLE COWL PANEL . . . . .  | 2                    | A                 |
| 7                     | 60-3329        | . SEAL, ATTACHMENT, U-BOLT, ENGINE NACELLE COWL . . . . .  | 3                    | A                 |
| 8                     | 60-3329-1      | . SEAL, ATTACHMENT, U-BOLT, ENGINE NACELLE COWL . . . . .  | 1                    | A                 |
| 9                     | 66-4025        | . PIN, SHEAR, ENGINE NACELLE COWL PANEL . . . . .<br>(ATTACHING PARTS)   | 1                    | A                 |
|                       | NAS679A4W      | . NUT (FOR REPLACEMENT ORDER BACN10JC4) . . . . .  | 1                    | A                 |
|                       | 5-85638-55     | . DOOR INSTL, FORWARD FIRE, RIGHT HAND SIDE COWL PANEL, .<br>ENGINE NACELLE  | 1                    | A                 |
|                       | 5-85638-54     | . DOOR INSTL, AFT FIRE, RIGHT HAND SIDE COWL PANEL, . . .<br>ENGINE NACELLE  | 1                    | A                 |
| 9A                    | 6-25391-1      | . . SPRING, FIRE CONTROL DOOR . . . . .  | 3                    | A                 |
| 10                    | 90-2907        | . . DOOR ASSY, ACCESS, FIRE EXTINGUISHER, ENGINE. . . . .<br>NACELLE (USED ON 5-85638-55)  | 1                    | A                 |
| 11                    | 90-2908        | . . DOOR ASSY, ACCESS, FIRE EXTINGUISHER, ENGINE. . . . .<br>NACELLE (USED ON 5-85638-54)  | 1                    | A                 |
| 12                    | MS25083-1AA10  | . . . JUMPER ASSY . . . . .<br>(ATTACHING PARTS)   | 1                    | A                 |
|                       | NAS601-6       | . . . SCREW (FOR REPLACEMENT ORDER NAS601-6P) . . . . .  | 1                    | A                 |
|                       | NAS679A06W     | . . . NUT (FOR REPLACEMENT ORDER BACN10JC06) . . . . .   | 1                    | A                 |
| 12A                   | 5-85638-53     | . . PAN, FIRE DOOR FWD (USED ON 5-85638-55) . . . . .  | 1                    | A                 |
| 13                    | 5-96762        | . HOOK, HINGE, NACELLE COWLING. . . . .  | 2                    | A                 |
| 14                    | 5-96766        | . HOOK, HINGE, NACELLE COWLING. . . . .  | 1                    | A                 |
| 15                    | 5-96766-1      | . HOOK, HINGE, NACELLE COWLING. . . . .  | 1                    | A                 |
| 16                    | 5-96766-2      | . HOOK, HINGE, NACELLE COWLING. . . . .<br>(ATTACHING PARTS)   | 1                    | A                 |
|                       | AN5-10A        | . BOLT (FOR REPLACEMENT ORDER BACB3ONE5-10) . . . . .  | 4                    | A                 |
|                       | NAS1105-9W     | . BOLT (FOR REPLACEMENT ORDER BACB3ONE5-9) . . . . .   | 1                    | A                 |
|                       | AN960-516L     | . WASHER. . . . .  | 10                   | A                 |
|                       | MS21042L3      | . NUT (REPLACES NAS679A5 OR BACN10JC5) . . . . .   | 5                    | A                 |
|                       | AN3-7A         | . BOLT (FOR REPLACEMENT ORDER BACB3ONE3-8) . . . . .   | 5                    | A                 |
|                       | AN960-10L      | . WASHER. . . . .  | 5                    | A                 |
|                       | NAS679A3W      | . NUT (FOR REPLACEMENT ORDER BACN10JC3) . . . . .  | 5                    | A                 |
| 17                    | 5-96719-800    | . HINGE, SPEAR, ENGINE NACELLE COWL PANEL . . . . .<br>(ATTACHING PARTS)   | 1                    | A                 |
|                       | AN4-10A        | . BOLT (FOR REPLACEMENT ORDER BACB3ONE4-9) . . . . .   | 1                    | A                 |
|                       | AN960-416      | . WASHER. . . . .  | 1                    | A                 |
|                       | AN960-416L     | . WASHER. . . . .  | 1                    | A                 |
|                       | NAS679A4W      | . NUT (REPLACEMENT ORDER BACN10JC4) . . . . .  | 1                    | A                 |
|                       | AN3-7A         | . BOLT (FOR REPLACEMENT ORDER BACB3ONE3-8) . . . . .   | 1                    | A                 |
|                       | AN960-10       | . WASHER. . . . .  | 1                    | A                 |
|                       | AN960-10L      | . WASHER. . . . .  | 1                    | A                 |
|                       | NAS679A3W      | . NUT (FOR REPLACEMENT ORDER BACN10JC3) . . . . .  | 1                    | A                 |

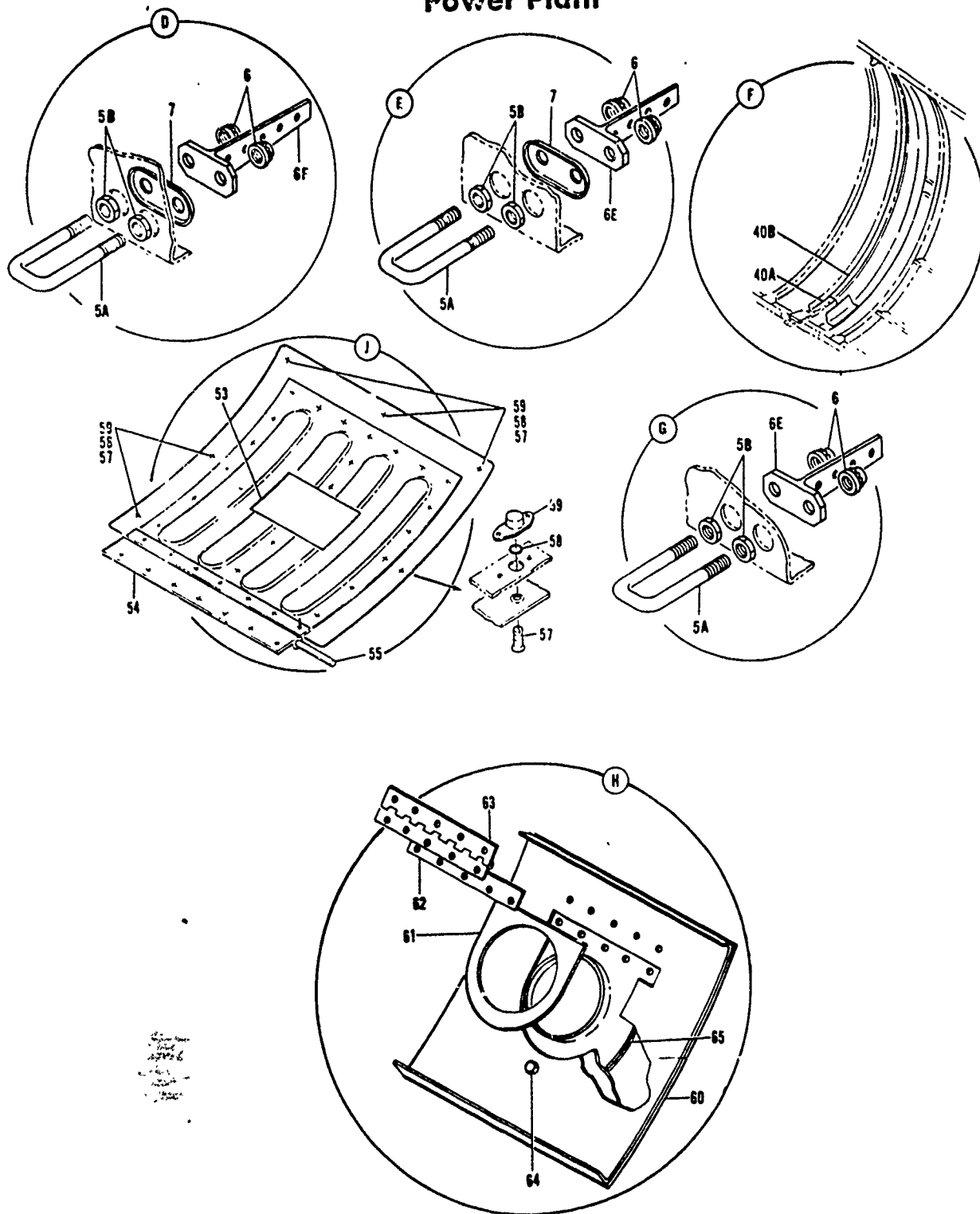
**Power Plant**

Figure 1102. Engine Nacelle Right Hand Side Cowl Panel Assembly (Sheet 2 of 2)

Section II  
Group Assembly Parts List

T.O. 1C-135A-4

| FIGURE &<br>INDEX NO. | PART NUMBER | DESCRIPTION   | UNITS<br>PER<br>ASSY | USE<br>ON<br>CODE |
|-----------------------|-------------|---|----------------------|-------------------|
|                       |             | 1 2 3 4 5 6 7   |                      |                   |
| 1102-                 |             |   |                      |                   |
| 18                    | 65-1296     | . VENT INSTL, OIL BREATHER LINE, ENGINE . . . . .   | 1                    | A                 |
|                       | 65-1296-1   | . . VENT ASSY, OIL BREATHER LINE, ENGINE. . . . .   | 1                    | A                 |
|                       | 65-1843     | . EXHAUST INSTL, WATER INJECTION PUMP ENGINE. . . . .   | 1                    | A                 |
| 19                    | 65-1843-10  | . EXHAUST INSTL, WATER INJECTION PUMP, ENGINE . . . . .   | 1                    | A                 |
|                       | 1200874     | . . SEAL ASSY, EXIT BELLOWS, FUEL AIR STARTER EXHAUST . .   | 1                    | A                 |
|                       |             | (87273) (ALTERNATE 8449402 (71688) (BOEING<br>SPEC 10-1748) (FOR REPLACEMENT ORDER 1200874-10<br>(87273) (BOEING SPEC 10-2748-1)) (FOR 1200874-10<br>REPAIR, ON 65-1843-10 INST ONLY, ORDER 69B25097-1) |                      |                   |
| 20                    | 65-1843-6   | . . COVER, EXHAUST, WATER INJECTION PUMP, ENGINE (MAKE. .   | 1                    | A                 |
|                       |             | FROM 2024-T3 CLAD SHEET 0.040 X 7.2 X 8.6)<br>(ATTACHING PARTS)   |                      |                   |
| 20A                   | AN3-4A      | . . BOLT (ALTERNATE NAS1303-2) (DO NOT SUBSTITUTE AN3-4A.<br>FOR NAS1303-2)   | 10                   | A                 |
| 20B                   | AN3-3A      | . . BOLT (ALTERNATE NAS1303-1) (DO NOT SUBSTITUTE AN3-3A.<br>FOR NAS1303-1)   | 10                   | A                 |
| 20C                   | AN960D10    | . . WASHER. . . . .   | 10                   | A                 |
| 20D                   | NAS679A3W   | . . NUT . . . . .   | 10                   | A                 |
|                       |             | -----   |                      |                   |
| 20E                   | 65-1843-19  | . . EXHAUST ASSY, WATER INJECTION PUMP ENGINE . . . . .   | 1                    | A                 |
| 20F                   | 65-1843-11  | . . DUCT ASSY, EXHAUST, WATER INJECTION PUMP, ENGINE. .   | 1                    | A                 |
| 21                    | 65-1843-1   | . . DUCT ASSY, EXHAUST WATER INJECTION PUMP, ENGINE . . .   | 1                    | A                 |
|                       | 5-85638-1   | . SKIN, FORWARD, RIGHT HAND SIDE COWL PANEL, ENGINE . . .   | 1                    | A                 |
|                       |             | NACELLE   |                      |                   |
| 22                    | 5-85638-2   | . SKIN, MIDDLE, RIGHT HAND SIDE COWL PANEL, ENGINE. . . .   | 1                    | A                 |
|                       |             | NACELLE   |                      |                   |
| 23                    | 5-85638-4   | . SKIN, UPPER AFT, RIGHT HAND SIDE COWL PANEL, ENGINE . .   | 1                    | A                 |
|                       |             | NACELLE   |                      |                   |
| 24                    | 5-85638-3   | . SKIN, LOWER AFT, RIGHT HAND SIDE COWL PANEL, ENGINE . .   | 1                    | A                 |
|                       |             | NACELLE   |                      |                   |
|                       | 5-85638-70  | . FRAMF AND SKIN ASSY, PANEL, RIGHT HAND SIDE COWL, . . .   | 1                    | A                 |
|                       |             | ENGINE NACELLE  |                      |                   |
| 25                    | 5-85638-5   | . . SKIN, AFT, RIGHT HAND SIDE COWL PANEL, ENGINE . . . .   | 1                    | A                 |
|                       |             | NACELLE   |                      |                   |
| 26                    | 5-85638-20  | . . FRAME, PANEL STATION 180.00, RIGHT HAND SIDE COWL,. .   | 1                    | A                 |
|                       |             | ENGINE NACELLE  |                      |                   |
| 27                    | 5-85638-22  | . . FRAME, PANEL STATION 200.00, RIGHT HAND SIDE COWL,. .   | 1                    | A                 |
|                       |             | ENGINE NACELLE  |                      |                   |
| 28                    | 5-85638-23  | . . FRAME, PANEL STATION 210.00, RIGHT HAND SIDE COWL,. .   | 1                    | A                 |
|                       |             | ENGINE NACELLE  |                      |                   |
| 29                    | 5-85638-25  | . . FRAME, PANEL STATION 235.00, RIGHT HAND SIDE COWL,. .   | 1                    | A                 |
|                       |             | ENGINE NACELLE  |                      |                   |
| 30                    | 5-85638-26  | . . DOUBLER, PANEL, RIGHT HAND SIDE COWL, ENGINE NACELLE.   | 1                    | A                 |
|                       | 5-85638-48  | . LONGERON ASSY, PANEL, RIGHT HAND SIDE COWL, ENGINE. . .   | 1                    | A                 |
|                       |             | NACELLE (WHEN EXHAUSTED USE 5-85638-94)   |                      |                   |
|                       | 5-85638-94  | . LONGERON ASSY, PANEL, RIGHT HAND SIDE COWL, ENGINE. . .   | 1                    | A                 |
|                       |             | NACELLE (SUITABLE SUB. FOR 5-85638-48) (WHEN<br>EXHAUSTED USE 5-85638-99)   |                      |                   |
|                       | 5-85638-99  | . LONGERON ASSY, PANEL, RIGHT HAND SIDE COWL, ENGINE. . .   | 1                    | A                 |
|                       |             | NACELLE   |                      |                   |
| 31                    | 5-85638-7   | . . LONGERON, UPPER FORWARD, RIGHT HAND SIDE COWL PANEL .   | 1                    | A                 |
|                       |             | ENGINE NACELLE  |                      |                   |
| 31                    | 5-85638-92  | . . LONGERON, UPPER FORWARD, RIGHT HAND SIDE COWL PANEL .   | 1                    | A                 |
|                       |             | ENGINE NACELLE  |                      |                   |
| 31                    | 5-85638-97  | . . LONGERON, UPPER FORWARD, RIGHT HAND SIDE COWL PANEL,. .   | 1                    | A                 |
|                       |             | ENGINE NACELLE  |                      |                   |
|                       | 5-85638-49  | . LONGERON ASSY, PANEL, RIGHT HAND SIDE COWL, ENGINE. . .   | 1                    | A                 |
|                       |             | NACELLE (FOR I/W INFO SEE 5-85638-91)   |                      |                   |
|                       | 5-85638-91  | . LONGERON ASSY, PANEL, RIGHT HAND SIDE COWL, ENGINE. . .   | 1                    | A                 |
|                       |             | NACELLE   |                      |                   |
| 32                    | 5-85638-29  | . . DOUBLER, PANEL, RIGHT HAND SIDE COWL, ENGINE NACELLE.   | 1                    | A                 |
| 32                    | 5-85638-89  | . . DOUBLER, PANEL, RIGHT HAND SIDE COWL, ENGINE NACELLE.   | 1                    | A                 |
| 33                    | 5-85638-8   | . . LONGERON, UPPER AFT, RIGHT HAND SIDE COWL, ENGINE . .   | 1                    | A                 |
|                       |             | NACELLE   |                      |                   |
| 34                    | 5-85638-62  | . LONGERON, PANEL, RIGHT HAND SIDE COWL, ENGINE NACELLE .   | 1                    | A                 |
|                       | 5-85638-81  | . LONGERON ASSY, PANEL, RIGHT HAND SIDE COWL, ENGINE. . .   | 1                    | A                 |
|                       |             | NACELLE   |                      |                   |
| 35                    | 5-85638-59  | . . DOUBLER, PANEL, RIGHT HAND SIDE COWL, ENGINE NACELLE.   | 1                    | A                 |
| 36                    | 5-85638-58  | . . LONGERON, PANEL, RIGHT HAND SIDE COWL, ENGINE NACELLE   | 1                    | A                 |

| FIGURE &<br>INDEX NO. | PART NUMBER    | DESCRIPTION   | UNITS<br>PER<br>ASSY | USE<br>ON<br>CODE |
|-----------------------|----------------|---|----------------------|-------------------|
|                       |                | 1 2 3 4 5 6 7   |                      |                   |
| 1102-                 |                |   |                      |                   |
| 37                    | 5-85638-60     | . DOUBLER, PANEL, RIGHT HAND SIDE COWL, ENGINE NACELLE. .   | 1                    | A                 |
|                       | 5-85638-46     | . LONGERON ASSY, PANEL, RIGHT HAND SIDE COWL, ENGINE. . .   | 1                    | A                 |
|                       |                | NACELLE   |                      |                   |
| 38                    | 5-85638-9      | . . LONGERON, LOWER FORWARD, RIGHT HAND SIDE COWL PANEL, .  | 1                    | A                 |
|                       |                | ENGINE NACELLE  |                      |                   |
|                       | 5-85638-47     | . LONGERON ASSY, PANEL, RIGHT HAND SIDE COWL, ENGINE. . .   | 1                    | A                 |
|                       |                | NACELLE   |                      |                   |
| 39                    | 5-85638-10     | . . LONGERON, LOWER AFT, RIGHT HAND SIDE COWL PANEL, . . .  | 1                    | A                 |
|                       |                | ENGINE NACELLE  |                      |                   |
|                       | 5-85638-38     | . FRAME ASSY, LOWER AFT, RIGHT HAND SIDE COWL PANEL, . . .  | 1                    | A                 |
|                       |                | ENGINE NACELLE  |                      |                   |
| 40                    | 5-85638-19     | . . FRAME, STATION 171.20 RIGHT HAND SIDE COWL PANEL. . .   | 1                    | A                 |
|                       |                | ENGINE NACELLE  |                      |                   |
| 40A                   | 5-85638-803    | . . FRAME, STATION 171.20, RIGHT HAND SIDE COWL PANEL, . .  | 1                    | A                 |
|                       |                | ENGINE NACELLE  |                      |                   |
| 40B                   | 5-85638-804    | . . FRAME, STATION 171.20, RIGHT HAND SIDE COWL PANEL, . .  | 1                    | A                 |
|                       |                | ENGINE NACELLE  |                      |                   |
|                       | 5-85638-805    | . . SPLICE, STATION 171.20, RIGHT HAND SIDE COWL PANEL, .   | 1                    | A                 |
|                       |                | ENGINE NACELLE  |                      |                   |
|                       | 5-85638-806    | . . SPLICE, STATION 171.20, RIGHT HAND SIDE COWL PANEL, .   | 1                    | A                 |
|                       |                | ENGINE NACELLE  |                      |                   |
|                       | 5-85638-35     | . FRAME ASSY, STATION 171.20, RIGHT HAND SIDE COWL PANEL, . | 1                    | A                 |
|                       |                | ENGINE NACELLE  |                      |                   |
| 41                    | 5-85638-11     | . . FRAME, STATION 89.50, RIGHT HAND SIDE COWL PANEL, . .   | 1                    | A                 |
|                       |                | ENGINE NACELLE  |                      |                   |
| 42                    | 5-85638-12     | . FRAME, STATION 100.43, RIGHT HAND SIDE COWL PANEL. . .    | 1                    | A                 |
|                       |                | ENGINE NACELLE  |                      |                   |
|                       | 5-85638-36     | . FRAME ASSY, STATION 100.43, RIGHT HAND SIDE COWL PANEL, . | 1                    | A                 |
|                       |                | ENGINE NACELLE  |                      |                   |
| 43                    | 5-85638-13     | . . FRAME, STATION 112.50, RIGHT HAND SIDE COWL PANEL, . .  | 1                    | A                 |
|                       |                | ENGINE NACELLE  |                      |                   |
| 44                    | 5-85638-14     | . FRAME, STATION 120.00, RIGHT HAND SIDE COWL PANEL, . . .  | 1                    | A                 |
|                       |                | ENGINE NACELLE  |                      |                   |
| 45                    | 5-85638-15     | . FRAME, STATION 131.50, RIGHT HAND SIDE COWL PANEL, . . .  | 1                    | A                 |
|                       |                | ENGINE NACELLE  |                      |                   |
|                       | 5-85638-37     | . FRAME ASSY, COWL PANEL, RIGHT HAND SIDE, ENGINE NACELLE   | 1                    | A                 |
|                       |                | (WHEN EXHAUSTED USE 5-85638-101)                            |                      |                   |
|                       | 5-85638-101    | . FRAME ASSY, COWL PANEL, RIGHT HAND SIDE, ENGINE NACELLE   | 1                    | A                 |
| 46                    | 5-85638-100    | . . FRAME, STATION 142.80, RIGHT HAND SIDE COWL PANEL, . .  | 1                    | A                 |
|                       |                | ENGINE NACELLE  |                      |                   |
| 47                    | 5-85638-17     | . FRAME, STATION 152.75, RIGHT HAND SIDE COWL PANEL, . . .  | 1                    | A                 |
|                       |                | ENGINE NACELLE  |                      |                   |
| 48                    | 5-85638-18     | . FRAME, STATION 161.50, RIGHT HAND SIDE COWL PANEL, . . .  | 1                    | A                 |
|                       |                | ENGINE NACELLE  |                      |                   |
|                       | 5-85638-39     | . FRAME ASSY, STATION 161.50, RIGHT HAND SIDE COWL PANEL, . | 1                    | A                 |
|                       |                | ENGINE NACELLE  |                      |                   |
| 49                    | 5-85638-21     | . . FRAME, STATION 190.00, RIGHT HAND SIDE COWL PANEL, . .  | 1                    | A                 |
|                       |                | ENGINE NACELLE  |                      |                   |
|                       | 5-85638-40     | . FRAME ASSY, STATION 190.00 RIGHT HAND SIDE COWL PANEL, .  | 1                    | A                 |
|                       |                | ENGINE NACELLE (WHEN EXHAUSTED USE 5-85638-90)              |                      |                   |
|                       | 5-85638-90     | . FRAME ASSY, STATION 190.00, RIGHT HAND SIDE COWL PANEL, . | 1                    | A                 |
|                       |                | ENGINE NACELLE  |                      |                   |
| 50                    | 5-85638-24     | . . FRAME, STATION 225.00, RIGHT HAND SIDE COWL PANEL, . .  | 1                    | A                 |
|                       |                | ENGINE NACELLE  |                      |                   |
| 50                    | 5-85638-86     | . . FRAME, STATION 225.00, RIGHT HAND SIDE COWL PANEL, . .  | 1                    | A                 |
|                       |                | ENGINE NACELLE  |                      |                   |
| 51                    | 5-85638-34     | . SEGMENT, LONGERON, RIGHT HAND SIDE COWL PANEL, ENGINE .   | 1                    | A                 |
|                       |                | NACELLE   |                      |                   |
| 52                    | 5-85638-6      | . CAP, RIGHT HAND SIDE COWL PANEL, ENGINE NACELLE . . . .   | 1                    | A                 |
|                       | 35-1376-1      | . DOOR ASSY, ACCESS, PNEUMATIC CARTRIDGE STARTER. . . . .   | 1                    | A                 |
| 53                    | 35-1376-1      | . . MARKER, FOIL. . . . .                                   | 1                    | A                 |
| 54                    | 35-1376-5      | . . HINGE HALF (MAKE FROM MS20001PH6-1040). . . . .         | 2                    | A                 |
| 55                    | MS20253P2-1015 | . . PIN, HINGE. . . . .                                     | 1                    | A                 |
| 56                    | F5T14          | . . STUD (72794). . . . .                                   | 3                    | A                 |
| 57                    | F5T9           | . . STUD (72794). . . . .                                   | 3                    | A                 |
| 58                    | GH5            | . . GROMMET (72794). . . . .                                | 6                    | A                 |
| 59                    | RF5            | . RECEPTACLE (72794). . . . .                               | 6                    | A                 |

Section II  
Group Assembly Parts List

T.O. 1C-135A-4

| FIGURE &<br>INDEX NO. | PART NUMBER | DESCRIPTION  | 1 2 3 4 5 6 7 |  |  |  |  |  |  | UNITS<br>PER<br>ASSY | USE<br>ON<br>CODE |
|-----------------------|-------------|--|---------------|--|--|--|--|--|--|----------------------|-------------------|
|                       |             |  |               |  |  |  |  |  |  |                      |                   |
| 1102-                 |             |  |               |  |  |  |  |  |  |                      |                   |
| 60                    | 7727014-10  | . DOOR ASSY, CONSTANT SPEED DRIVE ACCESS. . . . .                                  |               |  |  |  |  |  |  | 1                    | A                 |
| 61                    | 7727014-03  | . . FILLER (MADE FROM AL ALLOY SHT PER QQ-A-250/4 2024T .<br>.050 X 10.00 X 10.40) |               |  |  |  |  |  |  | 1                    | A                 |
| 62                    | 7727014-05  | . . DOUBLER; (MADE FROM AL ALLOY 2024-T4 PER QQ-A-250/4 .<br>.050 THK)             |               |  |  |  |  |  |  | 1                    | A                 |
| 63                    | 7727014-07  | . . SPACER; (MADE FROM AL ALLOY 2024-T4 PER QQ-A-450/4 .<br>.050 THK)              |               |  |  |  |  |  |  | 1                    | A                 |
| 64                    | AN257-4-5   | . . HINGE, 5 INCHES LONG. . . . .  |               |  |  |  |  |  |  | 1                    | A                 |
| 65                    | 99947P-130  | . . RECEPTACLE, SPRING (83058). . . . .  |               |  |  |  |  |  |  | 1                    | A                 |
|                       | 5-85637-112 | . . DOOR. . . . .  |               |  |  |  |  |  |  | 1                    | A                 |
|                       |             | A 2201 THRU 2299, 3001 THRU 3015   |               |  |  |  |  |  |  |                      |                   |
|                       |             | ALSO SEE FIGURE 1132   |               |  |  |  |  |  |  |                      |                   |



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*****
1 15113A * WORK CONTROL DOCUMENT * MISTR 1.DATE 88054 PAGE 1 OF 2 PAGES!
*****
12.Orig/PROD NR 13.QUANTITY 14.PROD SECTION/RCC 15.DATE SCHED 16.DATE COMP
1 15113A 1 MABPAB 1 89093 1
-----
17.PART NUMBER 19.ITEM SERIAL NR 18/12.TECH DATA/OPTIONAL
1 772-7042-10 1 DRWG 5-85638
-----
10.MODEL/DESIGN/SERIES 11.STOCK NR 1 T.O.1-1A-1
1 KC-135 1 1560010419310FL 1 T.O.1-1-2
-----
13.MISC 14.NOUN/END ITEM NOUN 1 T.O.1C-135(K)A-3-1
1 SIDE COWL PANEL R.H. 1 T.O.1C-135(K)A-3-4
1 1C-135(K)A-3-1.3-4
-----
L. MULLINAX/MABERS/65246
-----
15.DISP-16.PDN/
1 STATION/UP NO. 17.WORK TO BE ACCOMPLISHED 18.MECH 19"P" 20"Q"
-----
2122 010 RECEIVE & UNCRATE SIDE COWL. / / /
MBPAB NOTE
OBSERVE CAUTION THAT SIDE COWL IS
NOT DAMAGED DURING UNCRATING.
-----
2122 020 WASH INTERIOR & EXTERIOR IAW T.O. / / /
MBPCA 1C-135(K)A-3-4, PARA 11-7 AND SOW
1560FL-82-174.
-----
2122 030 STRIP ALL INTERIOR & EXTERIOR PAINT / / /
MBPCA FROM SIDE COWL IAW T.O.1C-135(K)
A-3-4, PARA 11-15
SOW OC1560FL-82-174
-----
2122 040 ABRASIVE BLAST SIDE COWL IAW T.O. / / /
MBPCA 1C-135(K)A-3-4 SEC 9 PARA 16
AND T.O. 1-1-2.
-----
95 050 ACCOMPLISH VISUAL INSPECTION IAW / / /
MBPAB SOW 82-174.
-----
95 065 TEARDOWN / / /
MBPAB NOTE: DEPOT OVERHAUL OF J-57 RIGHT
HAND SIDE COWL WILL BE DONE IN
ACCORDANCE WITH INSTRUCTIONS IN
SOW OC1560/82-174 AND 1C-135(K)A-3-4
-----
95 070 REMOVE CORROSION & APPLY CORROSION / / /
MBPAB PROTECTIVE FINISH TO ALL REWORKED
SURFACES IAW T.O. 1C-135(K)A-3-4
AND T.O. 1-1-2
-----
3001 075 WELD AS REQD. REF T.O.1-1A-1 / / /
MTPIW REQD-----NOT REQD-----
WELDING DONE AT POST K-73
-----
95 080 ASSEMBLE (-81) LONGERON (-85) / / /
MBPAB DOUBLER AND 637-131 PLATE.
REQ'D NOT REQ'D
-----
95 090 SPEC DELETED / / /
MBPAB
-----
95 100 LONGERON (-46) / / /
MBPAB REPAIR REFLARE NOT REQ'D
-----
*****

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| *****  |       |  |  |  |  |  |  |   |   |
|--|-------|--|--|--|--|--|--|---|---|
| 15113A * WORK CONTROL DOCUMENT * MISTR 1. DATE 88054 PAGE 2 OF 7 PAGES |       |  |  |  |  |  |  |   |   |
| 15. DISC - 16. PDN /   |       |  |  |  |  |  |  |   |   |
| STATION / OP NO. 117. WORK TO BE ACCOMPLISHED                          |       |  |  |  |  |  |  |   |   |
| 118. MECH 119 "P" 120 "Q"  |       |  |  |  |  |  |  |   |   |
| 95   | 110   | LONGERON (-34)                             |  |  |  |  |  | E | / |
|  | MBPAB | REPAIR _____ REPLACE _____ NOT REQ'D _____ |  |  |  |  |  |   |   |
| 95   | 120   | LONGERON (-47)                             |  |  |  |  |  | / | / |
|  | MBPAB | REPAIR _____ REPLACE _____ NOT REQ'D _____ |  |  |  |  |  |   |   |
| 95   | 130   | ASSEMBLE -75 TO -99                        |  |  |  |  |  | / | / |
|  | MBPAB | REQ'D _____ NOT REQ'D _____                |  |  |  |  |  |   |   |
| 95   | 140   | LONGERON (-99)                             |  |  |  |  |  | / | / |
|  | MBPAB | REPAIR _____ REPLACE _____ NOT REQ'D _____ |  |  |  |  |  |   |   |
| 95   | 150   | ASSEMBLE -73 TO 21                         |  |  |  |  |  | / | / |
|  | MBPAB | REQ'D _____ NOT REQ'D _____                |  |  |  |  |  |   |   |
| 95   | 160   | LONGERON (-91)                             |  |  |  |  |  | / | / |
|  | MBPAB | REPAIR _____ REPLACE _____ NOT REQ'D _____ |  |  |  |  |  |   |   |
| 95   | 170   | LONGERON (-62)                             |  |  |  |  |  | / | / |
|  | MBPAB | REPAIR _____ REPLACE _____ NOT REQ'D _____ |  |  |  |  |  |   |   |
| 95   | 180   | FRAME #1, (-11) OR (-35) ASSEMBLY          |  |  |  |  |  | E | / |
|  | MBPAB | REPAIR _____ NOT REQ'D _____               |  |  |  |  |  |   |   |
| 95   | 190   | FRAME #2 (-12)                             |  |  |  |  |  | / | / |
|  | MBPAB | REPAIR _____ REPLACE _____ NOT REQ'D _____ |  |  |  |  |  |   |   |
| 95   | 200   | FRAME #3 (-13) OR (-36) ASSEMBLY           |  |  |  |  |  | / | / |
|  | MBPAB | REPAIR _____ REPLACE _____ NOT REQ'D _____ |  |  |  |  |  |   |   |
| 95   | 210   | FRAME #4 (-14)                             |  |  |  |  |  | / | / |
|  | MBPAB | REPAIR _____ REPLACE _____ NOT REQ'D _____ |  |  |  |  |  |   |   |
| 95   | 220   | FRAME #5 (-15)                             |  |  |  |  |  | / | / |
|  | MBPAB | REPAIR _____ NOT REQ'D _____               |  |  |  |  |  |   |   |
| 95   | 230   | FRAME #6 (-16) OR (-101) ASSEMBLY          |  |  |  |  |  | / | / |
|  | MBPAB | REPAIR _____ REPLACE _____ NOT REQ'D _____ |  |  |  |  |  |   |   |
| 95   | 240   | FRAME #7 (-17)                             |  |  |  |  |  | / | / |
|  | MBPAB | REPAIR _____ REPLACE _____ NOT REQ'D _____ |  |  |  |  |  |   |   |
| 95   | 250   | FRAME #8 (-18)                             |  |  |  |  |  | / | / |
|  | MBPAB | REPAIR _____ REPLACE _____ NOT REQ'D _____ |  |  |  |  |  |   |   |
| 95   | 260   | FRAME #9 (-19) OR (-38) ASSEMBLY           |  |  |  |  |  | / | / |
|  | MBPAB | REPAIR _____ NOT REQ'D _____               |  |  |  |  |  |   |   |
| 95   | 270   | FRAME #10 (-20)                            |  |  |  |  |  | / | / |
|  | MBPAB | REPAIR _____ REPLACE _____ NOT REQ'D _____ |  |  |  |  |  |   |   |
| 95   | 280   | FRAME #11 (-21) OR (-39) ASSEMBLY          |  |  |  |  |  | / | / |
|  | MBPAB | REPAIR _____ NOT REQ'D _____               |  |  |  |  |  |   |   |
| 95   | 290   | FRAME #12, (-22)                           |  |  |  |  |  | / | / |
|  | MBPAB | REPAIR _____ REPLACE _____ NOT REQ'D _____ |  |  |  |  |  |   |   |

| *****   |       |  |  |  |  |  |  |  |   |   |  |
|---|-------|--|--|--|--|--|--|--|---|---|--|
| 15113A * WORK CONTROL DOCUMENT * MISTR 1.DATE 00054 PAGE 3 OF 9 PAGES |       |  |  |  |  |  |  |  |   |   |  |
| 15.DISP-16.FDN/   |       |  |  |  |  |  |  |  |   |   |  |
| STATION/OP NO. 17.WORK TO BE ACCOMPLISHED 18.MECH 19"P" 20"Q"         |       |  |  |  |  |  |  |  |   |   |  |
| 95  | 300   | ASSEMBLE 60-4921 TO 638-23 FRAME           |  |  |  |  |  |  | / | / |  |
|   | MBPAB | REQ'D _____ NOT REQ'D _____                |  |  |  |  |  |  |   |   |  |
| 95  | 310   | FRAME #13 (-23)                            |  |  |  |  |  |  | / | / |  |
|   | MBPAB | REPAIR _____ REPLACE _____ NOT REQ'D _____ |  |  |  |  |  |  |   |   |  |
| 95  | 320   | FRAME #14 (-24) OR (-90) ASSEMBLY          |  |  |  |  |  |  | / | / |  |
|   | MBPAB | REPAIR _____ NOT REQ'D _____               |  |  |  |  |  |  |   |   |  |
| 95  | 330   | FRAME #15 (-25)                            |  |  |  |  |  |  | / | / |  |
|   | MBPAB | REPAIR _____ REPLACE _____ NOT REQ'D _____ |  |  |  |  |  |  |   |   |  |
| 95  | 340   | REPAIR OR REPLACE ALL ANGLES AND           |  |  |  |  |  |  | / | / |  |
|   | MBPAB | NECESSARY.                                 |  |  |  |  |  |  |   |   |  |
| 95  | 350   | BELLOWS SEAL, 1200874-10                   |  |  |  |  |  |  | / | / |  |
|   | MBPAB | REPLACE _____ NOT REQ'D _____              |  |  |  |  |  |  |   |   |  |
| 95  | 360   | BELLOWS, 65-1843-1                         |  |  |  |  |  |  | / | / |  |
|   | MBPAB | REPAIR _____ REPLACE _____ NOT REQ'D _____ |  |  |  |  |  |  |   |   |  |
| 95  | 370   | DRILL SKINS AS REQ'D                       |  |  |  |  |  |  | / | / |  |
|   | MBPAB | #1 REQ'D <u>100</u> NOT REQ'D _____        |  |  |  |  |  |  |   |   |  |
|   |       | #2 REQ'D <u>80</u> NOT REQ'D _____         |  |  |  |  |  |  |   |   |  |
|   |       | #3 REQ'D <u>50</u> NOT REQ'D _____         |  |  |  |  |  |  |   |   |  |
|   |       | #4 REQ'D <u>25</u> NOT REQ'D _____         |  |  |  |  |  |  |   |   |  |
|   |       | #5 REQ'D <u>25</u> NOT REQ'D _____         |  |  |  |  |  |  |   |   |  |
| 95  | 380   | SKINS REPAIRED IAW SOW                     |  |  |  |  |  |  | / | / |  |
|   | MBPAB | #1 REQ'D _____ NOT REQ'D _____             |  |  |  |  |  |  |   |   |  |
|   |       | #2 REQ'D _____ NOT REQ'D _____             |  |  |  |  |  |  |   |   |  |
|   |       | #3 REQ'D _____ NOT REQ'D _____             |  |  |  |  |  |  |   |   |  |
|   |       | #4 REQ'D _____ NOT REQ'D _____             |  |  |  |  |  |  |   |   |  |
|   |       | #5 REQ'D _____ NOT REQ'D _____             |  |  |  |  |  |  |   |   |  |
| 95  | 390   | FIXTURE                                    |  |  |  |  |  |  | / | / |  |
|   | MBPAB | PLACE COWLING IN FIXTURE                   |  |  |  |  |  |  |   |   |  |
| 95  | 400   | REMOVE CORROSION & APPLY CORROSION         |  |  |  |  |  |  | / | / |  |
|   | MBPAB | PROTECTIVE FINISH TO ALL REWORKED          |  |  |  |  |  |  |   |   |  |
|   |       | SURFACES IAW T.O. 1C-135(K)A-3-4           |  |  |  |  |  |  |   |   |  |
|   |       | AND T.O. 1-1-2                             |  |  |  |  |  |  |   |   |  |
| 95  | 410   | REPLACE (-81) LONGERON                     |  |  |  |  |  |  | / | / |  |
|   | MBPAB | REQ'D _____ NOT REQ'D _____                |  |  |  |  |  |  |   |   |  |
| 95  | 420   | REMOVE & REPLACE (-11) FRAME OR            |  |  |  |  |  |  | / | / |  |
|   | MBPAB | (-35) ASSEMBLY                             |  |  |  |  |  |  |   |   |  |
| (CONTINUED)   |       |  |  |  |  |  |  |  |   |   |  |

Handwritten notes in right margin:  
 1.0  
 1.0  
 .50  
 .75  
 .75  
 3.25





| *****  |        |  |          |         |         |
|--|--------|--|----------|---------|---------|
| 15113A * WORK CONTROL DOCUMENT * MISTR 1. DATE 88054 PAGE 6 OF 9 PAGES |        |  |          |         |         |
| 15. DISP-16. PDN/  |        |  |          |         |         |
| STATION  | OP NO. | 17. WORK TO BE ACCOMPLISHED              | 18. MECH | 19. "P" | 20. "Q" |
| 95   | 650    | INSTALL (-28) DOUBLER                    |          | /       | /       |
|  | MBPAB  | REQ'D _____ NOT REQ'D _____              |          |         |         |
| 95   | 655    | INSTALL (-99) LONGERON                   |          | /       | /       |
|  | MBPAB  | REQ'D _____ NOT REQ'D _____              |          |         |         |
| 95   | 660    | INSTALL (-88) DOUBLER                    |          | /       | /       |
|  | MBPAB  | REQ'D _____ NOT REQ'D _____              |          |         |         |
| 95   | 665    | INSTALL (-91) LONGERON                   |          | /       | /       |
|  | MBPAB  | REQ'D _____ NOT REQ'D _____              |          |         |         |
| 95   | 670    | INSTALL (-62) LONGERON                   |          | /       | /       |
|  | MBPAB  | REQ'D _____ NOT REQ'D _____              |          |         |         |
| 95   | 675    | INSTALL #2 FRAME (-12)                   |          | /       | /       |
|  | MBPAB  | REQ'D _____ NOT REQ'D _____              |          |         |         |
| 95   | 680    | INSTALL #3 FRAME (-13) OR (-36) OR (-37) |          | /       | /       |
|  | MBPAB  | REQ'D _____ NOT REQ'D _____              |          |         |         |
| 95   | 685    | INSTALL #4 FRAME (-14)                   |          | /       | /       |
|  | MBPAB  | REQ'D _____ NOT REQ'D _____              |          |         |         |
| 95   | 690    | INSTALL #5 FRAME (-15)                   |          | /       | /       |
|  | MBPAB  | REQ'D _____ NOT REQ'D _____              |          |         |         |
| 95   | 700    | INSTALL #6 FRAME (-16) OR (-101)         |          | /       | /       |
|  | MBPAB  | ASSEMBLY<br>REQ'D _____ NOT REQ'D _____  |          |         |         |
| 95   | 705    | INSTALL #7 FRAME (-17)                   |          | /       | /       |
|  | MBPAB  | REQ'D _____ NOT REQ'D _____              |          |         |         |
| 95   | 710    | INSTALL #8 FRAME (-18)                   |          | /       | /       |
|  | MBPAB  | REQ'D _____ NOT REQ'D _____              |          |         |         |
| 95   | 715    | INSTALL #9 FRAME (-19) OR (-38)          |          | /       | /       |
|  | MBPAB  | ASSEMBLY<br>REQ'D _____ NOT REQ'D _____  |          |         |         |
| 95   | 720    | INSTALL #10 FRAME (-20)                  |          | /       | /       |
|  | MBPAB  | REQ'D _____ NOT REQ'D _____              |          |         |         |
| 95   | 725    | INSTALL #11 FRAME (-21) OR (-39)         |          | /       | /       |
|  | MBPAB  | ASSEMBLY<br>REQ'D _____ NOT REQ'D _____  |          |         |         |
| 95   | 730    | INSTALL #12 FRAME (-22)                  |          | /       | /       |
|  | MBPAB  | REQ'D _____ NOT REQ'D _____              |          |         |         |
| 95   | 735    | INSTALL #13 FRAME (-23)                  |          | /       | /       |
|  | MBPAB  | REQ'D _____ NOT REQ'D _____              |          |         |         |
| 95   | 740    | INSTALL #14 FRAME (-24) OR (-90)         |          | /       | /       |
|  | MBPAB  | ASSEMBLY<br>REQ'D _____ NOT REQ'D _____  |          |         |         |
| *****  |        |  |          |         |         |



| STATION | OF NO. | 17.WORK TO BE ACCOMPLISHED   | 18.MECH | 19"P" | 20"Q" |
|---------|--------|--|---------|-------|-------|
| 95      | 810    | INSTALL OIL BREATHER VENT 65-1296-1<br>MBPAB REQ'D NOT REQ'D             |         | /     | /     |
| 95      | 815    | INSTALL (-56) PLATE<br>MBPAB REQ'D NOT REQ'D                             |         | /     | /     |
| 95      | 820    | INSTALL (-72) PLATE<br>MBPAB REQ'D NOT REQ'D                             |         | /     | /     |
| 95      | 825    | INSTALL (-1) SKIN<br>MBPAB REQ'D NOT REQ'D                               |         | L     | /     |
| 95      | 830    | INSTALL (-2) SKIN<br>MBPAB REQ'D NOT REQ'D                               |         | /     | /     |
| 95      | 835    | INSTALL (-3) SKIN<br>MBPAB REQ'D NOT REQ'D                               |         | /     | /     |
| 95      | 840    | INSTALL (-4) SKIN<br>MBPAB REQ'D NOT REQ'D                               |         | /     | /     |
| 95      | 845    | INSTALL (-5) SKIN<br>MBPAB REQ'D NOT REQ'D                               |         | /     | /     |
| 95      | 850    | INSTALL LATCHES AS REQUIRED<br>MBPAB REQ'D NOT REQ'D                     |         | /     | /     |
| 95      | 855    | INSTALL #1 HINGE HOOK<br>MBPAB P/N 5-96762<br>REQ'D NOT REQ'D            |         | /     | /     |
| 95      | 860    | INSTALL #2 HINGE HOOK<br>MBPAB 5-96766<br>REQ'D NOT REQ'D                |         | /     | /     |
| 95      | 865    | INSTALL #3 HINGE HOOK<br>MBPAB 5-96766-1<br>REQ'D NOT REQ'D              |         | /     | /     |
| 95      | 870    | INSTALL #4 HINGE HOOK<br>MBPAB 5-96766-2<br>REQ'D NOT REQ'D              |         | /     | /     |
| 95      | 875    | INSTALL #5 HINGE HOOK<br>MBPAB 5-96762<br>REQ'D NOT REQ'D                |         | /     | /     |
| 95      | 880    | INSTALL HINGE SPEAR (5-96719)<br>MBPAB REQ'D NOT REQ'D                   |         | /     | /     |
| 95      | 890    | DRILL ALL DRAIN HOLES<br>MBPAB IAW SOW GC1560FL/82-174                   |         | /     | /     |
| 95      | 895    | INS ALL CLIPS AS REQUIRED<br>MBPAB                                       |         | /     | /     |
| 95      | 900    | INSPECT COWLTH. ENSURE THAT ALL<br>MBPAB RIVETS ARE INSTALLED IN FRAMES, |         | E     | /     |

(CONTINUED)



STATION/OP NO. 117.WORK TO BE ACCOMPLISHED 118.MECH117"P"120"Q"

LONGERONS, CLIPS, ANGLES, DOUBLERS,  
SKINS, ETC.

95 1 905 1 SHAVE ALL HIGH RIVETS IN SKIN AND  
1 MBPAB 1 TRIM LONGERONS AND AFT EDGES.

|    |       |                                     |
|----|-------|-------------------------------------|
| 95 | 710   | PLACE COWLING IN ALIGNMENT FIXTURE  |
|    | MRPAB | AND ACCOMPLISH ALIGNMENT INSPECTION |
|    |       | CHECK.                              |

95 1 915 1 TRIM #1 SKIN IAW SOW  
1 MLPAB 1

```

95      1  920  1  INSTALL ALIGNMENT PLATES AND PINS
        1 MBPAB 1  MOVE TO MBPCB

```

|      |       |                                  |
|------|-------|----------------------------------|
| 2230 | 930   | FINAL WASH & TREAT FOR CORROSION |
|      | NDPUB |                                  |

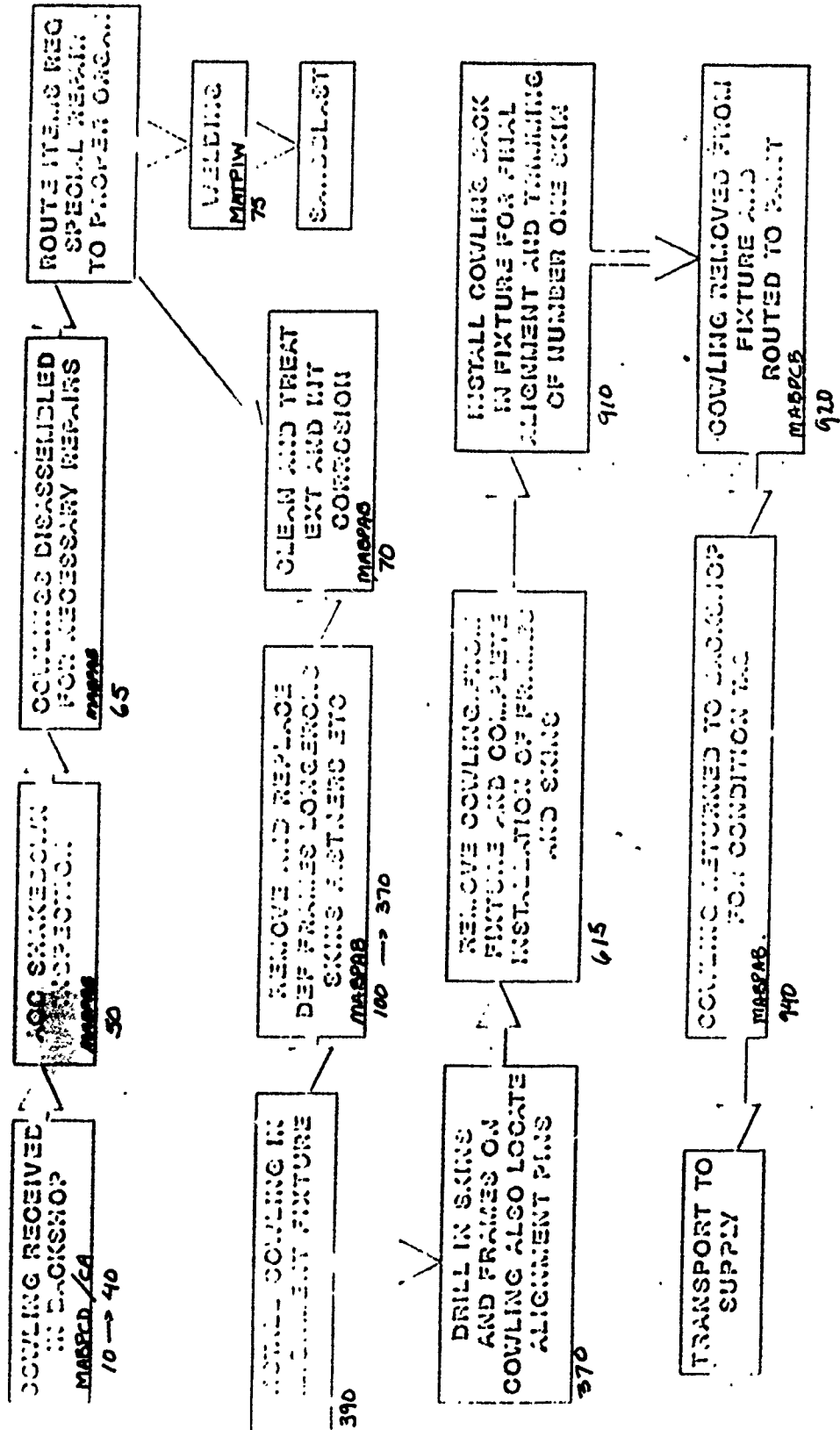
|      |       |                                    |
|------|-------|------------------------------------|
| 2280 | 935   | PAINT INTERIOR & EXTERIOR, INSTALL |
|      | MBPCB | EXTERIOR STENCILS PER COW          |
|      |       | OC1560FL/82-174                    |
|      |       | MOVE TO MBPCB                      |

95 1 940 1 WORK COMPLETE, CONDITION TAG: 3  
1 SUSPAB 1 IDENTIFY LAW TAG: 65-1

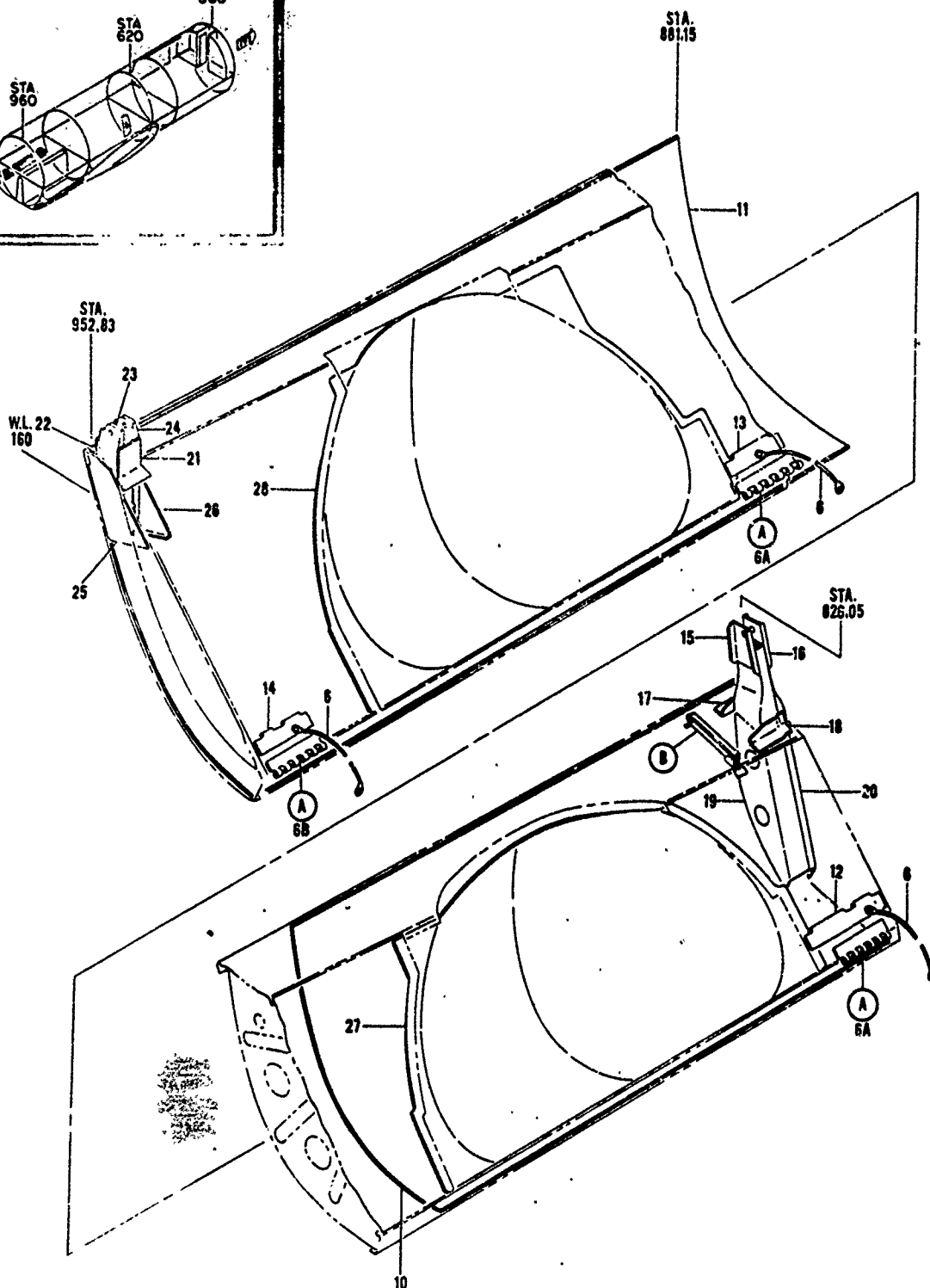
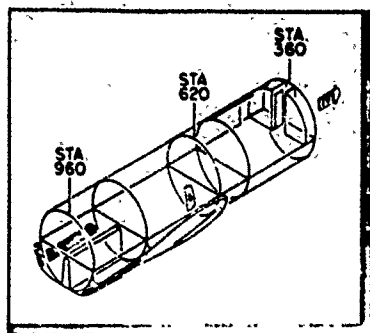
NOTE:  
ANY WORK PERFORMED AND NOT COVERED  
BY THIS DOCUMENT WILL BE NUMBERED  
AND RECORDED BELOW.

MABPAB L. STEWARD 3-22-89  
MABEBS L. MULLINAX 3-22-89  
MAUBF T. HAYES 3-22-89  
MABSCS H. NGUYEN 3-22-89

# FLOW CHART SIDE COWL REPAIR SHOP



Fuselage  
Center Section



3153-677a

Figure 675. Main Gear Outboard Door Assemblies (Sheet 1 of 2)

# FLOW PROCESS CHART

SUBJECT MLG DOOR OUTBD

DATE 4/5/89

PCN: 15119A RH  
15321A LH

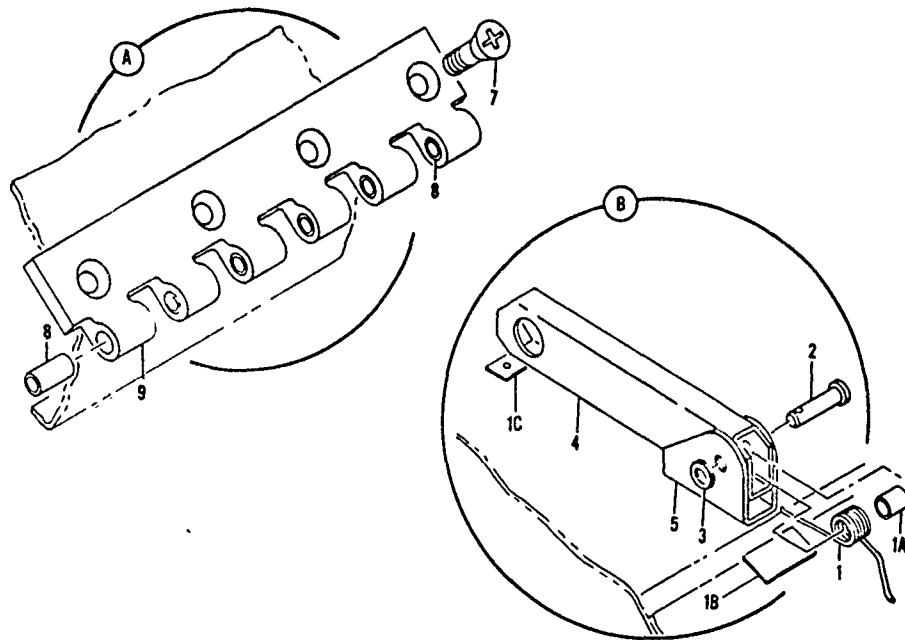
WCD: 15119A WCDDATE: 8907

CHART BEGINS:

CHART ENDS

PREPARED BY: LARRY M./RICARDO B.

| SYMBOLS       | DESCRIPTION                                       | SYMBOLS       | DESCRIPTION                                |
|---------------|---|---------------|--|
| 010 ● ◊ D □ ▽ | RECEIVE/UNCRATE<br>2122 MBPCD                     | 230 ● ◊ D □ ▽ | REPLACE JUMPER                             |
| ○ ◊ D □ ▽     | DELAY   | ○ ◊ D □ ▽     | DELAY                                      |
| ○ ◊ D □ ▽     | MOVE  | ○ ◊ D □ ▽     | MOVE To 2280                               |
| ○ ◊ D □ ▽     | DELAY   | ○ ◊ D □ ▽     | DELAY                                      |
| 020 ● ◊ D □ ▽ | WASH STRIP<br>2122 MBPCA                          | 240 ● ◊ D □ ▽ | FINAL WASH + GRASSHAWK TREAT<br>2280 MBPCA |
| ○ ◊ D □ ▽     | DELAY   | 250 ● ◊ D □ ▽ | PAINT INTERIOR                             |
| ○ ◊ D □ ▽     | MOVE To 95  | 260 ● ◊ D □ ▽ | PAINT EXTERIOR                             |
| ○ ◊ D □ ▽     | DELAY   | 270 ● ◊ D □ ▽ | STENCIL                                    |
| 030 ● ◊ D □ ▽ | SHAKEDOWN INSPECTION<br>95 MBPAB                  | ○ ◊ D □ ▽     | DELAY                                      |
| ○ ◊ D □ ▽     | DELAY   | ○ ◊ D □ ▽     | MOVE To 95                                 |
| 040 ● ◊ D □ ▽ | DISASSEMBLE FOR REPAIR                            | ○ ◊ D □ ▽     | DELAY                                      |
| 050 ● ◊ D □ ▽ | REMOVE AFT FAIRING                                | 080 ● ◊ D □ ▽ | WORK COMPLETE / CONDITION TAG              |
| 060 ● ◊ D □ ▽ | REMOVE AND TREAT INTERNAL<br>& EXTERNAL CORROSION | ○ ◊ D □ ▽     |  |
| 070 ● ◊ D □ ▽ | INSTALL IN FIXTURE<br>P/N 590CJ1110               | ○ ◊ D □ ▽     |  |
| 080 ● ◊ D □ ▽ | REPLACE WORN HINGE<br>ASSY                        | ○ ◊ D □ ▽     |  |
| 090 ● ◊ D □ ▽ | CHECK/REPAIR NUTPLATES                            | ○ ◊ D □ ▽     |  |
| 100 ● ◊ D □ ▽ | REPLACE BUSHINGS                                  | ○ ◊ D □ ▽     |  |
| 110 ● ◊ D □ ▽ | REP/REP SAFETY LINK                               | ○ ◊ D □ ▽     |  |
| 120 ● ◊ D □ ▽ | REP/REP CHANNEL                                   | ○ ◊ D □ ▽     |  |
| 130 ● ◊ D □ ▽ | REP/REP CHANNEL                                   | ○ ◊ D □ ▽     |  |
| 140 ● ◊ D □ ▽ | REP/REP TUBE HANGER<br>(-27)                      | ○ ◊ D □ ▽     |  |
| 150 ● ◊ D □ ▽ | REP/REP TUBE HANGER<br>(-29)                      | ○ ◊ D □ ▽     |  |
| 160 ● ◊ D □ ▽ | REPLACE BAD FASTENERS                             | ○ ◊ D □ ▽     |  |
| 170 ● ◊ D □ ▽ | REP/REP RIBS / LONGBOARDS                         | ○ ◊ D □ ▽     |  |
| 180 ● ◊ D □ ▽ | REMOVE FOD + CLOSE<br>DOOR INSPECTION             | ○ ◊ D □ ▽     |  |
| 190 ● ◊ D □ ▽ | SMOOTH SKIN PANELS                                | ○ ◊ D □ ▽     |  |
| 200 ● ◊ D □ ▽ | CHECK DOOR CORNERS                                | ○ ◊ D □ ▽     |  |
| 210 ● ◊ D □ ▽ | CHECK ALIGNMENT                                   | ○ ◊ D □ ▽     |  |
| 220 ● ◊ D □ ▽ | CHECK SECURITY OF<br>ATTACHMENTS                  | ○ ◊ D □ ▽     |  |

**Fuselage  
Center Section**

3153-677b

Figure 675. Main Gear Outboard Door Assemblies (Sheet 2 of 2)

| FIGURE &<br>INDEX NO. | PART NUMBER  | DESCRIPTION   | UNITS<br>PER<br>ASSY | USE<br>ON<br>CODE |
|-----------------------|--------------|---|----------------------|-------------------|
| 675 -                 |              | 1 2 3 4 5 6 7   |                      |                   |
|                       | 5-86308-5    | DOOR ASSY, OUTBOARD, MAIN GEAR (LH) (FOR NHA . . . . .  | REF                  |                   |
|                       |              | SEE FIG. 672)   |                      |                   |
|                       | 5-86308-6    | DOOR ASSY, OUTBOARD, MAIN GEAR (RH) (FOR NHA . . . . .  | REF                  |                   |
|                       |              | SEE FIG. 672)   |                      |                   |
| 1                     | 63-8412      | • SPRING, SAFETY LINK, MAIN GEAR DOOR . . . . .         | 1                    |                   |
| 1A                    | NAS43DD4-24  | • SPACER . . . . .                                      | 1                    |                   |
| 1B                    | 63-8411      | • STRIP, RUB, SAFETY LINK, MAIN GEAR DOOR (MAKE FROM    | 1                    |                   |
|                       |              | LAM THERMOSETTING SHY COTTON FABRIC PHENOLIC            |                      |                   |
|                       |              | RESIN MIL-P-15035 TYPE FBM 0.064 X 1.10 X 2.3)          |                      |                   |
| 1C                    | 63-8411-1    | • STRIP, RUB, SAFETY LINK, MAIN GEAR DOOR (MAKE FROM    | 1                    |                   |
|                       |              | LAM THERMOSETTING SHY COTTON FABRIC PHENOLIC            |                      |                   |
|                       |              | RESIN MIL-P-15035 TYPE FBM 0.064 X 1.00 X 1.8)          |                      |                   |
| 2                     | AN394-23     | • PIN (FOR REPLACEMENT ORDER MS20392-3C23) . . . . .    | 1                    |                   |
| 3                     | AN960-416L   | • WASHER . . . . .                                      | 1                    |                   |
| 4                     | 30-1572      | • LINK, SAFETY, MAIN GEAR DOOR (MAKE FROM 6800          | 1                    |                   |
|                       |              | BAC1501-684 5.80 LG)                                    |                      |                   |
| 5                     | 30-1573-1    | • FITTING, SAFETY LINK, MAIN GEAR DOOR (LH ONLY) . . .  | 1                    |                   |
|                       | 30-1573-2    | • FITTING, SAFETY LINK, MAIN GEAR DOOR (RH ONLY) . . .  | 1                    |                   |
| 6                     | MS25083-2886 | • JUMPER ASSY . . . . .                                 | 3                    |                   |
|                       |              | (ATTACHING PARTS)                                       |                      |                   |
|                       | NAS603-10    | • SCREW (FOR REPLACEMENT ORDER NAS603-10P) . . . . .    | 3                    |                   |
|                       | BACW10P151AL | • WASHER, PLAIN . . . . .                               | 3                    |                   |
|                       | BACW10T17L   | • WASHER, 5052 AL (FOR REPLACEMENT ORDER NAS1197-10L) . | 3                    |                   |
| 6A                    | 9-65317-1    | • HINGE HALF ASSY, OUTBOARD, MAIN GEAR DOOR . . . . .   | 2                    |                   |
| 6B                    | 9-65317-5    | • HINGE HALF ASSY, OUTBOARD, MAIN GEAR DOOR (LH ONLY) . | 1                    |                   |
|                       | 9-65317-6    | • HINGE HALF ASSY, OUTBOARD, MAIN GEAR DOOR (RH ONLY) . | 1                    |                   |
|                       |              | (ATTACHING PARTS)                                       |                      |                   |
| 7                     | NAS517-4-7   | • SCREW (FOR REPLACEMENT ORDER BACB30LU4-7) . . . . .   | 12                   |                   |
| 8                     | AA397        | • BEARING, SINTERED, PLAIN COP-TIN (90646) . . . . .    | 6                    |                   |
|                       |              | (ALTERNATES C250V0500 (71129) P349-32 (79039)           |                      |                   |
|                       |              | A2505-3145-32 (00481)) (BACB10D130)                     |                      |                   |

CHANGED 28 JUNE 1967

2-1759

Section II  
Group Assembly Parts List

T.O.1C-135 A-4

| FIGURE &<br>INDEX NO. | PART NUMBER | DESCRIPTION  | UNITS<br>PER<br>ASSY | USE<br>ON<br>CODE |
|-----------------------|-------------|--|----------------------|-------------------|
|                       |             | 1 2 3 4 5 6 7  |                      |                   |
| 675-                  |             |  |                      |                   |
| 9                     | 9-65317-3   | . . HINGE HALF, OUTBOARD, MAIN GEAR DOOR (USED ON . .<br>9-65317-1)      | 1                    |                   |
| 9                     | 9-65317-7   | . . HINGE HALF, OUTBOARD, MAIN GEAR DOOR (USED CN . .<br>9-65317-5)      | 1                    |                   |
|                       | 9-65317-8   | . . HINGE HALF, OUTBOARD, MAIN GEAR DOOR (USED ON . .<br>9-65317-6)      | 1                    |                   |
| 10                    | 5-86308-15  | . PANEL, FOWARD OUTBOARD SKIN, MAIN GEAR OUTBOARD DOOR<br>(LH ONLY)      | 1                    |                   |
|                       | 5-86308-16  | . PANEL, FOWARD OUTBOARD SKIN, MAIN GEAR OUTBOARD DOOR<br>(RH ONLY)      | 1                    |                   |
| 11                    | 5-86308-17  | . PANEL, AFT OUTBOARD SKIN, MAIN GEAR OUTBOARD DOOR .<br>(LH ONLY)       | 1                    |                   |
|                       | 5-86308-18  | . PANEL, AFT OUTBOARD SKIN, MAIN GEAR OUTBOARD DOOR .<br>(RH ONLY)       | 1                    |                   |
| 12                    | 5-86308-53  | . GUSSET, MAIN GEAR OUTBOARD DOOR (LH ONLY) . . . . .                    | 1                    |                   |
|                       | 5-86308-54  | . GUSSET, MAIN GEAR OUTBOARD DOOR (RH ONLY) . . . . .                    | 1                    |                   |
| 13                    | 5-86308-55  | . GUSSET, MAIN GEAR OUTBOARD DOOR (LH ONLY) . . . . .                    | 1                    |                   |
|                       | 5-86308-56  | . GUSSET, MAIN GEAR OUTBOARD DOOR (RH ONLY) . . . . .                    | 1                    |                   |
| 14                    | 5-86308-57  | . GUSSET, MAIN GEAR OUTBOARD DOOR (LH ONLY) . . . . .                    | 1                    |                   |
|                       | 5-86308-58  | . GUSSET, MAIN GEAR OUTBOARD DOOR (RH ONLY) . . . . .                    | 1                    |                   |
| 15                    | 5-86308-31  | . CHANNEL, MAIN GEAR OUTBOARD DOOR . . . . .                             | 1                    |                   |
| 16                    | 5-86308-32  | . CHANNEL, MAIN GEAR OUTBOARD DOOR . . . . .                             | 1                    |                   |
| 17                    | 60-2623-1   | . CLIP, MAIN GEAR OUTBOARD DOOR (LH ONLY) . . . . .                      | 1                    |                   |
|                       | 60-2623-2   | . CLIP, MAIN GEAR OUTBOARD DOOR (RH ONLY) . . . . .                      | 1                    |                   |
| 18                    | 60-2623-3   | . CLIP, MAIN GEAR OUTBOARD DOOR (LH ONLY) . . . . .                      | 1                    |                   |
|                       | 60-2623-4   | . CLIP, MAIN GEAR OUTBOARD DOOR (RH ONLY) . . . . .                      | 1                    |                   |
| 19                    | 5-86308-25  | . BRACKET, HALF, MAIN GEAR OUTBOARD DOOR (LH ONLY) . .                   | 1                    |                   |
|                       | 5-86308-63  | . BRACKET, HALF, MAIN GEAR OUTBOARD DOOR (RH ONLY) . .                   | 1                    |                   |
| 20                    | 5-86308-26  | . BRACKET, HALF, MAIN GEAR OUTBOARD DOOR (LH ONLY) . .                   | 1                    |                   |
|                       | 5-86308-64  | . BRACKET, HALF, MAIN GEAR OUTBOARD DOOR (RH ONLY) . .                   | 1                    |                   |
| 21                    | 60-2622-1   | . CLIP, MAIN GEAR OUTBOARD DOOR (LH ONLY) . . . . .                      | 1                    |                   |
|                       | 60-2622-2   | . CLIP, MAIN GEAR OUTBOARD DOOR (RH ONLY) . . . . .                      | 1                    |                   |
| 22                    | 60-2622-3   | . CLIP, MAIN GEAR OUTBOARD DOOR (LH ONLY) . . . . .                      | 1                    |                   |
|                       | 60-2622-4   | . CLIP, MAIN GEAR OUTBOARD DOOR (RH ONLY) . . . . .                      | 1                    |                   |
| 23                    | 5-86308-27  | . TUBE, HANGER BRACKET, MAIN GEAR OUTBOARD DOOR . . .<br>(LH ONLY)       | 1                    |                   |
|                       | 5-86308-28  | . TUBE, HANGER BRACKET, MAIN GEAR OUTBOARD DOOR . . .<br>(RH ONLY)       | 1                    |                   |
| 24                    | 5-86308-29  | . TUBE, HANGER BRACKET, MAIN GEAR OUTBOARD DOOR . . .<br>(LH ONLY)       | 1                    |                   |
|                       | 5-86308-30  | . TUBE, HANGER BRACKET, MAIN GEAR OUTBOARD DOOR . . .<br>(RH ONLY)       | 1                    |                   |
| 25                    | 5-86308-33  | . STIFFENER, MAIN GEAR OUTBOARD DOOR (LH ONLY) . . . .                   | 1                    |                   |
|                       | 5-86308-34  | . STIFFENER, MAIN GEAR OUTBOARD DOOR (RH ONLY) . . . .                   | 1                    |                   |
| 26                    | 5-86308-35  | . STIFFENER, MAIN GEAR OUTBOARD DOOR (LH ONLY) . . . .                   | 1                    |                   |
|                       | 5-86308-36  | . STIFFENER, MAIN GEAR OUTBOARD DOOR (RH ONLY) . . . .                   | 1                    |                   |
| 27                    | 5-97061-1   | . FAIRING, FORWARD WHEEL, MAIN LANDING GEAR OUTBOARD .<br>DOOR (LH ONLY) | 1                    |                   |
|                       | 5-97061-2   | . FAIRING, FOWARD WHEEL, MAIN LANDING GEAR OUTBOARD .<br>DOOR (RH ONLY)  | 1                    |                   |
| 28                    | 5-97061-3   | . FAIRING, AFT WHEEL, MAIN LANDING GEAR OUTBOARD DOOR<br>(LH ONLY)       | 1                    |                   |
|                       | 5-97061-2   | . FAIRING, AFT WHEEL, MAIN LANDING GEAR OUTBOARD DOOR<br>(RH ONLY)       | 1                    |                   |

\*\*\*\*\*  
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\*\*\*\*\*  
 12.Orig/PROD NR 13.QUANTITY 14.PROD SECTION/RCC 15.DATE SCHED 16.DATE COMP  
 | | MBPAB | 89093 |

17.PART NUMBER 19.ITEM SERIAL NR 18/12.TECH DATA/OPTIONAL  
 | | | REVI AUG 01-78, REV

10.MODEL/DESIGN/SERIES 11.STOCK NR | WORK STATEMENT UC-1560  
 | KC-135 | | FL/78-1-25, 27 JUN 78  
 | | | 1C 135(K)A-3-3, & 4

13.MISC 14.NOUN/END ITEM NOUN  
 | | MLG DOOR - OUTBO

PHYLLIS HEALD/MBPAB/65265

P/N NON C/N

1560003397220FL 15119A

5-86308-5(M) 1560003404191FL 15321A

15.DISP-16.PDN/

STATION/OP NO. 17.WORK TO BE ACCOMPLISHED 18.NECH 19" 120"Q"

|      |       |                             |   |   |
|------|-------|-----------------------------|---|---|
| 2122 | 010   | RECEIVE AND UNCRATE MOVE TO | / | / |
|      | MBPCA | MBPCA                       |   |   |

|      |       |                              |   |   |
|------|-------|------------------------------|---|---|
| 2122 | 020   | WASH AND STRIP, MOVE TO BLDG | / | / |
|      | MBPCA | 95 MBPAB                     |   |   |

|    |       |                      |   |   |
|----|-------|----------------------|---|---|
| 95 | 030   | SHAKEDOWN INSPECTION | / | / |
|    | MBPAB |                      |   |   |

|    |       |                                   |   |   |
|----|-------|-----------------------------------|---|---|
| 95 | 040   | DISASSEMBLE AS REQUIRED TO ACCOM- | / | / |
|    | MBPAB | LISH REPAIR.                      |   |   |

|    |       |                     |   |   |
|----|-------|---------------------|---|---|
| 95 | 050   | REMOVE AFT. FAIRING | / | / |
|    | MBPAB | REQ NOT REQ         |   |   |

|    |       |                               |   |   |
|----|-------|-------------------------------|---|---|
| 95 | 060   | REMOVE AND TREAT INTERNAL AND | E | / |
|    | MBPAB | EXTERNAL CORROSION            |   |   |

|    |       |                             |   |   |
|----|-------|-----------------------------|---|---|
| 95 | 070   | INSTALL MLG DOOR IN JIG P/N | / | / |
|    | MBPAB | 590CJ1110 - CHECK ALIGNMENT |   |   |

|    |       |                        |   |   |
|----|-------|------------------------|---|---|
| 95 | 080   | RELACE WORN HINDE ASSY | / | / |
|    | MBPAB | REQ NOT REQ            |   |   |

|    |       |                  |   |   |
|----|-------|------------------|---|---|
| 95 | 090   | CHECK NUT FLATES | / | / |
|    | MBPAB | REQ NOT REQ      |   |   |

|    |       |                  |   |   |
|----|-------|------------------|---|---|
| 95 | 100   | REPLACE BUSHINGS | / | / |
|    | MBPAB | REQ NOT REQ      |   |   |

|    |       |                               |   |   |
|----|-------|-------------------------------|---|---|
| 95 | 110   | REPAIR OR REPLACE SAFETY LINK | / | / |
|    | MBPAB | P/N 30-1572                   |   |   |
|    |       | REQ NOT REQ                   |   |   |

|    |       |                           |   |   |
|----|-------|---------------------------|---|---|
| 95 | 120   | REPAIR OR REPLACE CHANNEL | / | / |
|    | MBPAB | P/N 5-86308-31            |   |   |
|    |       | REQ NOT REQ               |   |   |

|    |       |                           |   |   |
|----|-------|---------------------------|---|---|
| 95 | 130   | REPAIR OR REPLACL CHANNEL | / | / |
|    | MBPAB | P/N 5-86308-32            |   |   |
|    |       | REQ NOT REQ               |   |   |

\*\*\*\*\*

| *****  |        |                                      |              |         |         |
|--|--------|--------------------------------------|--------------|---------|---------|
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| 15. DISP-16. PDN/  |        |                                      |              |         |         |
| STATION  | OP NO. | 17. WORK TO BE ACCOMPLISHED          | 18. MECH     | 19. "P" | 20. "R" |
| 95   | 140    | REPAIR OR REPLACE TUBE HANGER        |              | /       | /       |
|  | MBFAB  | BRACKET L/H 5-86308-27               |              |         |         |
|  |        | R/H 5-86308-28                       |              |         |         |
|  |        | REQ _____ NOT REQ _____              |              |         |         |
| 95   | 150    | REPAIR OR REPLACE TUBE HANGER        |              | /       | /       |
|  | MBFAB  | BRACKET L/H 5-86308-29               |              |         |         |
|  |        | R/H 5-86308-30                       |              |         |         |
|  |        | REQ _____ NOT REQ _____              |              |         |         |
| 95   | 160    | REPAIR OR REPLACE LOOSE,             |              | /       | /       |
|  | MBFAB  | MISSING OR DEFECTIVE FASTENERS,      |              |         |         |
|  |        | PINS, NUTS AND BOLTS.                |              |         |         |
|  |        | REQ _____ NOT REQ _____              |              |         |         |
| 95   | 170    | REPAIR OR REPLACE RIDS AND LONGERONS |              | /       |         |
|  | MBFAB  | REQ _____ NOT REQ _____              |              |         |         |
| 95   | 180    | REMOVE FOREIGN MATERIAL AND CLOSE    |              | E       | /       |
|  | MBFAB  | OUT INSPECTION.                      |              |         |         |
|  |        | REQ _____ NOT REQ _____              |              |         |         |
| 95   | 190    | SMOOTH OUT SKIN PANELS LESS THAN 20% | Replace 10   | L       | /       |
|  | MBFAB  | DAMAGE MORE THAN 20%, REPLACE SKIN   | Repair 2 hrs |         |         |
|  |        | REQ'D _____ NOT REQ'D _____          |              |         |         |
| 95   | 200    | CHECK THAT DOOR CORNERS ARE NOT      |              | /       | /       |
|  | MBFAB  | SEALED AND ARE FREE OF DIRT.         |              |         |         |
| 95   | 210    | CHECK ALIGNMENT WITH MLGR DOOR       |              | L       | /       |
|  | MBFAB  | IN JIG P/N 590CJ1110                 |              |         |         |
| 95   | 220    | CHECK ENTIRE MLG DOOR FOR SECUR-     |              | E       | /       |
|  | MBFAB  | ITY OF ATTACHMENTS BEFORE REMOVAL    |              |         |         |
|  |        | FROM FIXTURE.                        |              |         |         |
| 95   | 230    | REPLACE JUMPLER ASBY                 |              | /       | /       |
|  | MBFAB  | REQ _____ NOT REQ _____              |              |         |         |
|  |        | MOVE TO MBPCB                        |              |         |         |
| 2280   | 240    | FINAL WASH AND CORROSION TREAT       |              | /       | /       |
|  | MBPCB  | REQ _____ NOT REQ _____              |              |         |         |
| 2280   | 250    | PAINT INTERIOR WITH EPOXY PRIMER     |              | /       | /       |
|  | MBPCB  | PAINT-P-23377 AND POLYURETHANE PER   |              |         |         |
|  |        | MIL-C-83286 COLOR 37200 NOTE: TAPE   |              |         |         |
|  |        | BUSHINGS AND HINGE BUSHING           |              |         |         |
| 2280   | 260    | PAINT EXTERIOR IAW 10 1C-135(K)      |              | /       | /       |
|  | MBPCB  | A-3-4 SECT XI PARA 11-30             |              |         |         |
| 2280   | 270    | INSTALL ALL STENCILS IAW DRAWING     |              | /       | /       |
|  | MBPCB  | 5-86308                              |              |         |         |
|  |        | NOTE: PARTS STOCKLISTED AS FIELD OR  |              |         |         |
|  |        | DEPOT MANUFACTURE, AND NON-STOCK     |              |         |         |
|  |        | LISTED PARTS WITHIN THE              |              |         |         |
|  |        | CAPABILITY OF THE REPAIR FACILITY,   |              |         |         |
|  |        | WILL BE LOCALLY FABRICATED TO ENABLE |              |         |         |
| *****  |        |                                      |              |         |         |

(CONTINUED)

2 people - 21 hrs  
24 hrs + 12 + 3 hrs  
Replace 10  
Repair 2 hrs



| *****   |              |  |  |                     |  |
|---|--------------|--|--|---------------------|--|
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| 15.DISP-16.PDN/   |              |  |  |                     |  |
| STATION/DP NO.  |              | 117.WORK TO BE ACCOMPLISHED  |  | 118.MECH/19"P/20"Q" |  |
|   |              | COMPLETION OF THE UNITS UNDERGOING REPAIR<br>MOVE TO 95, MABPAB  |  |                     |  |
| 95  | 280<br>MBPAB | WORK COMPLETED, CONDITION TAG CONDITION TAGGED AFW 67-1.<br>DATE _____<br>MOVE TO CRATING<br>NOTE: PART WILL HAVE OC-ALC FORM 586, 587, OR 588 IDENTIFICATION LABELS APPLIED TO COMPLETED ITEM<br>AFLCR 66-51 CHG. 1, PARA 2.<br>ACCEPTANCE DATE ON THE LABEL<br>ALONG WITH "M" STAMP OF THE PERSON PERFORMING THE OVERHAUL<br>CAUTION:<br>SURFACES TO WHICH LABELS ARE APPLIED MUST BE FREE OF CONTAMINATION.<br>NOTE: COMPLETE "REMARKS" COLUMN OF AFLO FORM 1574 IAW MAOI 66-36.<br>THIS PARAGRAPH IS NOT APPLICABLE TO NON-PROGRAMMED AIRCRAFT WORKLOAD. |  |                     |  |
|   |              | COORDINATION<br>NAME DATE<br>MABSCS CONNIE WEBBER 22 MARCH 89<br>MAQBF TED HAYES 22 MARCH 89<br>MABPAB JESSIE JACOBS 22 MARCH 89<br>MABEBS PHYLLIS HEALD 22 MARCH 89   |  |                     |  |

# Fuselage Center Section

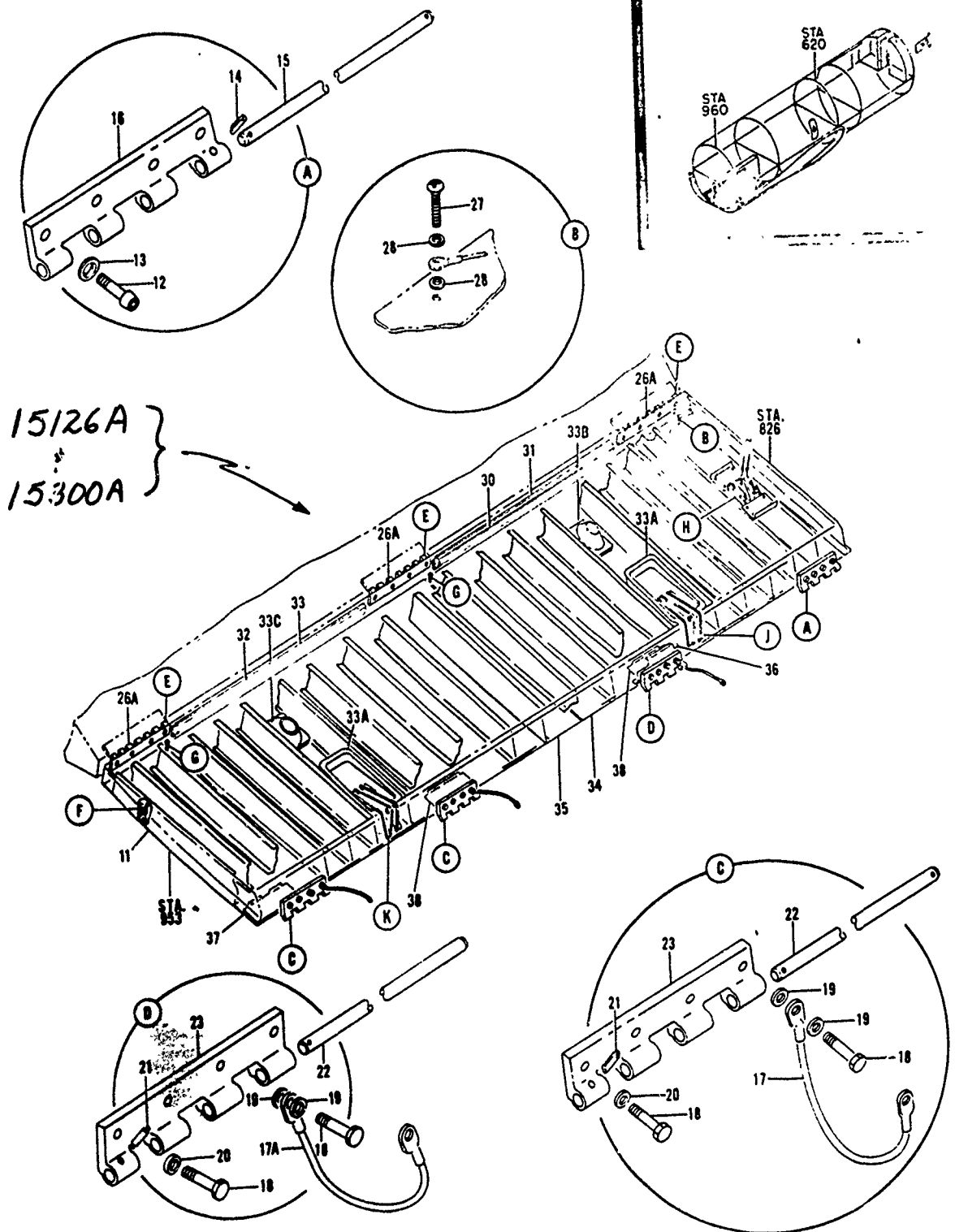


Figure 673. Main Gear Inboard Door Assemblies (Sheet 1 of 3)

# FLOW PROCESS CHART

SUBJECT: M66 Door Endd Ltr or RH

DATE: 4/5/89

PCN: 15126A  
15300A

WCD: 15126A

WCD DATE: 89073

CHART BEGINS: Operation 210

CHART ENDS: Operation 270

PREPARED BY: Tim Hall

| SYMBOLS     | DESCRIPTION  | SYMBOLS     | DESCRIPTION                         |
|-------------|--|-------------|-------------------------------------|
| 110 ● ◊ ▢ ▽ | Receive and uncrate<br>2122 MABPCA                     | ○ ◊ ▢ ▽     | Move to 2280<br>2280 MABPCA         |
| ○ ◊ ▢ ▽     | Delay  | ○ ◊ ▢ ▽     | Delay                               |
| ○ ◊ ▢ ▽     | Move to MABPCA<br>2122 MABPCA                          | 230 ● ◊ ▢ ▽ | Final Wash & Corrosion<br>Treat     |
| ○ ◊ ▢ ▽     | Delay  | 240 ● ◊ ▢ ▽ | Paint interior with<br>epoxy primer |
| 220 ● ◊ ▢ ▽ | Wash and strip   | 250 ● ◊ ▢ ▽ | Paint exterior                      |
| ○ ◊ ▢ ▽     | Delay  | 260 ● ◊ ▢ ▽ | Install all Stencils                |
| ○ ◊ ▢ ▽     | Move to Bldg 95<br>95 MABPCA                           | ○ ◊ ▢ ▽     | Delay                               |
| ○ ◊ ▢ ▽     | Delay  | ○ ◊ ▢ ▽     | Move to 95<br>95 MABPCA             |
| 230 ● ◊ ▢ ▽ | Shakedown  | ○ ◊ ▢ ▽     | Delay                               |
| 240 ● ◊ ▢ ▽ | Disassemble  | 270 ● ◊ ▢ ▽ | Condition Tag                       |
| 250 ● ◊ ▢ ▽ | Repair or replace seals<br>& retainers                 | ○ ◊ ▢ ▽     |                                     |
| 260 ● ◊ ▢ ▽ | Remove aft fairing                                     | ○ ◊ ▢ ▽     |                                     |
| 270 ● ◊ ▢ ▽ | Treat Corrosion  | ○ ◊ ▢ ▽     |                                     |
| 280 ● ◊ ▢ ▽ | Install M66 Door<br>in Jig                             | ○ ◊ ▢ ▽     |                                     |
| 290 ● ◊ ▢ ▽ | Replace Worn Hinge<br>Assembly                         | ○ ◊ ▢ ▽     |                                     |
| 300 ● ◊ ▢ ▽ | Replace Bushings                                       | ○ ◊ ▢ ▽     |                                     |
| 310 ● ◊ ▢ ▽ | Replace Fitting, Emergency<br>Link                     | ○ ◊ ▢ ▽     |                                     |
| 320 ● ◊ ▢ ▽ | Repair or replace defective<br>fasteners, nuts & bolts | ○ ◊ ▢ ▽     |                                     |
| 330 ● ◊ ▢ ▽ | Repair or replace ribs<br>or lag screws                | ○ ◊ ▢ ▽     |                                     |
| 340 ● ◊ ▢ ▽ | Install pans   | ○ ◊ ▢ ▽     |                                     |
| 350 ● ◊ ▢ ▽ | Remove foreign matter<br>or close out bays             | ○ ◊ ▢ ▽     |                                     |
| 360 ● ◊ ▢ ▽ | Smooth out skin panels<br>or replace if 70% damaged    | ○ ◊ ▢ ▽     |                                     |
| 370 ● ◊ ▢ ▽ | Install pan - 2393                                     | ○ ◊ ▢ ▽     |                                     |
| 380 ● ◊ ▢ ▽ | Install pan - 2394                                     | ○ ◊ ▢ ▽     |                                     |
| 390 ● ◊ ▢ ▽ | Check alignment with<br>M66 door                       | ○ ◊ ▢ ▽     |                                     |
| 400 ○ ◊ ▢ ▽ | Inspect M66 door                                       | ○ ◊ ▢ ▽     |                                     |
| 410 ○ ◊ ▢ ▽ | Inspect door corners                                   | ○ ◊ ▢ ▽     |                                     |
| 420 ● ◊ ▢ ▽ | Replace jumper assy                                    | ○ ◊ ▢ ▽     |                                     |
| ○ ◊ ▢ ▽     | Delay  | ○ ◊ ▢ ▽     |                                     |

# Fuselage Center Section

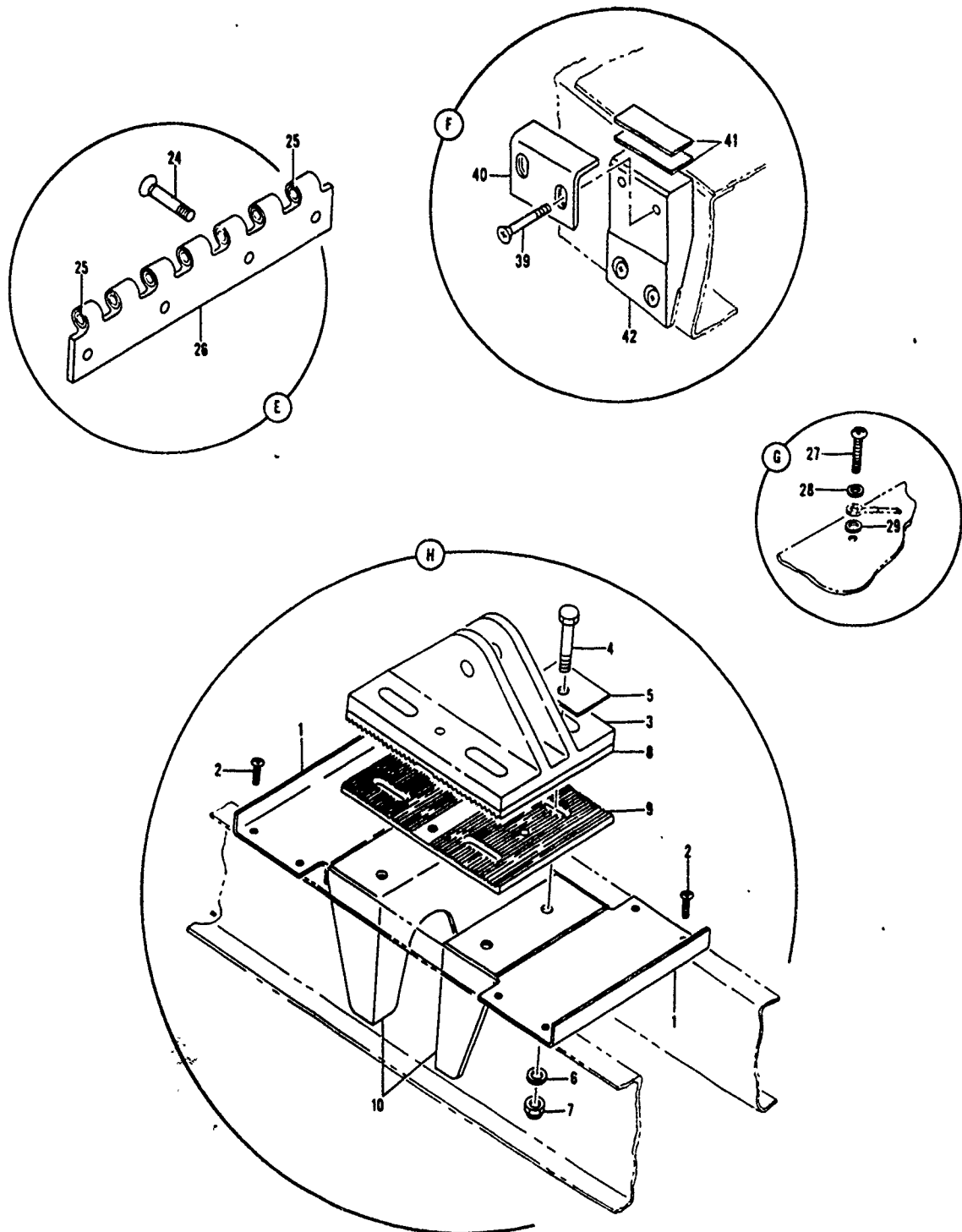


Figure 673. Main Gear Inboard Door Assemblies (Sheet 2 of 3)

# Fuselage Center Section

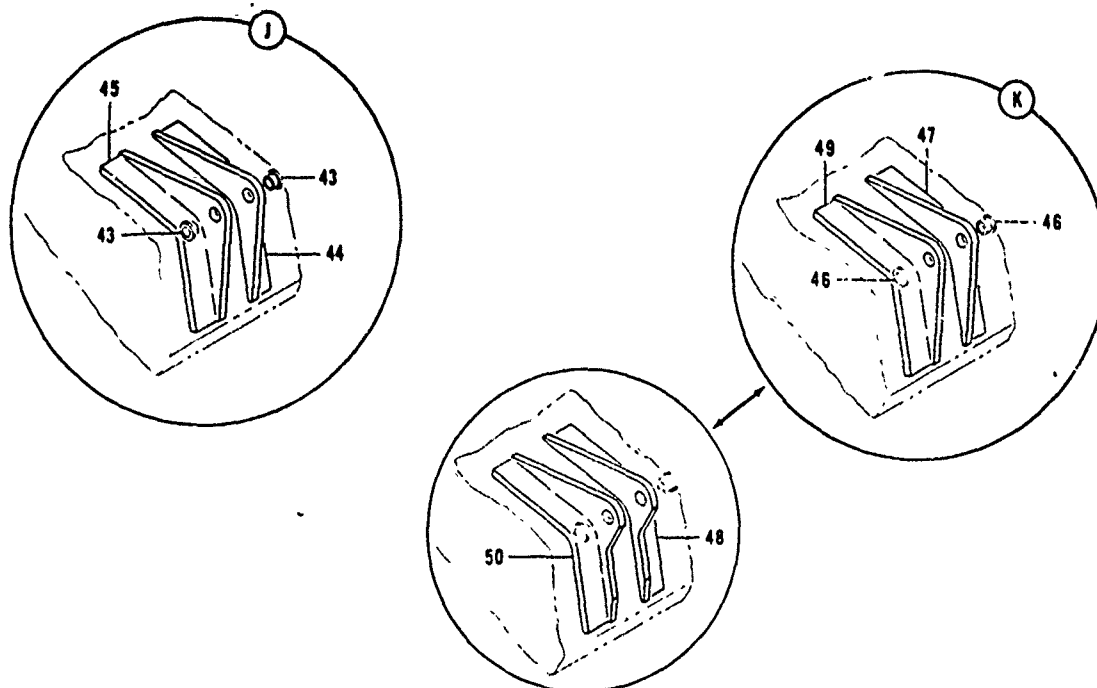


Figure 673. Main Gear Inboard Door Assemblies (Sheet 3 of 3)

| FIGURE &<br>INDEX NO. | PART NUMBER  | DESCRIPTION  |   |   |   |   |   |   | UNITS<br>PER<br>ASSY | USE<br>ON<br>CODE |
|-----------------------|--------------|--|---|---|---|---|---|---|----------------------|-------------------|
|                       |              | 1  | 2 | 3 | 4 | 5 | 6 | 7 |                      |                   |
| 673-                  | 5-86308-3    | DOOR ASSY, INBOARD, MAIN GEAR (ALTERNATE 5-86308-65). . .  |   |   |   |   |   |   | REF                  |                   |
|                       | 5-86308-4    | DOOR ASSY, INBOARD, MAIN GEAR (ALTERNATE 5-86308-66). . .  |   |   |   |   |   |   | REF                  |                   |
|                       | 65-26845-1   | DOOR ASSY, INBOARD, MAIN GEAR (5-86308-3149 REWORKED BY .  |   |   |   |   |   |   | REF                  |                   |
|                       | 65-26845-2   | 65-26845) (DETAIL ASSEMBLY OF 5-86308-65 ALTERNATE         |   |   |   |   |   |   | REF                  |                   |
| 1                     | 5-86308-23   | DOOR ASSY, INBOARD, MAIN GEAR (5-86308-3150 REWORKED BY .  |   |   |   |   |   |   | 2                    |                   |
| 1                     | 5-86308-2023 | 65-26845) (DETAIL ASSEMBLY OF 5-86308-66 ALTERNATE         |   |   |   |   |   |   | 2                    |                   |
| 2                     | NAS603-8P    | TO 5-86308-3) (RH) (FOR NHA SEE FIG. 672)                  |   |   |   |   |   |   | 8                    |                   |
| 3                     | 9-65400      | . PANEL, ACCESS, INBOARD DOOR, MAIN GEAR (USED ON . . . .  |   |   |   |   |   |   | 1                    |                   |
| 3                     | 9-65400-3000 | 5-86308-3, -4)   |   |   |   |   |   |   | 1                    |                   |
| 4                     | AN6-16A      | . BRACKET ASSY, LINKAGE, DOOR ACTUATOR, MAIN GEAR . . . .  |   |   |   |   |   |   | 4                    |                   |
| 5                     | 5-86308-38   | (USED ON 5-86308-3, -4)                                    |   |   |   |   |   |   | 4                    |                   |
| 5                     | 5-86308-2038 | . BRACKET ASSY, LINKAGE, DOOR ACTUATOR, MAIN GEAR . . . .  |   |   |   |   |   |   | 4                    |                   |
| 6                     | AN960-616    | (USED ON 65-26845-1, -2)                                   |   |   |   |   |   |   | 4                    |                   |
| 7                     | MS21042L6    | (ATTACHING PARTS)  |   |   |   |   |   |   | 4                    |                   |
| 8                     | 6-83599-1    | . BOLT (FOR REPLACEMENT ORDER BACB30NE6-19) . . . . .      |   |   |   |   |   |   | 1                    |                   |
| 9                     | 6-83599      | . FILLER, RADIUS, INBOARD DOOR, MAIN GEAR (USED ON . . . . |   |   |   |   |   |   | 1                    |                   |
|                       |              | 5-86308-3, -4)   |   |   |   |   |   |   |                      |                   |
|                       |              | . FILLER, RADIUS, INBOARD DOOR, MAIN GEAR (USED ON . . . . |   |   |   |   |   |   |                      |                   |
|                       |              | 65-26845-1, -2)  |   |   |   |   |   |   |                      |                   |
|                       |              | . WASHER. . . . .  |   |   |   |   |   |   |                      |                   |
|                       |              | . NUT (REPLACES NAS679A6) . . . . .                        |   |   |   |   |   |   |                      |                   |
|                       |              | . PLATE, SERRATED, DOOR ACTUATOR LINKAGE, MAIN GEAR . .    |   |   |   |   |   |   |                      |                   |
|                       |              | . PLATE, SERRATED, DOOR ACTUATOR LINKAGE, MAIN GEAR . .    |   |   |   |   |   |   |                      |                   |

Section II  
Group Assembly Parts List

T.O. 135A-4

| F. URE &<br>INDEX NO. | PART NUMBER     | 1 2 3 4 5 6 7 | DESCRIPTION   | UNITS<br>PER<br>ASSY | USE<br>ON<br>CODE |
|-----------------------|-----------------|---------------|---|----------------------|-------------------|
|                       |                 |               |   |                      |                   |
| 673-                  |                 |               |   |                      |                   |
| 10                    | 9-65343         |               | . FITTING, SUPPORT, DOOR DRIVE LINK ATTACHMENT, MAIN. . .<br>GEAR (USED ON 5-86308-3, -4)   | 2                    |                   |
| 10                    | 9-65343-2000    |               | . FITTING, SUPPORT, DOOR DRIVE LINK ATTACHMENT, MAIN. . .<br>GEAR (USED ON 65-26845-1, -2)  | 2                    |                   |
|                       | SALPT8-7        |               | (ATTACHING PARTS)   |                      |                   |
|                       | SALPT8-8        |               | . BOLT, FH SHAR LOCK (29666) (BACB30N8-7). . . . .  | 16                   |                   |
|                       | NAS528A7        |               | . BOLT, FH SHAR LOCK (29666) (BACB30N8-8). . . . .  | 4                    |                   |
|                       | NAS528A8        |               | . COLLAR (FOR REPLACEMENT ORDER NAS1080C7). . . . .   | 16                   |                   |
|                       |                 |               | . COLLAR (FOR REPLACEMENT ORDER NAS1080C8). . . . .   | 4                    |                   |
| 11                    | 5-96183-1       |               | . RIB INSTL, INBOARD DOOR, MAIN GEAR, LH (USED ON . . . . .<br>5-86308-1) (FOR BREAKDOWN SEE FIG. 674)  | 1                    |                   |
|                       | 5-96183-2       |               | . RIB INSTL, INBOARD DOOR, MAIN GEAR, RH (USED ON . . . . .<br>5-86308-1) (FOR BREAKDOWN SEE FIG. 674)  | 1                    |                   |
|                       | 9-65127-3       |               | . HINGE-HALF ASSY, DOOR INBOARD, MAIN GEAR (USED ON . . . . .<br>5-86308-1)   | 1                    |                   |
|                       | 9-65127-4       |               | . HINGE-HALF ASSY, DOOR INBOARD, MAIN GEAR (USED ON . . . . .<br>5-86308-1)   | 1                    |                   |
|                       | 9-65127-3003    |               | . HINGE-HALF ASSY, DOOR INBOARD, MAIN GEAR (USED ON . . . . .<br>65-26845-1)  | 1                    |                   |
|                       | 9-65127-3004    |               | . HINGE-HALF ASSY, DOOR INBOARD, MAIN GEAR (USED ON . . . . .<br>65-26845-2)  | 1                    |                   |
|                       |                 |               | (ATTACHING PARTS)   |                      |                   |
| 12                    | MS20005-13      |               | . BOLT. . . . .   | 4                    |                   |
| 13                    | MS20002C5       |               | . WASHER. . . . .   | 4                    |                   |
| 14                    | NAS561P3-12     |               | . . PIN. . . . .  | 1                    |                   |
| 15                    | 9-65127-8       |               | . . PIN, HALF HINGE, DOOR INBOARD, MAIN GEAR (USED ON . . . . .<br>9-65127-3, -4)   | 1                    |                   |
| 15                    | 9-65127-2008    |               | . . PIN, HALF HINGE, DOOR INBOARD, MAIN GEAR (USED ON . . . . .<br>9-65127-3003, -3004)   | 1                    |                   |
| 16                    | 9-65127-7       |               | . . HINGE-HALF ASSY, DOOR INBOARD, MAIN GEAR (USED ON. . . . .<br>9-65127-3, -4)  | 1                    |                   |
| 16                    | 9-65127-2007    |               | . . HINGE-HALF ASSY, DOOR INBOARD, MAIN GEAR (USED ON. . . . .<br>9-65127-3003, -3004)  | 1                    |                   |
| 17                    | MS25083-2CC4    |               | . JUMPER ASSY. . . . .  | 2                    |                   |
| 17A                   | MS25083-2BC4    |               | . JUMPER ASSY. . . . .  | 1                    |                   |
|                       | 9-65125         |               | . HINGE-HALF ASSY, DOOR INBOARD, MAIN GEAR (FOR I/W . . . . .<br>INFO SEE 9-65125-5) (USED ON 5-86308-3 AND -4)                                 | 3                    | B                 |
|                       | 9-65125-5       |               | . HINGE-HALF ASSY, DOOR INBOARD, MAIN GEAR (I/W . . . . .<br>9-65125-5) (USE 9-65125-1 UNTIL EXHAUSTED) (USED<br>ON 5-86308-3 AND -4)           | 3                    | A                 |
|                       | 9-65125-2000    |               | . HINGE-HALF ASSY, DOOR INBOARD, MAIN GEAR (USED ON . . . . .<br>65-26845-1 AND -2)   | 3                    |                   |
|                       |                 |               | (ATTACHING PARTS)   |                      |                   |
| 18                    | AN4-10A         |               | . BOLT (FOR REPLACEMENT ORDER BACB30NE4-9). . . . .   | 12                   |                   |
| 19                    | BACW10P142AL    |               | . WASHER. . . . .   | 6                    |                   |
| 20                    | AN960D416       |               | . WASHER. . . . .   | 9                    |                   |
| 21                    | 52-022-094-0812 |               | . . PIN, SPG (72962) (ALTERNATE 23S094-0812 (56878) . . . . .<br>094-0812HBS (00287)) (BACP18L6P0812)   | 1                    |                   |
| 22                    | 9-65125-4       |               | . . PIN, HALF HINGE, DOOR INBOARD, MAIN GEAR (USED ON . . . . .<br>9-65125-5)   | 1                    | B                 |
| 22                    | 9-65125-4       |               | . . PIN, HALF HINGE, DOOR INBOARD, MAIN GEAR (USED ON . . . . .<br>9-65125-2000)  | 1                    |                   |
| 22                    | 9-65125-6       |               | . . PIN, HALF HINGE, DOOR INBOARD, MAIN GEAR (USED ON . . . . .<br>9-65125-5)   | 1                    | A                 |
| 23                    | 9-65125-2       |               | . . HINGE-HALF ASSY, DOOR INBOARD, MAIN GEAR (USED ON. . . . .<br>9-65125-5)  | 1                    |                   |
| 23                    | 9-65125-2002    |               | . . HINGE-HALF ASSY, DOOR INBOARD, MAIN GEAR (USED ON. . . . .<br>9-65125-2000)   | 1                    |                   |
|                       | 9-35317         |               | . HINGE-HALF ASSY, DOOR OUTBOARD, MAIN GEAR (USED ON. . . . .<br>5-86308-3, -4)   | 3                    |                   |
|                       |                 |               | (ATTACHING PARTS)   |                      |                   |
| 24                    | NAS517-4-7      |               | . SCREW (FOR REPLACEMENT ORDER 3ACB30LU4-7) . . . . .   | 12                   |                   |
| 25                    | AA397           |               | . . BEARING, MAIN (COPPER-TIN SINTERED) (70417). . . . .<br>(ALTERNATES C250V0500 (71129) P349-32 (79039)<br>A250-1145-32 (00481)) (BACB10D130) | 7                    |                   |
| 26                    | 9-65317-2       |               | . . HINGE-HALF ASSY, DOOR OUTBOARD, MAIN GEAR. . . . .  | 1                    |                   |
| 26A                   | 9-65317-3000    |               | . HINGE-HALF ASSY, DOOR OUTBOARD, MAIN GEAR (USED ON. . . . .<br>65-26845-1, -2)  | 3                    |                   |
|                       |                 |               | (ATTACHING PARTS)   |                      |                   |
|                       | NAS517-4-7      |               | . SCREW (FOR REPLACEMENT ORDER BACB30LU4-7) . . . . .   | 12                   |                   |
| 27                    | NAS603-7        |               | . SCREW (FOR REPLACEMENT ORDER NAS603-7P) (USED ON. . . . .<br>5-86308-3, -4)   | 3                    |                   |

| FIGURE &<br>INDEX NO. | PART NUMBER  | DESCRIPTION   | UNITS<br>PER<br>ASSY | USE<br>ON<br>CODE |
|-----------------------|--------------|---|----------------------|-------------------|
|                       |              | 1 2 3 4 5 6 7   |                      |                   |
| 673-                  |              |   |                      |                   |
| 27                    | AN520-10R7   | . SCREW (FOR REPLACEMENT ORDER NAS603-7P) (USED ON . . . .<br>65-26845-1, -2)   | 3                    |                   |
| 28                    | BACW10P151AL | . WASHER, PLAIN . . . . .   | 4                    |                   |
| 29                    | BACW10T10L   | . WASHER, 5052 AL (FOR REPLACEMENT ORDER NAS1197-10L) . . . .   | 2                    |                   |
|                       | 5-86308-39   | . SEAL ASSY, FORWARD, MAIN GEAR DOOR, LH (LH ONLY) (FOR<br>REPLACEMENT USE BAC1521-274 AND 5-86308-43)                      | 1                    |                   |
|                       | 5-86308-40   | . SEAL ASSY, FORWARD, MAIN GEAR DOOR, RH (RH ONLY) (FOR<br>REPLACEMENT USE BAC1521-274 AND 5-86308-44)<br>(ATTACHING PARTS) | 1                    |                   |
|                       | NAS603-8     | . SCREW (FOR REPLACEMENT ORDER NAS603-8P) . . . . .   | 12                   |                   |
| 30                    | 5-86308-41   | . . SEAL RUBBER, DOOR FORWARD, MAIN GEAR (MAKE FROM . . . .<br>BAC1521-274 X 53.6) (LH ONLY)                                | 1                    |                   |
|                       | 5-86308-42   | . . SEAL, RUBBER, DOOR FORWARD, MAIN GEAR (MAKE FROM . . . .<br>BAC1521-274 X 53.6) (RH ONLY)                               | 1                    |                   |
| 31                    | 5-86308-43   | . . RETAINER, SEAL, DOOR FORWARD, MAIN GEAR (MAKE FROM . . . .<br>BAC1492-169 X 60) (LH ONLY)                               | 1                    |                   |
|                       | 5-86308-44   | . . RETAINER, SEAL, DOOR FORWARD, MAIN GEAR (MAKE FROM . . . .<br>BAC1492-169 X 60) (RH ONLY)                               | 1                    |                   |
|                       | 5-86308-45   | . SEAL ASSY, DOOR AFT, MAIN GEAR, LH (LH ONLY) . . . . .  | 1                    |                   |
|                       | 5-86308-46   | . SEAL ASSY, DOOR AFT, MAIN GEAR, RH (RH ONLY) . . . . .<br>(ATTACHING PARTS)   | 1                    |                   |
|                       | NAS603-8     | . SCREW (FOR REPLACEMENT ORDER NAS603-8P) . . . . .   | 12                   |                   |
| 32                    | 5-86308-47   | . . SEAL, RUBBER, DOOR AFT, MAIN GEAR (MAKE FROM . . . .<br>BAC1521-274 X 50.8) (LH ONLY)                                   | 1                    |                   |
|                       | 5-86308-48   | . . SEAL, RUBBER, DOOR AFT, MAIN GEAR (MAKE FROM . . . .<br>BAC1521-274 X 50.8) (RH ONLY)                                   | 1                    |                   |
| 33                    | 5-86308-49   | . . RETAINER, SEAL, DOOR AFT, MAIN GEAR (LH ONLY) . . . . .   | 1                    |                   |
|                       | 5-86308-50   | . . RETAINER, SEAL, DOOR AFT, MAIN GEAR (RH ONLY) . . . . .   | 1                    |                   |
| 33A                   | 9-67575      | . PAN, BAR, DOOR SAFETY, MAIN LANDING GEAR (USED ON . . . .<br>5-86308-3, -4)   | 2                    |                   |
| 33A                   | 69-9342      | . PAN, BAR, DOOR SAFETY, MAIN LANDING GEAR (USED ON . . . .<br>65-26845-1, -2)  | 2                    |                   |
| 33B                   | 90-2394      | . PAN, CLEARANCE, DOOR AXLE, MAIN GEAR . . . . .  | 1                    |                   |
| 33C                   | 90-2393      | . PAN, CLEARANCE, DOOR AXLE, MAIN GEAR . . . . .  | 1                    |                   |
| 34                    | 5-86308-9    | . SKIN, OUTBOARD PANEL, INBOARD DOOR, MAIN GEAR . . . . .<br>(USED ON 5-86308-3)  | 1                    |                   |
|                       | 5-86308-10   | . SKIN, PANEL, FORWARD OUTBOARD, INBOARD DOOR, MAIN . . . .<br>GEAR (USED ON 5-86308-4)                                     | 1                    |                   |
| 34                    | 5-86308-3139 | . SKIN, FORWARD PANEL, INBOARD DOOR, MAIN GEAR (USED ON . . . .<br>65-26845-1)  | 1                    |                   |
|                       | 5-86308-3140 | . SKIN, FORWARD PANEL, INBOARD DOOR, MAIN GEAR (USED ON . . . .<br>65-26845-2)  | 1                    |                   |
| 35                    | 5-86308-11   | . SKIN, OUTBOARD PANEL, INBOARD DOOR AFT, MAIN GEAR . . . .<br>(USED ON 5-86308-3)  | 1                    |                   |
|                       | 5-86308-12   | . SKIN, OUTBOARD PANEL, INBOARD DOOR AFT, MAIN GEAR . . . .<br>(USED ON 5-86308-4)  | 1                    |                   |
| 35                    | 5-86308-3119 | . SKIN, OUTBOARD PANEL, INBOARD DOOR AFT, MAIN GEAR . . . .<br>(USED ON 65-26845-1)   | 1                    |                   |
|                       | 5-86308-3120 | . SKIN, OUTBOARD PANEL, INBOARD DOOR AFT, MAIN GEAR . . . .<br>(USED ON 65-26845-2)   | 1                    |                   |
| 36                    | 30-2222-1    | . CLIP, CHANNEL, INBOARD DOOR, MAIN GEAR (USED ON . . . .<br>5-86308-3)   | 1                    |                   |
|                       | 30-2222-2    | . CLIP, CHANNEL, INBOARD DOOR, MAIN GEAR (USED ON . . . .<br>5-86308-4)   | 1                    |                   |
| 36                    | 30-2222-3001 | . CLIP, CHANNEL, INBOARD DOOR, MAIN GEAR (USED ON . . . .<br>65-26845-1)  | 1                    |                   |
|                       | 30-2222-3002 | . CLIP, CHANNEL, INBOARD DOOR, MAIN GEAR (USED ON . . . .<br>65-26845-2)  | 1                    |                   |
| 37                    | 5-86308-59   | . GUSSET, INBOARD DOOR, MAIN GEAR (USED ON 5-86308-3) . . . .   | 1                    |                   |
|                       | 5-86308-60   | . GUSSET, INBOARD DOOR, MAIN GEAR (USED ON 5-86308-4) . . . .   | 1                    |                   |
| 37                    | 5-86308-2059 | . GUSSET, INBOARD DOOR, MAIN GEAR (USED ON 65-26845-1) . . . .  | 1                    |                   |
|                       | 5-86308-2060 | . GUSSET, INBOARD DOOR, MAIN GEAR (USED ON 65-26845-2) . . . .  | 1                    |                   |
| 38                    | 5-86308-61   | . GUSSET, INBOARD DOOR, MAIN GEAR (USED ON 5-86308-3) . . . .   | 2                    |                   |
|                       | 5-86308-62   | . GUSSET, INBOARD DOOR, MAIN GEAR (USED ON 5-86308-4) . . . .   | 2                    |                   |
| 38                    | 5-86308-2061 | . GUSSET, INBOARD DOOR, MAIN GEAR (USED ON 65-26845-1) . . . .  | 2                    |                   |
|                       | 5-86308-2062 | . GUSSET, INBOARD DOOR, MAIN GEAR (USED ON 65-26845-2) . . . .  | 2                    |                   |
| 39                    | NAS517-3-17  | . SCREW (FOR REPLACEMENT ORDER BACB30LU3-17) (USED ON . . . .<br>65-26845-1, -2)  | 2                    |                   |
| 40                    | 63-1985-2001 | . ANGLE, STOP, MAIN GEAR DOOR (USED ON 65-26845-1) . . . . .  | 1                    |                   |
|                       | 63-1985-2002 | . ANGLE, STOP, MAIN GEAR DOOR (USED ON 65-26845-2) . . . . .  | 1                    |                   |
| 41                    | BACS40C9-27  | . SHIM, LAV, 0.093 THK. . . . .   | 2                    |                   |
| 42                    | 66-3668-3001 | . BLOCK, DOOR STOP, MAIN GEAR DOOR (USED ON 65-26845-1) . . . .   | 1                    |                   |
|                       | 66-3668-3002 | . BLOCK, DOOR STOP, MAIN GEAR DOOR (USED ON 65-26845-2) . . . .<br>(ATTACHING PARTS)  | 1                    |                   |
|                       | NAS517-3-5   | . SCREW (FOR REPLACEMENT ORDER BACB30LU3-5) . . . . .   | 2                    |                   |

| FIGURE &<br>INDEX NO. | PART NUMBER  | DESCRIPTION   | UNITS<br>PER<br>ASSY | USE<br>ON<br>CODE |
|-----------------------|--------------|---|----------------------|-------------------|
|                       |              | 1 2 3 4 5 6 7   |                      |                   |
| 673-                  | 65-26845-3   | . FILLER, INBOARD DOOR, MAIN GEAR . . . . .   | 1                    |                   |
|                       | 5-96183-2275 | . FILLER, INBOARD DOOR, MAIN GEAR . . . . .   | 1                    |                   |
|                       | 9-67006-3    | . FITTING ASSY, EMERGENCY LINK, MAIN LANDING GEAR DOOR. .<br>(LH ONLY) (REPLACE WITH 9-67006-11)                  | 1                    |                   |
|                       | 9-67006-4    | . FITTING ASSY, EMERGENCY LINK, MAIN LANDING GEAR DOOR. .<br>(RH ONLY) (REPLACE WITH 9-67006-12)                  | 1                    |                   |
| 43                    | NAS77A6-25P  | . . BUSHING . . . . .   | 1                    |                   |
| 44                    | 9-67006-7    | . . FITTING, EMERGENCY LINK, MAIN LANDING GEAR DOOR . . .<br>(USED ON 9-67006-3)                                  | 1                    |                   |
| 45                    | 9-67006-8    | . . FITTING, EMERGENCY LINK, MAIN LANDING GEAR DOOR . . .<br>(USED ON 9-67006-4)                                  | 1                    |                   |
|                       | 9-67006-3    | . FITTING ASSY, EMERGENCY LINK, MAIN LANDING GEAR DOOR. .<br>(USED ON 5-86308-3)                                  | 1                    |                   |
|                       | 9-67006-12   | . FITTING ASSY, EMERGENCY LINK, MAIN LANDING GEAR DOOR. .<br>(SUITABLE SUB. FOR 9-67006-2) (USED ON<br>5-86308-4) | 1                    |                   |
|                       | 9-67006-3002 | . FITTING ASSY, EMERGENCY LINK, MAIN LANDING GEAR DOOR. .<br>(REWORKED BY 65-26845) (USED ON 5-86308-66)          | 1                    |                   |
|                       | 9-67006-4    | . FITTING ASSY, EMERGENCY LINK, MAIN LANDING GEAR DOOR. .<br>(USED ON 5-86308-3)                                  | 1                    |                   |
|                       | 9-67006-11   | . FITTING ASSY, EMERGENCY LINK, MAIN LANDING GEAR DOOR. .<br>(SUITABLE SUB. FOR 9-67006-1) (USED ON<br>5-86308-4) | 1                    |                   |
|                       | 9-67006-3001 | . FITTING ASSY, EMERGENCY LINK, MAIN LANDING GEAR DOOR. .<br>(REWORKED BY 65-26845) (USED ON 5-86308-66)          | 1                    |                   |
| 46                    | NAS77A6-25P  | . . BUSHING . . . . .   | 1                    |                   |
| 47                    | 9-67006-7    | . . FITTING, EMERGENCY LINK, MAIN LANDING GEAR DOOR . . .<br>(USED ON 9-67006-3)                                  | 1                    |                   |
|                       | 9-67006-10   | . . FITTING, EMERGENCY LINK, MAIN LANDING GEAR DOOR . . .<br>(USED ON 9-67006-12)                                 | 1                    |                   |
| 48                    | 9-67006-2006 | . . FITTING, EMERGENCY LINK, MAIN LANDING GEAR DOOR . . .<br>(USED ON 9-67006-3002)                               | 1                    |                   |
| 49                    | 9-67006-8    | . . FITTING, EMERGENCY LINK, MAIN LANDING GEAR DOOR . . .<br>(USED ON 9-67006-4)                                  | 1                    |                   |
|                       | 9-67006-9    | . . FITTING, EMERGENCY LINK, MAIN LANDING GEAR DOOR . . .<br>(USED ON 9-67006-11)                                 | 1                    |                   |
| 50                    | 9-67006-2005 | . . FITTING, EMERGENCY LINK, MAIN LANDING GEAR DOOR . . .<br>(USED ON 9 67006-3001)                               | 1                    |                   |
|                       |              | A 2201 THRU 2299  |                      |                   |
|                       |              | B 3001 THRU 3099  |                      |                   |



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 1. 15126A \* WORK CONTROL DOCUMENT \* 1. DATE 89073 PAGE 1 OF 3 PAGE 31

\*-----\*\*\*\*\*  
 2. ORIG/PROD NR 13. QUANTITY 14. PROD SECTION/RCC 15. DATE SCHED 16. DATE COMP  
 1 MABPAB 1 89073 1

17. PART NUMBER 19. ITEM SERIAL NR 18/12. TECH DATA/OPTIONAL  
 1 1. WORK STATEMENT

10. MODEL/DESIGN/SERIES 11. STOCK NR 100-1560FL/78-1-25

10. RC 135 1 2. 07 JUNE 78, 78 1-25

1 10-135(K)A-3 3, & 4

1 3. REV NO. 3 20 MAY 80

13. NISC 14. NOUN/END ITEM NOUN

1 DOOR MLG INBD LH OR RH

1 PHYLIS HLAD/MABEBS/65265

1 P/N 1 NSN 1 C/N

1 5-86308-3 1560003409-15FL 15126A

1 5-86308-4 15600034092161L 15300A

115. DISP 16. PON/-

1 STATION/OP NO. 17. WORK TO BE ACCOMPLISHED 118. MCH 119" P" 120" Q"

1 2122 010 RECLIVE HAD UNDERATL / /

1 MBPCD MOVE TO MBPCA

1 2122 020 WASH AND STRIP / /

1 MBPCA MOVE TO BLDG 95

1 95 030 SHAKEDOWN INSPECTION / /

1 MBPAB

1 95 040 DISASSEMBLE AS REQUIRED TO / /

1 MBPAB ACCOMPLISH REPAIR.

1 95 050 REPAIR OR REPLACE SEALS & RETAINERS E /

1 MBPAB REQ'D----- NOT REQ'D-----

1 95 060 REMOVE AFT FAIRING / /

1 MBPAB REQ'D----- NOT REQ'D-----

1 95 070 REMOVE AND TREAT INTERNAL AND / /

1 MBPAB EXTERNAL KORROSION.

1 REQ'D----- NOT REQ'D-----

1 95 080 INSTALL MLG DOOR IN JIG P/N / /

1 MBPAB 590CJ1100 - CHECK ALIGNMENT

1 95 090 REPLACE WORN HINGE ASSY / /

1 MBPAB REQ'D----- NOT REQ'D-----

1 95 100 REPLACE BUSHINGS / /

1 MBPAB REQ'D----- NOT REQ'D-----

1 95 110 REPLACE FITTINGS, EMERGENCY LINK. / /

1 MBPAB REQ'D----- NOT REQ'D-----

1 95 120 REPAIR OR REPLAC LOOSE, MISSING, E /

1 MBPAB OR DEFECTIVE FASTENERS, NUTS & BOLTS

1 REQ'D----- NOT REQ'D-----

1 95 130 REPAIR OR REPLACE RIBS OR LONGERONS E /

1 MBPAB REQ'D----- NOT REQ'D-----

1 95 130 REPAIR OR REPLACE RIBS OR LONGERONS E /

1 MBPAB REQ'D----- NOT REQ'D-----

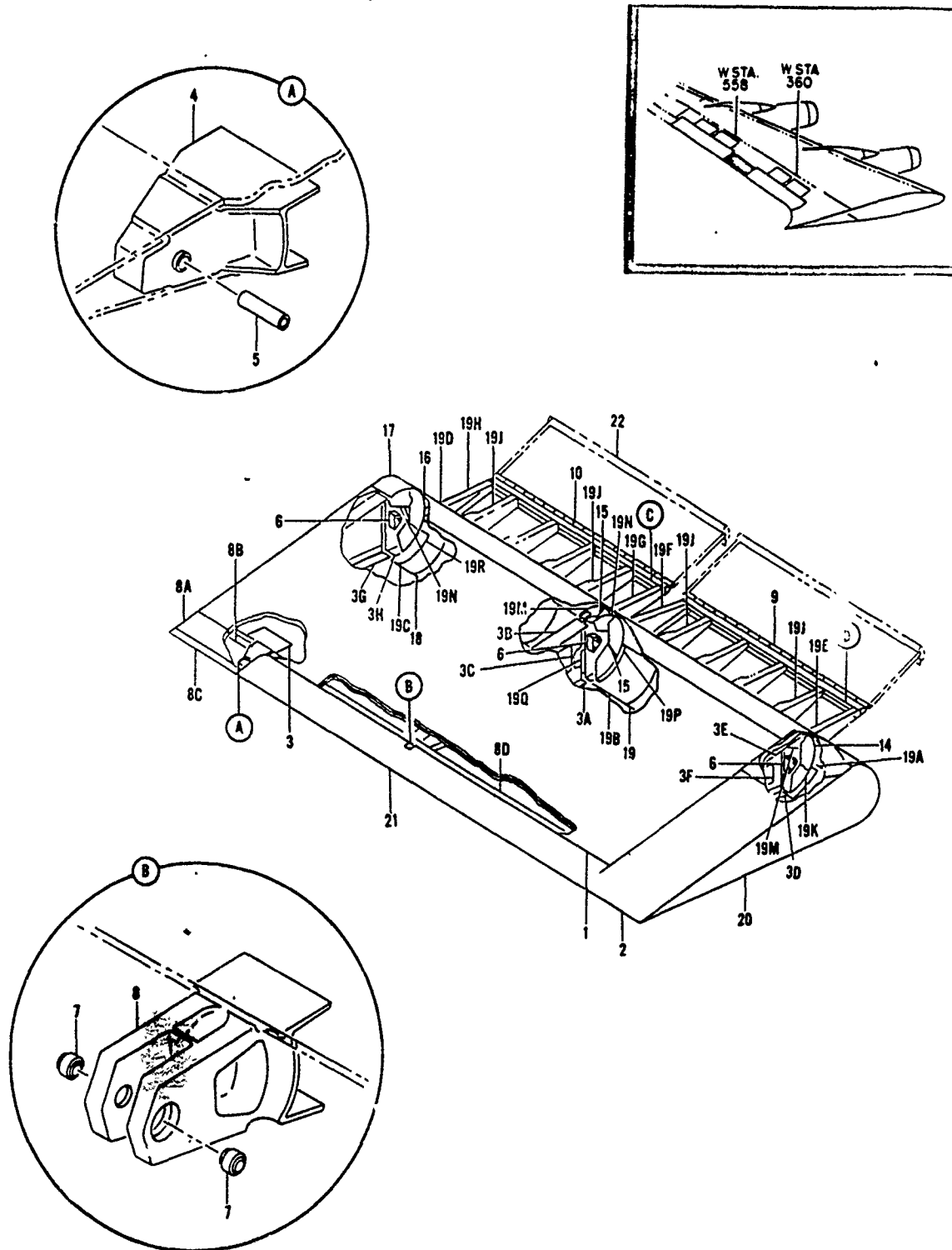
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| *****                                       |              |  |  |   |     |
|---|--------------|--|--|---|-----|
| 15126A * WORK CONTROL DOCUMENT *            |              | 1. DATE 89073 PAGE 3 OF 3 PAGES  |  |   |     |
| 15. DISP-16. PDN/                           |              |  |  |   |     |
| STATION/OP NO. 117. WORK TO BE ACCOMPLISHED |              | 110. MECH 117"P" 120"Q"  |  |   |     |
| 95  | 270<br>MBPAB | WORK COMPLETED, CONDITION TAGGED<br>IAW AFM-67-1.<br>DATE _____ MOVE TO CRATING.<br>NOTE: PART WILL HAVE OC-ALC FORM 586<br>587 OR 588 IDENTIFICATION LABELS<br>APPLIED TO COMPLETED ITEM IAW AFLCR<br>66-51 CHG. 1. PARA 2.<br>ACCEPTANCE DATE ON THE LABEL<br>LONG WITH "M" STAMP OF THE PERSON<br>PERFORMING THE OVERHAUL.<br>CAUTION: SURFACES TO WHICH LABELS<br>ARE APPLIED MUST BE FREE OF CONTAM<br>INATION.<br>NOTE: COMPLETE "REMARK" COLUMN OF<br>AFLO FORM 1574 IAW MAOI 66-36. THIS<br>PARAGRAPH IS NOT APPLICABLE TO NON-<br>PROGRAMMED AIRCRAFT WORKLOAD. |  | / | E / |
|   |              | COORDINATION: DATE:  |  |   |     |
|   |              | MABJCS CONNIE WEBBER 22 MARCH 89   |  |   |     |
|   |              | MABDF TLO HAYES 22 MARCH 89  |  |   |     |
|   |              | MABPAB JESSIE JACOBS 22 MARCH 89   |  |   |     |
|   |              | MABEBS PHYLLIS HEALD 22 MARCH 89   |  |   |     |

| FIGURE &<br>INDEX NO. | PART NUMBER  | DESCRIPTION  |   |   |   |   |   |   | UNITS<br>PER<br>ASSY | USE<br>ON<br>CODE |
|-----------------------|--------------|--|---|---|---|---|---|---|----------------------|-------------------|
|                       |              | 1  | 2 | 3 | 4 | 5 | 6 | 7 |                      |                   |
| 36 -                  | 5-86072-167  | AILERON AND TAB ASSY, INBOARD (LH) (FOR NHA SEE . . . .          |   |   |   |   |   |   | REF                  |                   |
|                       | 5-86072-168  | FIG. 35) AILERON AND TAB ASSY, INBOARD (RH) (FOR NHA SEE . . . . |   |   |   |   |   |   | REF                  |                   |
| 1                     | 5-86072-169  | FIG. 35) . AILERON ASSY, INBOARD (LH ONLY) . . . . .             |   |   |   |   |   |   | 1                    |                   |
|                       | 5-86072-170  | . AILERON ASSY, INBOARD (RH ONLY) . . . . .                      |   |   |   |   |   |   | 1                    |                   |
| 2                     | 4-5205-1     | . . PANEL ASSY, UPPER, SKIN, INBOARD AILERON (ALTERED .          |   |   |   |   |   |   | 1                    |                   |
|                       | 4-5205-2     | FROM 4-5205) (LH ONLY) . . . . .                                 |   |   |   |   |   |   | 1                    |                   |
| 3                     | 4-5205-3     | . . PANEL ASSY, UPPER, SKIN, INBOARD AILERON (ALTERED .          |   |   |   |   |   |   | 1                    |                   |
|                       | 4-5205-4     | FROM 4-5205) (RH ONLY) . . . . .                                 |   |   |   |   |   |   | 1                    |                   |
| 3A                    | NAS517-3-3   | . . PANEL ASSY, LOWER, SKIN, INBOARD AILERON (ALTERED .          |   |   |   |   |   |   | 1                    |                   |
|                       | NAS517-3-4   | FROM 4-5205) (REWORKED BY 65-13097-1) (LH ONLY)                  |   |   |   |   |   |   | 1                    |                   |
| 3B                    | NAS517-3-5   | . . PANEL ASSY, LOWER, SKIN, INBOARD AILERON (ALTERED .          |   |   |   |   |   |   | 1                    |                   |
|                       | NAS517-3-6   | FROM 4-5205) (REWORKED BY 65-13097-2) (RH ONLY)                  |   |   |   |   |   |   | 1                    |                   |
| 3C                    | NAS517-3-7   | (ATTACHING PARTS)  |   |   |   |   |   |   | 15                   |                   |
|                       | NAS517-3-8   | . . SCREW . . . . .  |   |   |   |   |   |   | 70                   |                   |
| 3D                    | NAS221-14    | . . SCREW . . . . .  |   |   |   |   |   |   | 26                   |                   |
|                       |              | . . SCREW . . . . .  |   |   |   |   |   |   | 4                    |                   |
| 3E                    |              | . . SCREW . . . . .  |   |   |   |   |   |   | 2                    |                   |
|                       |              | . . SCREW . . . . .  |   |   |   |   |   |   | 2                    |                   |
| 3F                    |              | . . SCREW . . . . .  |   |   |   |   |   |   | 4                    |                   |
|                       |              | . . SCREW . . . . .  |   |   |   |   |   |   | 4                    |                   |
| 3G                    | 5-86072-145  | . . PANEL ASSY, ACCESS, INBOARD AILERON (LH ONLY) . . . .        |   |   |   |   |   |   | 1                    |                   |
|                       | 5-86072-146  | . . PANEL ASSY, ACCESS, INBOARD AILERON (RH ONLY) . . . .        |   |   |   |   |   |   | 1                    |                   |
| 3H                    | NAS517-3-3   | (ATTACHING PARTS)  |   |   |   |   |   |   | 7                    |                   |
|                       | NAS517-3-6   | . . SCREW . . . . .  |   |   |   |   |   |   | 1                    |                   |
| 3I                    |              | . . SCREW . . . . .  |   |   |   |   |   |   | 1                    |                   |
|                       |              | . . SCREW . . . . .  |   |   |   |   |   |   | 1                    |                   |
| 3J                    | 5-86072-71   | . . CHORD, RIB, LOWER, INBOARD AILERON . . . . .                 |   |   |   |   |   |   | 1                    |                   |
|                       | 5-86072-73   | . . CHORD, RIB, UPPER, INBOARD AILERON . . . . .                 |   |   |   |   |   |   | 1                    |                   |
| 3K                    | 5-86072-107  | . . WEB ASSY, BONDED, INBOARD AILERON (LH ONLY) . . . . .        |   |   |   |   |   |   | 1                    |                   |
|                       | 5-86072-108  | . . WEB ASSY, BONDED, INBOARD AILERON (RH ONLY) . . . . .        |   |   |   |   |   |   | 1                    |                   |
| 3L                    | 5-86072-93   | . . CHORD, RIB, LOWER, INBOARD AILERON (LH ONLY) . . . . .       |   |   |   |   |   |   | 1                    |                   |
|                       | 5-86072-94   | . . CHORD, RIB, LOWER, INBOARD AILERON (RH ONLY) . . . . .       |   |   |   |   |   |   | 1                    |                   |
| 3M                    | 5-86072-91   | . . CHORD, RIB, UPPER, INBOARD AILERON (LH ONLY) . . . . .       |   |   |   |   |   |   | 1                    |                   |
|                       | 5-86072-92   | . . CHORD, RIB, UPPER, INBOARD AILERON (RH ONLY) . . . . .       |   |   |   |   |   |   | 1                    |                   |
| 3N                    | 5-86072-109  | . . WEB ASSY, BONDED, INBOARD AILERON (LH ONLY) . . . . .        |   |   |   |   |   |   | 1                    |                   |
|                       | 5-86072-110  | . . WEB ASSY, BONDED, INBOARD AILERON (RH ONLY) . . . . .        |   |   |   |   |   |   | 1                    |                   |
| 3O                    | 69-5854-1    | . . RIB ASSY, NO. 7, INBOARD AILERON (LH ONLY) . . . . .         |   |   |   |   |   |   | 1                    |                   |
|                       | 69-5854-2    | . . RIB ASSY, NO. 7, INBOARD AILERON (RH ONLY) . . . . .         |   |   |   |   |   |   | 1                    |                   |
| 3P                    | 6-73856-1    | . . RIB, NOSE, INBOARD AILERON (LH ONLY) . . . . .               |   |   |   |   |   |   | 1                    |                   |
|                       | 6-73856-2    | . . RIB, NOSE, INBOARD AILERON (RH ONLY) . . . . .               |   |   |   |   |   |   | 1                    |                   |
| 3Q                    | 65-7273-1    | . . FITTING ASSY, SUPPORT, OUTBOARD TAB HINGE, INBOARD           |   |   |   |   |   |   | 1                    |                   |
|                       | 65-7273-2    | AILERON (LH ONLY) . . . . .                                      |   |   |   |   |   |   | 1                    |                   |
| 3R                    | 65-7273-3    | . . FITTING ASSY, SUPPORT, OUTBOARD TAB HINGE, INBOARD           |   |   |   |   |   |   | 1                    |                   |
|                       | 65-7273-4    | AILERON (RH ONLY) . . . . .                                      |   |   |   |   |   |   | 1                    |                   |
| 3S                    | 90-9473-28   | . . . BUSHING, PRESSED FIT, STRUCTURAL . . . . .                 |   |   |   |   |   |   | 1                    |                   |
|                       | 6-58450-2    | . . SUPPORT ASSY, BEARING, INBOARD AILERON (FOR . . . .          |   |   |   |   |   |   | 3                    |                   |
| 3T                    |              | BREAKDOWN SEE FIG. 37)   |   |   |   |   |   |   |                      |                   |
|                       |              | (ATTACHING PARTS)  |   |   |   |   |   |   |                      |                   |
| 3U                    | NAS1104-170W | . . BOLT (FOR REPLACEMENT ORDER NAS1104-170) . . . . .           |   |   |   |   |   |   | 2                    |                   |
|                       | NAS1104-390W | . . BOLT (FOR REPLACEMENT ORDER NAS1104-390) . . . . .           |   |   |   |   |   |   | 2                    |                   |
| 3V                    | NAS1104-430W | . . BOLT (FOR REPLACEMENT ORDER NAS1104-430) . . . . .           |   |   |   |   |   |   | 2                    |                   |
|                       | AN980-416L   | . . WASHER . . . . .   |   |   |   |   |   |   | 12                   |                   |
| 3W                    | AN320-4      | . . NUT (FOR REPLACEMENT ORDER BACN10JD104) . . . . .            |   |   |   |   |   |   | 6                    |                   |
|                       | 6-72071-6    | . . FITTING ASSY, SUPPORT, CENTER HINGE TAB, INBOARD             |   |   |   |   |   |   | 1                    |                   |
| 3X                    |              | AILERON . . . . .  |   |   |   |   |   |   | 1                    |                   |
|                       |              | . . BUSHING . . . . .  |   |   |   |   |   |   | 1                    |                   |
| 3Y                    | NAS537D4P136 | . . FITTING, SUPPORT, CENTER HINGE TAB, INBOARD . . . .          |   |   |   |   |   |   | 1                    |                   |
|                       | 6-72071-7    | AILERON . . . . .  |   |   |   |   |   |   | 1                    |                   |
| 3Z                    | 5-86072-147  | . . SKIN ASSY, UPPER, PANEL, INBOARD AILERON (LH ONLY)           |   |   |   |   |   |   | 1                    |                   |
|                       | 5-86072-148  | . . SKIN ASSY, UPPER, PANEL, INBOARD AILERON (RH ONLY)           |   |   |   |   |   |   | 1                    |                   |
| 3AA                   | 5-86072-149  | . . SKIN ASSY, LOWER, PANEL, INBOARD AILERON (LH ONLY)           |   |   |   |   |   |   | 1                    |                   |
|                       | 5-86072-150  | . . SKIN ASSY, LOWER, PANEL, INBOARD AILERON (RH ONLY)           |   |   |   |   |   |   | 1                    |                   |
| 3AB                   | 5-86072-127  | . . FILLER, TRAILING EDGE, INBOARD AILERON . . . . .             |   |   |   |   |   |   | 1                    |                   |
|                       | 69-4383-7    | . . BEAM INSTL, TRAILING EDGE, INBOARD AILERON . . . . .         |   |   |   |   |   |   | 1                    |                   |
| 3AC                   | 69-4383-8    | (LH ONLY) . . . . .  |   |   |   |   |   |   | 1                    |                   |
|                       |              | . . BEAM INSTL, TRAILING EDGE, INBOARD AILERON . . . .           |   |   |   |   |   |   | 1                    |                   |
| 3AD                   |              | (RH ONLY)  |   |   |   |   |   |   |                      |                   |
|                       |              |  |   |   |   |   |   |   |                      |                   |

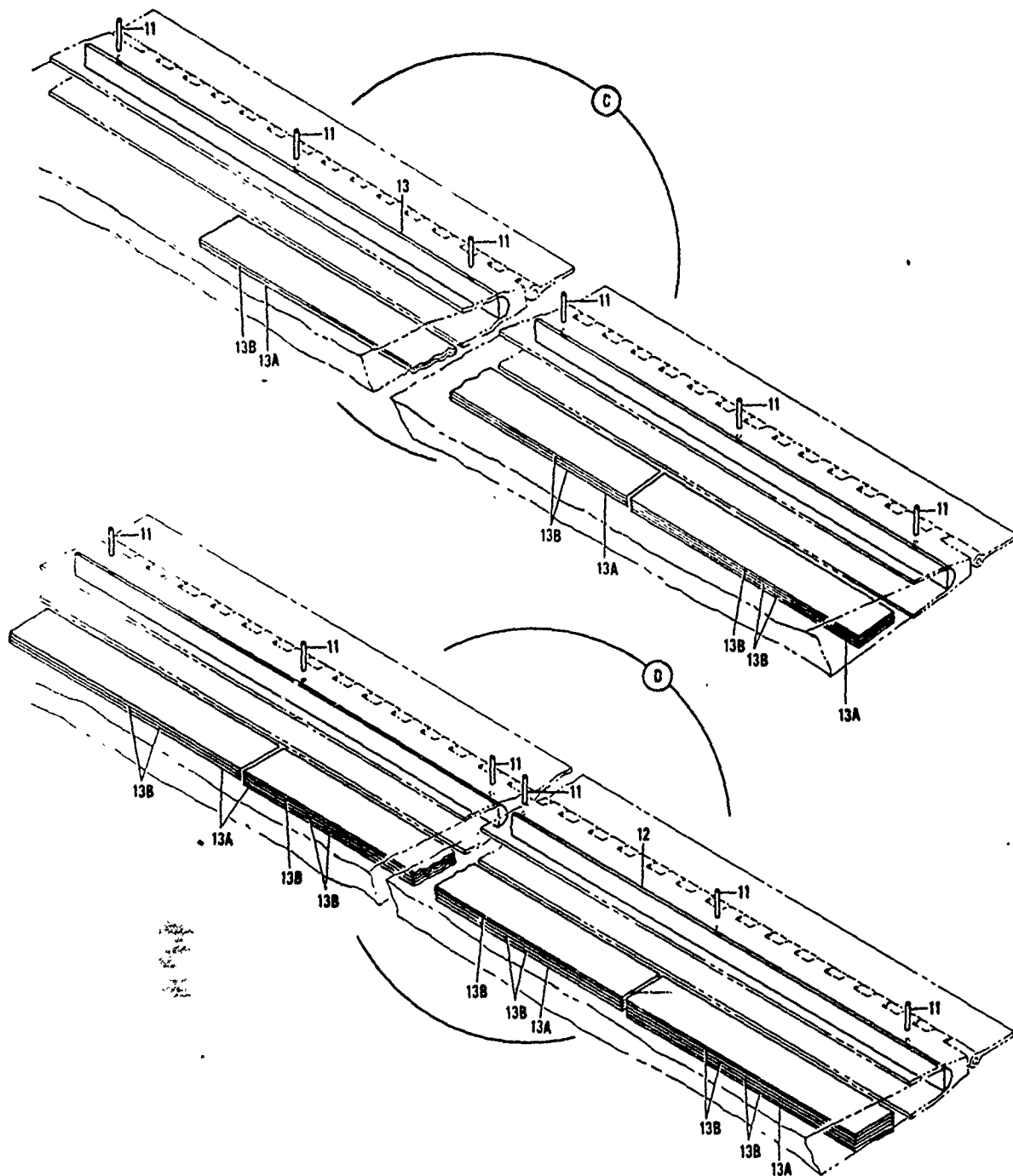
# Wing Control Surfaces



3153-36a

Figure 36. Inboard Aileron and Tab Assemblies (Sheet 1 of 2)

## Wing Control Surfaces



3153-36b

Figure 36. Inboard Aileron and Tab Assemblies (Sheet 2 of 2)

Section II  
Group Assembly Parts List

TO IC-135A-4

| FIGURE &<br>INDEX NO. | PART NUMBER  | DESCRIPTION  | UNITS<br>PER<br>ASSY | USE<br>ON<br>CODE |
|-----------------------|--------------|--|----------------------|-------------------|
| 36 -                  |              | 1 2 3 4 5 6 7  |                      |                   |
| 8D                    | 69-4383-5    | ... BEAM, TRAILING EDGE, INBOARD AILERON (LH ONLY)   | 1                    |                   |
|                       | 69-4383-6    | ... BEAM, TRAILING EDGE, INBOARD AILERON (RH ONLY)   | 1                    |                   |
|                       | NAS517-3-4   | ... SCREW  | 50                   |                   |
|                       | 5-86074-25   | ... STRUCTURE INSTL, NOSE, INBOARD AILERON (LH ONLY)   | 1                    |                   |
|                       | 5-86074-26   | ... STRUCTURE INSTL, NOSE, INBOARD AILERON (RH ONLY)   | 1                    |                   |
| 9                     | 9-61122-37   | ... HINGE-HALF, BALANCE PANEL, INBOARD AILERON<br>(LH ONLY) (SUITABLE SUB 9-61122-33 OR<br>9-61122-19) | 1                    |                   |
|                       | 9-61122-38   | ... HINGE-HALF, BALANCE PANEL, INBOARD AILERON<br>(RH ONLY) (SUITABLE SUB 9-61122-34)                  | 1                    |                   |
| 10                    | 9-61122-39   | ... HINGE-HALF, BALANCE PANEL, INBOARD AILERON<br>(LH ONLY) (SUITABLE SUB 9-61122-10)                  | 1                    |                   |
|                       | 9-61122-40   | ... HINGE-HALF, BALANCE PANEL, INBOARD AILERON<br>(RH ONLY) (SUITABLE SUB 9-61122-28)                  | 1                    |                   |
| 11                    | NAS561P3-11  | ... PIN  | 12                   |                   |
| 12                    | 60-2641-3001 | ... WEIGHT, BALANCE, NOSE, INBOARD AILERON (MAKE FROM<br>ANTIMONY LEAD L 16 0.375 X 60 X 32.28)        | 1                    |                   |
| 13                    | 60-2641-3002 | ... WEIGHT, BALANCE, NOSE, INBOARD AILERON   | 1                    |                   |
| 13A                   | 65-1091-1    | ... WEIGHT, BALANCE, INBOARD AILERON (LH ONLY)   | 1                    |                   |
|                       | 65-1091-2    | ... WEIGHT, BALANCE, INBOARD AILERON (RH ONLY)   | 1                    |                   |
| 13B                   | 65-1091-16   | ... WEIGHT, BALANCE, INBOARD AILERON (USED WITH<br>65-1091-1 AND -2)                                   | AR                   |                   |
| 14                    | 90-5529      | ... SEAL ASSY, HINGE CAVITY, INBOARD AILERON (FOR<br>BREAKDOWN SEE FIG. 37)                            | 1                    |                   |
| 15                    | 90-5529-3    | ... SEAL ASSY, HINGE CAVITY, INBOARD AILERON (FOR<br>BREAKDOWN SEE FIG. 37)<br>(ATTACHING PARTS)       | 2                    |                   |
|                       | AN3-5A       | ... BOLT   | 6                    |                   |
|                       | AN960D10     | ... WASHER   | 6                    |                   |
|                       | NAS679A3W    | ... NUT  | 6                    |                   |
| 16                    | 90-5529-1    | ... SEAL ASSY, HINGE CAVITY, INBOARD AILERON (LH<br>ONLY) (FOR BREAKDOWN SEE FIG. 37)                  | 1                    |                   |
|                       | 90-5529-2    | ... SEAL ASSY, HINGE CAVITY, INBOARD AILERON (RH<br>ONLY) (FOR BREAKDOWN SEE FIG. 37)                  | 1                    |                   |
|                       | AN3-6A       | ... BOLT   | 2                    |                   |
|                       | AN960D10     | ... WASHER   | 2                    |                   |
|                       | NAS679A3W    | ... NUT  | 2                    |                   |
| 17                    | 66-9351-1625 | ... DOOR ASSY, ACCESS, SNUBBER, INBOARD AILERON<br>(LH ONLY)   | 1                    |                   |
|                       | 66-9351-1626 | ... DOOR ASSY, ACCESS, SNUBBER, INBOARD AILERON<br>(RH ONLY)   | 1                    |                   |
| 18                    | 9-61173-23   | ... PANEL, NOSE SKIN, LOWER, INBOARD AILERON<br>(LH ONLY)  | 1                    |                   |
|                       | 9-61173-24   | ... PANEL, NOSE SKIN, LOWER, INBOARD AILERON<br>(RH ONLY)  | 1                    |                   |
| 19                    | 9-61173-21   | ... PANEL, NOSE SKIN, LOWER, INBOARD AILERON<br>(LH ONLY)  | 1                    |                   |
|                       | 9-61173-22   | ... PANEL, NOSE SKIN, LOWER, INBOARD AILERON<br>(RH ONLY)  | 1                    |                   |
| 19A                   | 9-61173-27   | ... PANEL, NOSE SKIN, LOWER, INBOARD AILERON<br>(LH ONLY)  | 1                    |                   |
|                       | 9-61173-28   | ... PANEL, NOSE SKIN, LOWER, INBOARD AILERON<br>(RH ONLY)  | 1                    |                   |
| 19B                   | 9-61173-5    | ... PANEL, NOSE SKIN, LOWER, INBOARD AILERON<br>(LH ONLY)  | 1                    |                   |
|                       | 9-61173-6    | ... PANEL, NOSE SKIN, LOWER, INBOARD AILERON<br>(RH ONLY)  | 1                    |                   |
| 19C                   | 9-61173-9    | ... PANEL, NOSE SKIN, LOWER, INBOARD AILERON<br>(LH ONLY)  | 1                    |                   |
|                       | 9-61173-10   | ... PANEL, NOSE SKIN, LOWER, INBOARD AILERON<br>(RH ONLY)  | 1                    |                   |
| 19D                   | 9-61172-7    | ... PANEL, NOSE SKIN, UPPER, INBOARD AILERON<br>(LH ONLY)  | 1                    |                   |
|                       | 9-61172-8    | ... PANEL, NOSE SKIN, UPPER, INBOARD AILERON<br>(RH ONLY)  | 1                    |                   |
| 19E                   | 9-60369-1    | ... RIB, NOSE, INBOARD AILERON, STATION 466.36<br>(LH ONLY)  | 1                    |                   |
|                       | 9-60369-2*   | ... RIB, NOSE, INBOARD AILERON, STATION 466.36<br>(RH ONLY)  | 1                    |                   |

| FIGURE &<br>INDEX NO. | PART NUMBER | DESCRIPTION   | UNITS<br>PER<br>ASSY | USE<br>ON<br>CODE |
|-----------------------|-------------|---|----------------------|-------------------|
|                       |             | 1 2 3 4 5 6 7   |                      |                   |
| 36 -                  |             |   |                      |                   |
| 19F                   | 9-60370-1   | . . . RIB, NOSE, INBOARD AILERON, STATION 501 (LH ONLY)                   | 1                    |                   |
|                       | 9-60370-2   | . . . RIB, NOSE, INBOARD AILERON, STATION 501 (RH ONLY)                   | 1                    |                   |
| 19G                   | 9-60370-3   | . . . RIB, NOSE, INBOARD AILERON, STATION 501 (LH ONLY)                   | 1                    |                   |
|                       | 9-60370-4   | . . . RIB, NOSE, INBOARD AILERON, STATION 501 (RH ONLY)                   | 1                    |                   |
| 19H                   | 9-60371-1   | . . . RIB, NOSE, INBOARD AILERON, STATION 535.14 . . .<br>(LH ONLY)       | 1                    |                   |
|                       | 9-60371-2   | . . . RIB, NOSE, INBOARD AILERON, STATION 535.14 . . .<br>(RH ONLY)       | 1                    |                   |
| 19J                   | 6-68499     | . . . RIB, NOSE, INBOARD AILERON . . . . .                                | 8                    |                   |
| 19K                   | 9-63015-1   | . . . FORMER, NOSE, INBOARD AILERON (LH ONLY) . . . . .                   | 1                    |                   |
|                       | 9-63015-2   | . . . FORMER, NOSE, INBOARD AILERON (RH ONLY) . . . . .                   | 1                    |                   |
| 19L                   | DELETED     |   |                      |                   |
| 19M                   | 9-63015-4   | . . . FORMER, NOSE, INBOARD AILERON . . . . .                             | 2                    |                   |
| 19N                   | 9-63015-3   | . . . FORMER, NOSE, INBOARD AILERON . . . . .                             | 2                    |                   |
| 19P                   | 9-63015-6   | . . . FORMER, NOSE, INBOARD AILERON . . . . .                             | 1                    |                   |
| 19Q                   | 9-63015-5   | . . . FORMER, NOSE, INBOARD AILERON . . . . .                             | 1                    |                   |
| 19R                   | 9-63015-7   | . . . FORMER, NOSE, INBOARD AILERON (LH ONLY) . . . . .                   | 1                    |                   |
|                       | 9-63015-8   | . . . FORMER, NOSE, INBOARD AILERON (RH ONLY) . . . . .                   | 1                    |                   |
| 20                    | 5-86071-115 | . . . END INSTL, INBOARD AILERON (LH ONLY) (FOR BREAKDOWN<br>SEE FIG. 38) | 1                    |                   |
|                       | 5-86071-116 | . . . END INSTL, INBOARD AILERON (RH ONLY) (FOR BREAKDOWN<br>SEE FIG. 38) | 1                    |                   |
| 21                    | 65-6774-7   | . TAB INSTL, INBOARD AILERON (LH ONLY) (FOR BREAKDOWN .<br>SEE FIG. 39)   | 1                    |                   |
|                       | 65-6774-8   | . TAB INSTL, INBOARD AILERON (RH ONLY) (FOR BREAKDOWN .<br>SEE FIG. 39)   | 1                    |                   |
| 22                    |             | PANEL INSTL, BALANCE, INBOARD AILERON (FOR REF . . . . .<br>SEE FIG. 41)  | REF                  |                   |



# FLOW PROCESS CHART

SUBJECT Aileron Assy Inbd

DATE 4/5/89

PCN: 15136A WCD: 15136A WCD DATE: 88205  
15137A

CHART BEGINS Operation 010

CHART ENDS Operation 440

PREPARED BY: Tim Hall

| SYMBOLS     | DESCRIPTION                                     | SYMBOLS     | DESCRIPTION   |
|-------------|---|-------------|---|
| 010 ● ◊ ▢ ▽ | Receive and Uncrate<br>2122 MABPCA              | 160 ● ◊ ▢ ▽ | Replace defective ribs<br>and nose skins            |
| ◊ ◊ ▢ ▽     | Delay   | 170 ● ◊ ▢ ▽ | Replace defective<br>bearings                       |
| ◊ ◊ ▢ ▽     | Move to MABPCA<br>2122 MABPCA                   | 180 ● ◊ ▢ ▽ | Replace in over panel<br>hinges                     |
| ◊ ◊ ▢ ▽     | Delay   | 190 ● ◊ ▢ ▽ | Replace loose or missing<br>fasteners               |
| 020 ● ◊ ▢ ▽ | Wash & strip paint                              | 200 ● ◊ ▢ ▽ | Replace chafing stripes                             |
| 030 ● ◊ ▢ ▽ | Treat for corrosion                             | 210 ● ◊ ▢ ▽ | Repair delamination of<br>upper & lower skin panels |
| ◊ ◊ ▢ ▽     | Delay   | 220 ● ◊ ▢ ▽ | Replace upper skin<br>panels                        |
| ◊ ◊ ▢ ▽     | Move to 95<br>95 MABPCA                         | 230 ● ◊ ▢ ▽ | Replace Lower skin<br>panels                        |
| ◊ ◊ ▢ ▽     | Delay   | 240 ● ◊ ▢ ▽ | Install aileron in<br>jig                           |
| 040 ● ◊ ▢ ▽ | Shakedown                                       | 250 ● ◊ ▢ ▽ | Remove & replace Tab<br>Hinge Fitting               |
| 050 ● ◊ ▢ ▽ | Treat Corrosion                                 | 260 ● ◊ ▢ ▽ | Remove FDB &<br>accomplish close out                |
| ◊ ◊ ▢ ▽     | Delay   | 270 ● ◊ ▢ ▽ | Install skin panels                                 |
| ◊ ◊ ▢ ▽     | Move to 3001<br>3001 MATPKT                     | 280 ● ◊ ▢ ▽ | Perform alignment<br>check                          |
| ◊ ◊ ▢ ▽     | Delay   | 290 ● ◊ ▢ ▽ | Remove From jig                                     |
| 060 ● ◊ ▢ ▽ | Replace bushing in<br>center hinge fitting      | 300 ● ◊ ▢ ▽ | Replace defective<br>seals                          |
| 070 ● ◊ ▢ ▽ | Replace bushing<br>in Tab Hng Fitting           | 310 ● ◊ ▢ ▽ | Replace defective<br>access doors                   |
| 080 ● ◊ ▢ ▽ | Replace Rod end<br>bearings                     | 320 ● ◊ ▢ ▽ | Install access panels                               |
| 090 ● ◊ ▢ ▽ | Install bushing in<br>inboard aileron           | 330 ● ◊ ▢ ▽ | Replace Fairings                                    |
| 100 ● ◊ ▢ ▽ | Install bushing in center<br>ailerons           | 340 ● ◊ ▢ ▽ | Repair dents, gouges, nicks<br>& scratches          |
| 110 ● ◊ ▢ ▽ | Install bushing in<br>bellcrank 985x            | 350 ● ◊ ▢ ▽ | Fill skin   |
| 120 ● ◊ ▢ ▽ | Install bushing in<br>outbd aileron             | ◊ ◊ ▢ ▽     | Delay   |
| 130 ● ◊ ▢ ▽ | Install bushing in inboard<br>ailerons snubber  | ◊ ◊ ▢ ▽     | Move to MABPCB<br>2280 MABPCB                       |
| 135 ● ◊ ▢ ▽ | Transfer holes on 8-<br>bearing support bracket | ◊ ◊ ▢ ▽     | Delay   |
| 140 ● ◊ ▢ ▽ | Transfer holes on 8-<br>support bracket - 2001  | 360 ● ◊ ▢ ▽ | Final Wash  |
| ◊ ◊ ▢ ▽     | Delay   | 370 ● ◊ ▢ ▽ | Mask off<br>ailerons                                |
| ◊ ◊ ▢ ▽     | Move to 95<br>95 MABPCB                         | 380 ● ◊ ▢ ▽ | Prime   |
| ◊ ◊ ▢ ▽     | Delay   | 390 ● ◊ ▢ ▽ | Paint   |
| 150 ● ◊ ▢ ▽ | Check nose end ribs<br>for cracks               | ◊ ◊ ▢ ▽     | Delay   |
|             |   | ◊ ◊ ▢ ▽     | Move to 95<br>95 MABPCB                             |

### FLOW PROCESS CHART

SUBJECT Aileron Assy Inboard DATE 4/5/89

PCN: 15136A 4 15137A WCD: 15136A WCD DATE: 88205

CHART BEGINS Operation 010

CHART ENDS Operation 440

PREPARED BY: Tim Hall

[illegible]

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 15136A \* WORK CONTROL DOCUMENT \* MISTR 1.DATE 88205 PAGE 1 OF 5 PAGES

\*\*\*\*\*  
 12.ORIG/PROD NR 13.QUANTITY 14.PROD SECTION/RCC 15.DATE SCHLD 16.DATE COMP  
 | | MABPAB | 89093 |

17.PART NUMBER 19.ITEM SERIAL NR 18/12.TECH DATA/OPTIONAL  
 | | | 1. SOW C/N UC 156078-1-  
 | | | 24. DID 22 JUN 78  
 10.MODEL/DESIGN/SERIES 11.STOCK NR 12.REV NO.1, DID 19 FEB 79  
 | C-135 | | 3.WRITE ADD'D WORK REQ'D  
 | | | 4.1.0.1C 135(K)A-3 1,3-3,  
 13.MISC.14.NOUN/END ITEM NOUN 15.1 1 4,1-1 0.  
 | AILERON ASSY INBD | |

-----MICHAEL TYTANIC/MABPAB/65261

| P/N             | NSN             | C/N     |
|-----------------|-----------------|---------|
| (M) 5-86072-169 | 1560004413621FL | 15136A✓ |
| 5-86072-165     | 1560006740912FL | 15214A  |
| 5-86072-105     | 1560006046701FL | 15301A  |
| 5-86072-161     | 1560006210777FL | 15303A  |
| 5-86072-153     | 1560006214863FL | 15304A  |
| 5-86072-117M    | 1560006527448FL | 15306A  |
| (M) 5-86072-170 | 1560004457470FL | 15137A✓ |
| 5-86072-166     | 1560006740713FL | 15215A  |
| 5-86072-106     | 1560006046702FL | 15302A  |
| 5-86072-154     | 1560006214834FL | 15305A  |
| 5-86072-118M    | 1560006527449FL | 15307A  |

15.10.16.17.DN/

STATION/OP NO. 17.WORK TO BE ACCOMPLISHED

|      |       |                                       |    |   |   |
|------|-------|---------------------------------------|----|---|---|
| 2122 | 010   | RECEIVE & UNCRATE                     | CO | / | / |
|      | MBPCD | MOVE TO WASH RACK BLDG 2122 MBPCA     |    |   |   |
| 2122 | 020   | WASH & STRIP EXTERIOR PAINT IAW T.O.  | 4W | / | / |
|      | MBPCA | 1C-135(K)A-3-4, SECTION XI.           |    |   |   |
|      |       | NOTE:PLUG ALL DRAIN HOLES TO PREVENT  |    |   |   |
|      |       | STRIPPER FROM ENTERING INTERIOR.      |    |   |   |
| 2122 | 030   | TREAT FOR CORROSION IAW T.O. 1C-135   | 4W | / | / |
|      | MBPCA | (K)A-3-4, SECTION IV                  |    |   |   |
| 95   | 040   | REMOVE LOWER SKIN PANELS AND          | ES | / | / |
|      | MBPAB | ACCOMPLISH SHAKEDOWN INSPECTION IAW   |    |   |   |
|      |       | SOW. ANNOTATE DISCREPANCIES.          |    |   |   |
| 95   | 050   | REMOVE & TREAT CORROSION IAW T.O.     | ES | / | / |
|      | MBPAB | 1C-135(K)A-3-4, SECTION IV.           |    |   |   |
|      |       | REQ'D NOT REQ'D                       |    |   |   |
|      |       | MOVE TO MTPIT                         |    |   |   |
| 0-65 | 060   | REPLACE BUSHING IN CENTER TAB HINGE   | JA | / | / |
|      | MTPIT | FITTING IAW 1C-135(K)A-3-3            |    |   |   |
|      |       | REQ'D NOT REQ'D                       |    |   |   |
| 0-65 | 070   | REPLACE BUSHING IN OUTBOARD TAB HINGE | JA | / | / |
|      | MTPIT | FITTING IAW T.O. 1C-135(K)A-3-3       |    |   |   |
|      |       | REQ'D NOT REQ'D                       |    |   |   |

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| *****  |        |  |          |         |         |  |
|--|--------|--|----------|---------|---------|--|
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| 15. DISP-16. PDN/  |        |  |          |         |         |  |
| STATION  | OP NO. | 17. WORK TO BE ACCOMPLISHED  | 18. MECH | 19. "P" | 20. "Q" |  |
| 0-65   | 080    | REPLACE WORN OR LOOSE ROD END BEAR-  | JA       | /       | /       |  |
|  | MTPIT  | INGS IAW T.O. 1C-135(K)A-3-3, FIG 2-10, DETAIL 1, JOINT 2                    |          |         |         |  |
|  |        | REQ'D_____NOT REQ'D_____   |          |         |         |  |
| 0-65   | 090    | INSTALL BUSHING IN INBOARD AILERON   | JA       | /       | /       |  |
|  | MTPIT  | ATTACH BEARING SUPPORT IAW 1C-135(K)A-3-3, FIG 2-10, DETAIL I, JOINT 3 & 12. |          |         |         |  |
|  |        | REQ'D_____NOT REQ'D_____   |          |         |         |  |
| 0-65   | 100    | INSTALL BUSHING IN CENTER AILERON  | JA       | /       | /       |  |
|  | MTPIT  | ATTACH BEARING SUPPORT IAW 1C-135(K)A-3-3, FIG 2-10, DETAIL III, JOINT 3     |          |         |         |  |
|  |        | REQ'D_____NOT REQ'D_____   |          |         |         |  |
| 0-65   | 105    | INSTALL BUSHINGS IN BELLEFARK ASSY.  | JA       | /       | /       |  |
|  | MTPIT  | IAW 1C-135(K)A-3-3, FIG 2-10, DETAIL I, JOINT 3 & 12. MAX. .2495 - .2505     |          |         |         |  |
|  |        | REQ'D_____NOT REQ'D_____   |          |         |         |  |
| 0-65   | 110    | INSTALL BUSHING IN OUTBOARD AILERON  | JA       | /       | /       |  |
|  | MTPIT  | ATTACH BEARING SUPPORT IAW 1C-135(K)A-3-3, FIG 2-10 DETAIL II, JOINT 3       |          |         |         |  |
|  |        | REQ'D_____NOT REQ'D_____   |          |         |         |  |
| 0-65   | 120    | INSTALL BUSHING IN INBOARD AILERON   | JA       | /       | /       |  |
|  | MTPIT  | SNUBBER IAW 1C-135(K)A-3-3, FIG 2-10B  |          |         |         |  |
|  |        | REQ'D_____NOT REQ'D_____   |          |         |         |  |
| 0-65   | 130    | INSTALL BUSHING IN SUPPORT   | JA       | /       | /       |  |
|  | MTPIT  | CONTROL MECHANISM IAW 1C-135(K)A-3-3   |          |         |         |  |
|  |        | REQ'D_____NOT REQ'D_____   |          |         |         |  |
| 0-65   | 135    | TRANSFER HOLES ON BEARING SUPPORT  | JA       | /       | /       |  |
|  | MTPIT  | BRACKET, P/N 69-1353 0 & 2 IAW WITH T.O. 135(K)A-3-3.                        |          |         |         |  |
|  |        | REQ'D_____NOT REQ'D_____   |          |         |         |  |
| 0-65   | 140    | TRANSFER HOLES ON BEARING SUPPORT  | JA       | /       | /       |  |
|  | MTPIT  | BRACKET, P/N 7-60366-2001 IAW 1C-135(K)A-3-3                                 |          |         |         |  |
|  |        | REQ'D_____NOT REQ'D_____   |          |         |         |  |
| 95   | 150    | CHECK NOSE END RIBS FOR CRACKS.  | ES       | /       | /       |  |
|  | MBPAB  | IF CRACKED, REMOVE NOSE SKIN & INSPECT ALL NOSE RIBS.                        |          |         |         |  |

(CONTINUED)

| *****  |                  |   |           |           |   |  |  |  |  |
|--|------------------|---|-----------|-----------|---|--|--|--|--|
| 15136A * WORK CONTROL DOCUMENT * MISIR 1. DATE 88205 PAGE 3 OF 5 PAGES |                  |   |           |           |   |  |  |  |  |
| 15. DISP-16. PDN/  |                  |   |           |           |   |  |  |  |  |
| STATION/OP NO. 117. WORK TO BE ACCOMPLISHED 118. MECH 119 "P" 120 "Q"  |                  |   |           |           |   |  |  |  |  |
|  |                  |   | REQ'D     | NOT REQ'D |   |  |  |  |  |
| 95   | 160              | REPLACE RIBS AND NOSE SKINS THAT  | ES        | /         | / |  |  |  |  |
|  | MBPAB            | HAVE CRACKS AND/OR OVERSIZED HOLES.   |           |           |   |  |  |  |  |
|  |                  | REQ'D   | NOT REQ'D |           |   |  |  |  |  |
| 95   | 170              | REPLACE DAMAGED, LOOSE OR FROZEN  | ES        | /         | / |  |  |  |  |
|  | MBPAB            | BEARINGS.   |           |           |   |  |  |  |  |
|  |                  | REQ'D   | NOT REQ'D |           |   |  |  |  |  |
| 95   | 180              | REPLACE BALANCE PANEL HINGES.   | ES        | /         | / |  |  |  |  |
|  | <del>MBPAB</del> | REQ'D   | NOT REQ'D |           |   |  |  |  |  |
| 95   | 190              | REPLACE LOOSE AND/OR MISSING FASTENERS IAW WORK STATEMENT.                          | ES        | /         | / |  |  |  |  |
|  | MBPAB            | REQ'D   | NOT REQ'D |           |   |  |  |  |  |
| 95   | 200              | REPLACE CHAFING STRIPS  | ES        | /         | / |  |  |  |  |
|  | MBPAB            | REQ'D   | NOT REQ'D |           |   |  |  |  |  |
| 95   | 210              | REPAIR DELAMINATION OF UPPER & LOWER SKIN PANELS IAW F.O. 1C-135(K)A-3-1, SECTION X | ES        | /         | / |  |  |  |  |
|  | MBPAB            | REQ'D   | NOT REQ'D |           |   |  |  |  |  |
| 95   | 220              | REPLACE UPPER SKIN PANELS   | ES        | /         | / |  |  |  |  |
|  | MBPAB            | REQ'D   | NOT REQ'D |           |   |  |  |  |  |
| 95   | 230              | REPLACE LOWER SKIN PANELS. NOTE: CLEAN & CLOSE OUT INSPECTION REQ'D.                | ES        | /         | / |  |  |  |  |
|  | MBPAB            | REQ'D   | NOT REQ'D |           |   |  |  |  |  |
| 95   | 240              | INSTALL AILERON IN JIG P/N59UCJ 1010  | ES        | /         | / |  |  |  |  |
|  | MBPAB            | REQ'D   | NOT REQ'D |           |   |  |  |  |  |
| 95   | 250              | REMOVE & REPLACE DAMAGED FIBER HINGE FITTING WITH NEW FITTING F.O. 1C-135(K)A-3-1   | ES        | /         | / |  |  |  |  |
|  | MBPAB            | REQ'D   | NOT REQ'D |           |   |  |  |  |  |
| 95   | 260              | REMOVE FOD & ACCOMPLISH CLOSE OUT   | ES        | /         | / |  |  |  |  |
|  | MBPAB            | REQ'D   | NOT REQ'D |           |   |  |  |  |  |
| 95   | 270              | INSTALL SKIN PANELS   | ES        | /         | / |  |  |  |  |
|  | MBPAB            | REQ'D   | NOT REQ'D |           |   |  |  |  |  |
| 95   | 280              | PERFORM ALIGNMENT CHECK.  | ES        | /         | / |  |  |  |  |
|  | MBPAB            | 1C-135(K)A-3-4, XXXXXXXXXXXXXXXXXXXX  |           |           |   |  |  |  |  |





Section II  
Group Assembly Parts List

T.O.1C-135 A-4

Power Plant

15140 A

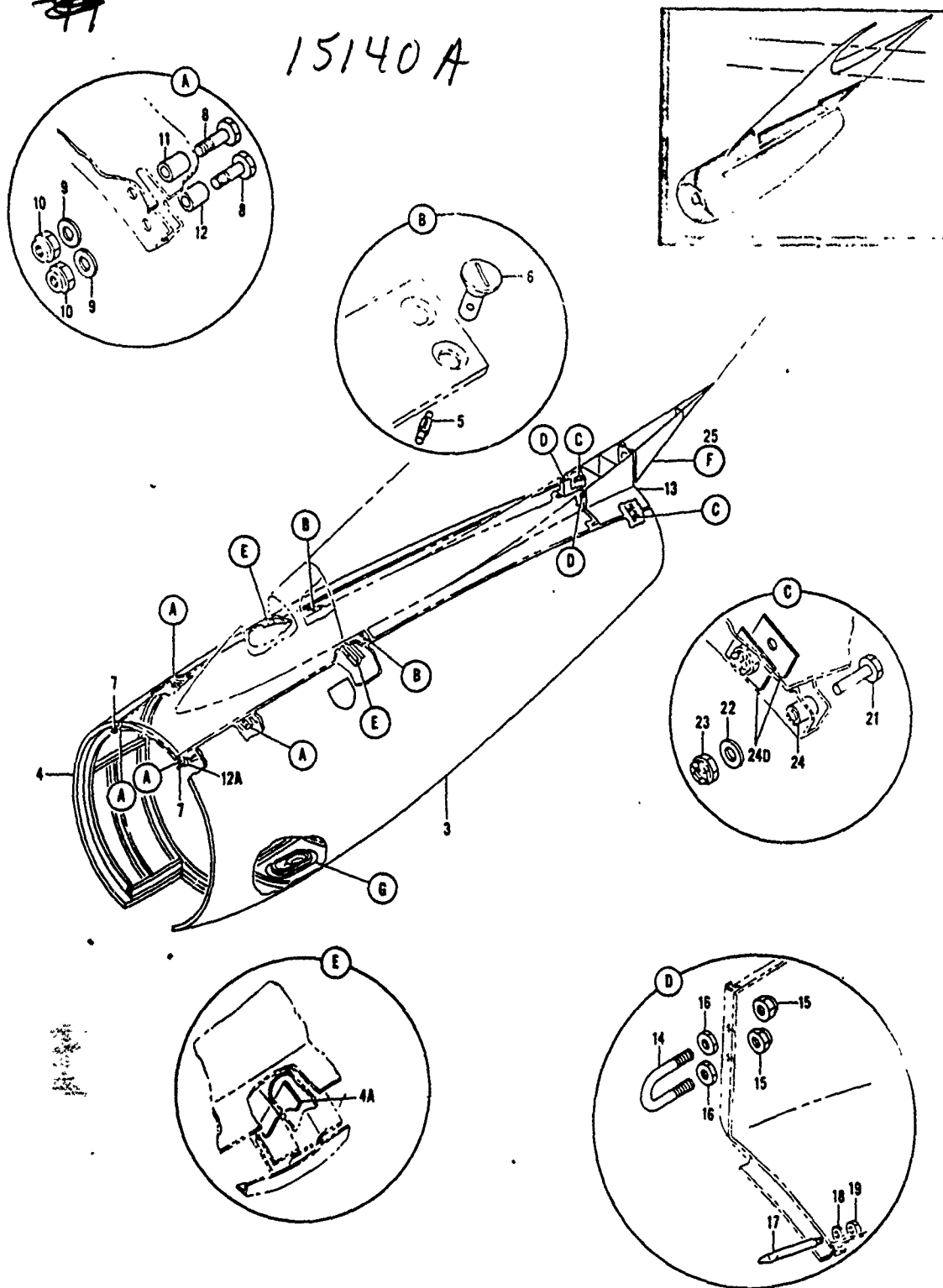


Figure 1100. Engine Nacelle Cowl Installations (Sheet 1 of 2)



| FIGURE &<br>INDEX NO. | PART NUMBER   | DESCRIPTION   | UNITS<br>PER<br>ASSY | USE<br>ON<br>CODE |
|-----------------------|---------------|---|----------------------|-------------------|
|                       |               | 1 2 3 4 5 6 7   |                      |                   |
| 1100-                 | 50-3371       | COWL INSTL, ENGINE NACELLE (ENGINES NO. 1, 2 AND 3) . . .<br>(FOR NHA SEE FIG. 1099)  | REF                  | A                 |
|                       | 50-3371-1     | COWL INSTL, ENGINE NACELLE (ENGINE NO. 4) (FOR NHA SEE . .<br>FIG. 1099)  | REF                  | A                 |
| 1                     | NAS514P1032-6 | . SCREW (FOR REPLACEMENT ORDER NAS514P1032-6P) . . . . .  | 10                   | A                 |
| 2                     | NAS679A3W     | . NUT (ALTERNATE BACN10JC3) . . . . .   | 10                   | A                 |
| 2A                    | 90-3342       | . DUCT, AIR EXHAUST, ALTERNATOR COOLING (USED ON 50-3371)   | 1                    | A                 |
| 2A                    | 90-3343-2     | . DUCT, EXHAUST, FUEL AIR STARTER (USED ON 50-3371-1) . .   | 1                    | B                 |
| 2A                    | 90-3343-1     | . DUCT, EXHAUST, FUEL AIR STARTER (USED ON 50-3371-1) . .   | 1                    | C                 |
| 2B                    | 1200874-10    | . SEAL ASSY, BELLOW, EXHAUST EXIT, FUEL AIR STARTER. . .<br>(98769) (BOEING SPEC 10-2748-1) (ALTERNATE<br>65-32834-1) (USED ON 50-3371-1)   | 1                    | B                 |
| 2B                    | 1200874       | . SEAL ASSY, BELLOW, EXHAUST EXIT, FUEL AIR STARTER. . .<br>(98769) (ALTERNATE 8449402 (71688)) (BOEING SPEC<br>10-2748) (FOR REPLACEMENT ORDER 1200874-10<br>(98769) (BOEING SPEC 10-2748-1)) (USED ON<br>50-3371-1)   | 1                    | C                 |
| 2B                    | 1200874       | . SEAL ASSY, BELLOW, EXHAUST EXIT, FUEL AIR STARTER. . .<br>(98769) (ALTERNATE 8449402 (71688)) (BOEING SPEC<br>10-2748) (FOR REPLACEMENT ORDER 1200874-10<br>(98769) (BOEING SPEC 10-2748-1)) (USED ON<br>50-3371) FOR REPAIR OF 1200874 AND<br>1200874-10 ORDER 69B25097-1) | 1                    | A                 |
| 2C                    | 69-22576-1    | . SEAL, GASKET, STARTER EXHAUST EXIT (USED ON 50-3371-1).   | AR                   | B                 |
| 3                     | 5-85637       | . PANEL ASSY, SIDE COWL, LEFT HAND, ENGINE NACELLE (FOR .<br>BREAKDOWN SEE FIG. 1101)   | 1                    | A                 |
| 3                     | 35-32371-1    | . PANEL ASSY, LEFT HAND SIDE COWL, ENGINE NACELLE (FOR. .<br>BREAKDOWN SEE FIG. 1101)   | 1                    | A                 |
| 4                     | 5-85638       | . PANEL ASSY, SIDE COWL, RIGHT HAND, ENGINE NACELLE . . .<br>(FOR BREAKDOWN SEE FIG. 1102)  | 1                    | A                 |
| 4                     | 35-32370-1    | . PANEL ASSY, SIDE COWL, RIGHT HAND, ENGINE NACELLE (FOR.<br>BREAKDOWN SEE FIG. 1102)   | 1                    | A                 |
| 4                     | 7727042-10    | . PANEL ASSY, SIDE COWL, RIGHT HAND, ENGINE NACELLE (FOR.<br>BREAKDOWN SEE FIG. 1102)   | 1                    | A                 |
|                       | 5-85654-25    | . FAIRING ASSY, NACELLE FORWARD . . . . .   | 1                    | B                 |
|                       | 5-85654       | . FAIRING ASSY, NACELLE FORWARD (ALTERNATE AND FOR. . . .<br>REPLACEMENT ORDER 5-85654-25)  | 1                    | C                 |
| 4A                    | 5-85654-21    | . . . BLOCK, STOP, NACELLE FORWARD. . . . .   | 2                    | A                 |
| 5                     | 99836         | . . . PIN, COWL FASTNR (61864) (BACP18A5) . . . . .   | 4                    | A                 |
| 6                     | 98265-2-.230  | . . . STUD, COWL FASTNR (61864) (BACS21B5FH23) . . . . .  | 4                    | A                 |
| 7                     | 60-1507       | . . . PIN, FAIRING SUPPORT, FORWARD NACELLE . . . . .<br>(ATTACHING PARTS)  | 2                    | A                 |
|                       | NAS517-3-8    | . . . SCREW (ALTERNATE BACB30LU3-8) . . . . .   | 2                    | A                 |
|                       | NAS517-3-12   | . . . SCREW (ALTERNATE BACB30LU3-12) . . . . .  | 2                    | A                 |
|                       | AN960-10L     | . . . WASHER. . . . .   | 4                    | A                 |
|                       | NAS679A3W     | . . . NUT (ALTERNATE BACN10JC3) . . . . .   | 4                    | A                 |
| 8                     | NAS1104-11W   | . . . BOLT (ALTERNATE BACB30NE4-11) . . . . .   | 8                    | A                 |
| 9                     | AN960-416     | . . . WASHER. . . . .   | 8                    | A                 |
| 10                    | NAS679A4W     | . . . NUT (ALTERNATE BACN10JC4) . . . . .   | 8                    | A                 |
| 11                    | 6-84606       | . . . SPACER, HINGE, COWL PANEL, ENGINE NACELLE . . . . .   | 4                    | A                 |
| 12                    | 6-84606-1     | . . . SPACER, HINGE, COWL PANEL, ENGINE NACELLE . . . . .   | 4                    | A                 |
| 12A                   | 5-85654-3     | . . . FRAME, FORWARD FAIRING, NACELLE . . . . .   | 1                    | A                 |
|                       | 5-85653-51    | . FAIRING ASSY, AFT, ENGINE NACELLE, SECTION 71 . . . . .   | 1                    | A                 |
| 13                    | 5-85653-52    | . FAIRING ASSY, AFT FWD, ENGINE NACELLE, SECTION 71 . .   | 1                    | A                 |
| 14                    | 9-66304-1     | . . . U-BOLT, COWL LATCH, ENGINE NACELLE. . . . .<br>(ATTACHING PARTS)  | 2                    | A                 |
| 15                    | MS21042L5     | . . . NUT (REPLACES NAS679A5 OR BACN10JC5) . . . . .  | 4                    | A                 |
| 16                    | AN375-5R      | . . . NUT . . . . .   | 4                    | A                 |
| 17                    | 60-1491       | . . . PIN, GUIDE, COWL FAIRING, ENGINE NACELLE. . . . .<br>(ATTACHING PARTS)  | 2                    | A                 |
| 18                    | AN960-616L    | . . . WASHER. . . . .   | 2                    | A                 |
| 19                    | MS21042L6     | . . . NUT (REPLACES NAS679A6 OR BACN10JC6) . . . . .  | 2                    | A                 |

# FLOW PROCESS CHART

SUBJECT FAIRING ASSY FWD NACELLE

DATE 4/5/89

PCN: 15140A WCD: 15140A WCD DATE: 89073

CHART BEGINS \_\_\_\_\_

PAGE 1 OF 1

CHART ENDS \_\_\_\_\_

PREPARED BY: R. BOLANDS

| WCD<br>OP<br># | SYMBOLS | DESCRIPTION   | WCD<br>OP<br># | SYMBOLS | DESCRIPTION                         |
|----------------|---------|---|----------------|---------|-------------------------------------|
| 10             | ● ◊ ▢ ▽ | REC. + CONCRETE<br>2122 MABPCD                                  | 240            | ● ◊ ▢ ▽ | R/R PINS                            |
|                | ○ ◊ ▢ ▽ | DELAY   | 250            | ● ◊ ▢ ▽ | CHECK ALIGNMENT                     |
|                | ○ ◊ ▢ ▽ | MOVE TO CLEAN + STRIP<br>MABPCA                                 | 260            | ● ◊ ▢ ▽ | INSTALL UPPER BUSHINGS              |
|                | ○ ◊ ▢ ▽ | DELAY   | 270            | ● ◊ ▢ ▽ | ASSURE LATCH FITS BUSHING           |
| 20             | ● ◊ ▢ ▽ | STRIP PAINT + CLEAN   |                | ○ ◊ ▢ ▽ | DELAY                               |
|                | ○ ◊ ▢ ▽ | DELAY   |                | ○ ◊ ▢ ▽ | MOVE TO WASH + PAINT<br>2280 MABPCB |
|                | ○ ◊ ▢ ▽ | MOVE TO SHEETMETAL<br>95 MABPAB                                 |                | ○ ◊ ▢ ▽ | DELAY                               |
|                | ○ ◊ ▢ ▽ | DELAY   | 280            | ● ◊ ▢ ▽ | WASH                                |
| 30             | ○ ◊ ▢ ▽ | SHAKEDOWN INSPECTION  | 290            | ● ◊ ▢ ▽ | PAINT INTERIOR SURFACE              |
| 40             | ● ◊ ▢ ▽ | REMOVE CORROSION  |                | ○ ◊ ▢ ▽ | DELAY                               |
| 50             | ● ◊ ▢ ▽ | REPAIR L.H. LONGERON  |                | ○ ◊ ▢ ▽ | MOVE TO SHEETMETAL<br>95 MABPAB     |
| 60             | ○ ◊ ▢ ▽ | BLANK STEP  |                | ○ ◊ ▢ ▽ | DELAY                               |
| 70             | ● ◊ ▢ ▽ | R/R FRAME 5-85634-5   | 300            | ● ◊ ▢ ▽ | WORK COMPLETED INSPECT<br>+ TAG     |
| 80             | ● ◊ ▢ ▽ | ASSY. 60-1512-1 + 60-1512-2<br>PLATES, INSTALL BLOC + L BUSHING |                | ○ ◊ ▢ ▽ |                                     |
| 90             | ● ◊ ▢ ▽ | R/R FRAME 5-85634-4   |                | ○ ◊ ▢ ▽ |                                     |
| 100            | ● ◊ ▢ ▽ | R/R LONGERON IN FIXTURE<br>5-85647-ASST                         |                | ○ ◊ ▢ ▽ |                                     |
| 110            | ● ◊ ▢ ▽ | INSTALL PLATES  |                | ○ ◊ ▢ ▽ |                                     |
| 120            | ● ◊ ▢ ▽ | R/R FORMER  |                | ○ ◊ ▢ ▽ |                                     |
| 130            | ● ◊ ▢ ▽ | ASSY. PLATES  |                | ○ ◊ ▢ ▽ |                                     |
| 140            | ● ◊ ▢ ▽ | R/R FRAME IN FIXTURE  |                | ○ ◊ ▢ ▽ |                                     |
| 150            | ● ◊ ▢ ▽ | R/R SKIN ON FIXTURE<br>5-85654-800                              |                | ○ ◊ ▢ ▽ |                                     |
| 160            | ● ◊ ▢ ▽ | R/R SKIN ON FIXTURE<br>-801                                     |                | ○ ◊ ▢ ▽ |                                     |
| 170            | ● ◊ ▢ ▽ | R/R STIFFENER   |                | ○ ◊ ▢ ▽ |                                     |
| 180            | ● ◊ ▢ ▽ | R/R ANGLE R.H.  |                | ○ ◊ ▢ ▽ |                                     |
| 190            | ● ◊ ▢ ▽ | R/R ANGLE L.H.  |                | ○ ◊ ▢ ▽ |                                     |
| 200            | ● ◊ ▢ ▽ | R/R FRAME 60-1514-1   |                | ○ ◊ ▢ ▽ |                                     |
| 210            | ● ◊ ▢ ▽ | R/R " -2  |                | ○ ◊ ▢ ▽ |                                     |
| 220            | ● ◊ ▢ ▽ | R/R FASTENERS   |                | ○ ◊ ▢ ▽ |                                     |
| 230            | ● ◊ ▢ ▽ | R/R DENTS/SCRATCHES   |                | ○ ◊ ▢ ▽ |                                     |

NO OPERATION  
DONE ←

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*****
1 15140A * WORK CONTROL DOCUMENT * MISTR 1.DATE 89073 PAGE 1 OF 3 PAGES
*****
12.ORIG/PROD NR 13.QUANTITY 14.PROD SECTION/RCC 15.DATE SCHED 16.DATE COMP
| | | MBPAB | 89093 |
|-----|-----|-----|
17.PART NUMBER 19.ITEM SERIAL NR 10/12.TECH DATA/OPTIONAL
| | | 1.1C-135(K)A-3-1, 3-4,A
|-----|-----|-----|
| 4 0C-1560FL/78-1-1,
10.MODEL/DESIGN/SERIES 11.STOCK NR 12.ECO 13MAY83
| C 135 | | 3.FILL IN ANY ADD'L
|-----|-----|-----|
| 4.WORK REQ'D.
13.MISC 14.NOUN/END ITEM NOUN
| | FAIRING ASSY FWD NACELLE
|-----|-----|-----|
| PHYLIS HEALD/MABEBS/65265
P/N NSN C/N
5-85654-15 1560004637577FL 15140A
5-85654-28 1560001361731FL 15107A
5-85654 1560003409212FL 15125A
|-----|-----|-----|
15.DISP 16.FDN/
STATION/OP NO. 17.WORK TO BE ACCOMPLISHED 18.MECH 19"P" 20"Q"
|-----|-----|-----|
2122 010 RECEIVE & UNCRATE / /
| MBPAB MOVE TO MBPCA
|-----|-----|-----|
2122 020 STRIP INTERIOR OF ZINC CHROMATE & / /
| MBPCA CLEAN EXTERIOR SURFACE IAW 1C-135(K)
| A-3-4 MOVE TO BLDG. 95, MBPAB
|-----|-----|-----|
95 030 SHAKEDOWN INSPECTION IAW WORK REQ'T / /
| MBPAB ANNOTATE DISCREPANCIES.
| MBPAB.
|-----|-----|-----|
95 040 REMOVE CORROSION IAW 1C-135(K)A-3-4 / /
| MBPAB PARA. 4-9 THRU 4-17
| REQ'D____NOT REQ'D____
|-----|-----|-----|
95 050 REPAIR OR REPLACE L.H. LONGERON P/N E /
| MBPAB 5-85654-1 IAW 1C-135(K)A-3-1, FIG 10
| -3 IN FIXTURE P/N 5-8564ASMJ ECO
| 13MAY83 CLARIFY CUTOFF FOR -1
| LONGERON IN SHOP.
| REQ'D____NOT REQ'D____
|-----|-----|-----|
95 060 THIS STEP LEFT BLANK INTENTIONALLY
| MBPAB
|-----|-----|-----|
95 070 FRAME P/N 5-85654-5 / /
| MBPAB REPAIR____REPLACE____NOT REQ'D____
|-----|-----|-----|
95 080 ASSEMBLE 60-1512-1 AND 60-1512-2 / /
| MBPAB PLATES ON 5-85654-5. INSTALL BLOCKS
| AND LOWER BUSHINGS.
| REQ'D____NOT REQ'D____
|-----|-----|-----|
95 090 FRAME P/N 5-85654 4 C /
| MBPAB REPAIR____REPLACE____NOT REQ'D____
|-----|-----|-----|
95 100 R.H. LONGERON P/N 5-85654-2 IAW 1C- E /
| MBPAB 135(K)A-3-1, FIG 10 3 IN FIXTURE P/N
| 5-85654-ASMJ
|-----|-----|-----|
***** (CONTINUED) *****

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|  |       |                                      |         |           |   |   |  |  |  |
|--|-------|--------------------------------------|---------|-----------|---|---|--|--|--|
| *****  |       |                                      |         |           |   |   |  |  |  |
| 15140A * WORK CONTROL DOCUMENT * MISTR 1. DATE 37073 PAGE 2 OF 3 PAGES |       |                                      |         |           |   |   |  |  |  |
| 15. DISP-16. PDN/  |       |                                      |         |           |   |   |  |  |  |
| STATION OP NO. 17. WORK TO BE ACCOMPLISHED 18. MECH 19 "P" 20 "Q"      |       |                                      |         |           |   |   |  |  |  |
|  |       | REPAIR                               | REPLACE | NOT REQ'D |   |   |  |  |  |
| 95   | 110   | INSTALL PLATES P/N 60-1513, 60-1510  |         |           | / | / |  |  |  |
|  | MBPAB | AND STIFFENER P/N 60-1515-2 ON       |         |           |   |   |  |  |  |
|  |       | 5-85654-2 LONGERON                   |         |           |   |   |  |  |  |
|  |       | REPAIR                               | REPLACE | NOT REQ'D |   |   |  |  |  |
| 95   | 120   | FORMER P/N 5-85654-3                 |         |           | E | / |  |  |  |
|  | MBPAB |                                      |         |           |   |   |  |  |  |
|  |       | REPAIR                               | REPLACE | NOT REQ'D |   |   |  |  |  |
| 95   | 130   | ASSEMBLE PLATES 60-1511-3 & 60-1511- |         |           | / | / |  |  |  |
|  | MBPAB | 4. FRAMES 60-1514-3 & 60-1514-4 ON   |         |           |   |   |  |  |  |
|  |       | FORMER P/N 5-85654-3. INSTALL BLOCKS |         |           |   |   |  |  |  |
|  |       | AND LOWER BUSHINGS.                  |         |           |   |   |  |  |  |
|  |       | REQ'D                                |         | NOT REQ'D |   |   |  |  |  |
| 95   | 140   | FRAME P/N 5-85654-6 IN FIXTURE P/N   |         |           | / | / |  |  |  |
|  | MBPAB | 5-85654-ASMJ                         |         |           |   |   |  |  |  |
|  |       | REQ'D                                |         | NOT REQ'D |   |   |  |  |  |
| 95   | 150   | PLACE IN FIXTURE TO REPAIR/REPLACE   |         |           | / | / |  |  |  |
|  | MBPAB | SKIN P/N 5-85654-800                 |         |           |   |   |  |  |  |
|  |       | REPAIR                               | REPLACE | NOT REQ'D |   |   |  |  |  |
| 95   | 160   | PLACE IN FIXTURE TO REPAIR/REPLACE   |         |           | E | / |  |  |  |
|  | MBPAB | SKIN P/N 5-85654-801                 |         |           |   |   |  |  |  |
|  |       | REPAIR                               | REPLACE | NOT REQ'D |   |   |  |  |  |
| 95   | 170   | STIFFENER P/N 5-85654-22             |         |           | / | / |  |  |  |
|  | MBPAB | REPAIR                               | REPLACE | NOT REQ'D |   |   |  |  |  |
| 95   | 180   | R.H. ANGLE P/N 5-85654-24            |         |           | / | / |  |  |  |
|  | MBPAB | REPAIR                               | REPLACE | NOT REQ'D |   |   |  |  |  |
| 95   | 190   | L.H. ANGLE P/N 5-85654-25            |         |           | / | / |  |  |  |
|  | MBPAB | REPAIR                               | REPLACE | NOT REQ'D |   |   |  |  |  |
| 95   | 200   | FRAME P/N 60-1514-1 IN FIXTURE       |         |           | / | / |  |  |  |
|  | MBPAB | REPAIR                               | REPLACE | NOT REQ'D |   |   |  |  |  |
| 95   | 210   | FRAME P/N 60-1514-2 IN FIXTURE       |         |           | / | / |  |  |  |
|  | MBPAB | REPAIR                               | REPLACE | NOT REQ'D |   |   |  |  |  |
| 95   | 220   | LOOSE, MISSING & DEFECTIVE FASTENERS |         |           | / | / |  |  |  |
|  | MBPAB | REPAIR                               | REPLACE | NOT REQ'D |   |   |  |  |  |
| 95   | 230   | REPAIR ALL MINOR DENTS, SCRATCHES,   |         |           | / | / |  |  |  |
|  | MBPAB | NICKS AND ABRASIONS.                 |         |           |   |   |  |  |  |
|  |       | REQ'D                                |         | NOT REQ'D |   |   |  |  |  |
| 95   | 240   | REPLACE PIN P/N 60-1507 IF WORN      |         |           | / | / |  |  |  |
|  | MBPAB | BEYOND DRAWING DIMENSIONS.           |         |           |   |   |  |  |  |
|  |       | REQ'D                                |         | NOT REQ'D |   |   |  |  |  |
| 95   | 250   | CHECK IN FIXTURE P/N 5-85654-ASMJ    |         |           | E | / |  |  |  |
|  | MBPAB | FOR ALIGNMENT.                       |         |           |   |   |  |  |  |

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|  |       |                                      |   |   |   |  |
|--|-------|--------------------------------------|---|---|---|--|
| *****  |       |                                      |   |   |   |  |
| 15140A * WORK CONTROL DOCUMENT * M131R 1. DATE 89073 PAGE 3 OF 3 PAGES |       |                                      |   |   |   |  |
| 15.DISP-16.FDN/  |       |                                      |   |   |   |  |
| STATION/OP NO. 17.WORK TO BE ACCOMPLISHED 18.MECH 19"P" 20"Q"          |       |                                      |   |   |   |  |
| 95   | 260   | INSTALL UPPER BUSHINGS IN FORMERS    |   | / | / |  |
|  | MBPAB | P/N 5-85657-3 & 5-85654 5.           |   |   |   |  |
| 95   | 270   | MAKE SURE LATCH P/N 5-96762-2 &      |   | E | / |  |
|  | MBPAB | 5-96766-3, FITS BUSHING & SLOTS      |   |   |   |  |
|  |       | AT NO. 5 RIB & NO. 3 RIB, BOTH SIDES |   |   |   |  |
| 2100   | 280   | FINAL WASH & CORROSION TREATMENT     |   | / | / |  |
|  | MBPCB |                                      |   |   |   |  |
| 2200   | 290   | PAINT INTERIOR SURFACE WITH MIL-P-   |   | / | / |  |
|  | MBPCB | 23377 1AW 10-135(K)A-3-4, SECTION X1 |   |   |   |  |
|  |       | MOVE TO BLDG. 95                     |   |   |   |  |
| 95   | 300   | WORK COMPLETED, CONDITION TAG        |   | C | / |  |
|  | MBPAB | DATE _____ MOVE TO CRATING           | / |   |   |  |
|  |       | NOTE: PART WILL HAVE EITHER DC-ALC   |   |   |   |  |
|  |       | FORM 586,587,588 IDENTIFICATION,     |   |   |   |  |
|  |       | LABELS APPLIED TO COMPLETED ITEM     |   |   |   |  |
|  |       | 1AW NAOI 66-4.                       |   |   |   |  |
|  |       | ACCEPTANCE DATE ON THE LABELS ALONG  |   |   |   |  |
|  |       | WITH "M" STAMP OF THE PERSON         |   |   |   |  |
|  |       | PERFORMING THE OVERHAUL.             |   |   |   |  |
|  |       | COORDINATION                         |   |   |   |  |
|  |       | MABEBS PHYLLIS HEALD 22 MARCH 89     |   |   |   |  |
|  |       | MABSCS CONNIE WEBBER 22 MARCH 89     |   |   |   |  |
|  |       | MABPAB JESSIE JACOBS 22 MARCH 89     |   |   |   |  |
|  |       | MAOBN ILL HAYES 22 MARCH 89          |   |   |   |  |

15150 A

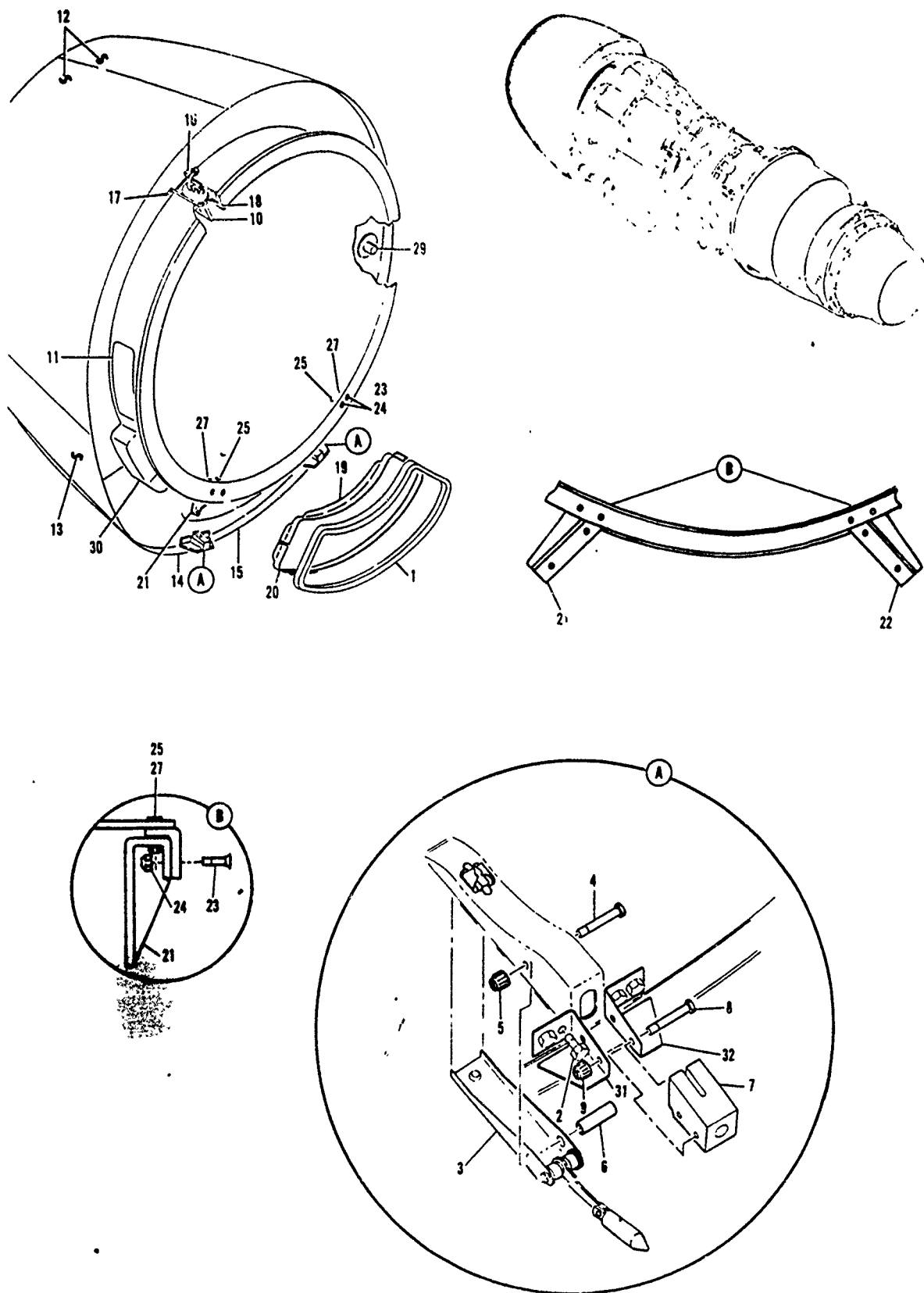


Figure 4-24. Nose Cowl Assembly

| FIGURE &<br>INDEX NO. | PART NUMBER   | DESCRIPTION   | 1 2 3 4 5 6 7 |  |  |  |  |  |  | REF<br>ASSY | UN<br>CODE |
|-----------------------|---------------|---|---------------|--|--|--|--|--|--|-------------|------------|
|                       |               |   |               |  |  |  |  |  |  |             |            |
| 4-24                  | 5-85655-150   | COWL ASSY, Engine nacelle nose (see figure 4-2, . . . . . index 5)  |               |  |  |  |  |  |  | Ref         |            |
|                       | 5-85655-811   | . DUCT ASSY . . . . .   |               |  |  |  |  |  |  | 1           |            |
| -1                    | 60-5176       | . SEAL. . . . .   |               |  |  |  |  |  |  | 1           |            |
| -2                    | NAS1103-3DW   | . BOLT (For replacement order BACB30NF3D3). . . . .   |               |  |  |  |  |  |  | 8           |            |
| -3                    | 90-3588-4     | . LATCH ASSY, Engine cowl panel safety (optional. . . . . 90-3588)  |               |  |  |  |  |  |  | 2           |            |
|                       |               | (ATTACHING PARTS)   |               |  |  |  |  |  |  |             |            |
| -4                    | NAS1303-16    | . BOLT (Replaces AN3-13A, (for replacement order . . . . . BACB30NF3-16)  |               |  |  |  |  |  |  | 2           |            |
| -5                    | MS21042L3     | . NUT, Self-locking 500°F (replaces NAS679A3W) (for . . . . . replacement order BACN10JC3)                            |               |  |  |  |  |  |  | 2           |            |
| -6                    | NAS43-3-65    | . SPACER (For replacement order NAS43HT-3-65) . . . . .   |               |  |  |  |  |  |  |             |            |
| -7                    | 60-5700       | . FITTING, Engine cowl safety latch . . . . .   |               |  |  |  |  |  |  |             |            |
|                       |               | (ATTACHING PARTS)   |               |  |  |  |  |  |  |             |            |
| -8                    | NAS1303-14    | . BOLT (Replaces AN3-12A) (for replacement order. . . . . BACB30NF3-14)   |               |  |  |  |  |  |  |             |            |
| -9                    | MS21042L3     | . NUT, Self-locking 500°F (replaces NAS679A3W) (for . . . . . replacement order BACN10JC3)                            |               |  |  |  |  |  |  |             |            |
| -10                   | 65-63031-501  | . PROBE ASSY, Engine inlet pressure (optional . . . . . 65-1570-8, 65-1570, 65-63031; 65-63031-9 use until exhaust d) |               |  |  |  |  |  |  |             |            |
| -11                   | BACN10B62-9DK | . METAL-CAL . . . . .   |               |  |  |  |  |  |  |             |            |
| -12                   | 5-85655-6     | . SKIN ASSY, Outer. . . . .   |               |  |  |  |  |  |  | 2           |            |
| -13                   | 5-85655-3     | . SKIN ASSY, Outer. . . . .   |               |  |  |  |  |  |  | 1           |            |
|                       | 5-85655-4     | . SKIN ASSY, Outer (opposite 5-85655-3) . . . . .   |               |  |  |  |  |  |  | 1           |            |
|                       | 5-85655-2     | . SKIN ASSY, Lower forward. . . . .   |               |  |  |  |  |  |  | 1           |            |
| -14                   | 5-85655-8     | . SKIN ASSY, Lower forward. . . . .   |               |  |  |  |  |  |  | 1           |            |
| -15                   | 5-85655-5     | . SKIN ASSY, Lower aft. . . . .   |               |  |  |  |  |  |  | 1           |            |
| -16                   | 5-85655-148   | . BRACKET . . . . .   |               |  |  |  |  |  |  | 1           |            |
| -17                   | 5-85655-149   | . CLIP. . . . .   |               |  |  |  |  |  |  | 1           |            |
| -18                   | 66-20097      | . STIFFENER, Probe support. . . . .   |               |  |  |  |  |  |  |             |            |
| -19                   | 5-85655-94    | . RETAINER Seal. . . . .  |               |  |  |  |  |  |  |             |            |
| -20                   | 5-85655-95    | . RETAINER, Seal. . . . .   |               |  |  |  |  |  |  |             |            |
| -21                   | 50-9571-7     | . FITTING ASSY, Oil cooler support. . . . .   |               |  |  |  |  |  |  |             |            |
| -22                   | 50-9571-8     | . FITTING ASSY, Oil cooler support. . . . .   |               |  |  |  |  |  |  |             |            |
|                       |               | (ATTACHING PARTS)   |               |  |  |  |  |  |  |             |            |
| -23                   | NAS1503-12    | . BOLT, Nose cowl fitting . . . . .   |               |  |  |  |  |  |  | 8           |            |
| -24                   | MS21042L3     | . NUT (Replaces NAS679A3W) (optional BACN10JC3) . . . . .   |               |  |  |  |  |  |  |             |            |
| -25                   | (a) NAS1456-4 | . PIN, Stage locking (optional BACB30GX6-4) . . . . .   |               |  |  |  |  |  |  |             |            |
| -26                   | (a) NAS1080-6 | . COLLAR, Stage locking (optional NAS1080R6). . . . .   |               |  |  |  |  |  |  | 4           |            |
| -27                   | (b) HL21PB6-4 | . HI-LOCK FASTENER (73197). . . . .   |               |  |  |  |  |  |  | 4           |            |
| -28                   | (b) HL86PB6   | . COLLAR (Optional HL86PBW6). . . . .   |               |  |  |  |  |  |  | 4           |            |
| -29                   | 90-6964       | . EJECTOR ASSY, Nose cowl anti-ice. . . . .   |               |  |  |  |  |  |  | 1           |            |
| -30                   | 50-6395       | . DUCT ASSY, Alternator exhaust . . . . .   |               |  |  |  |  |  |  | 1           |            |
| -31                   | 60-5199-1     | . BRACKET . . . . .   |               |  |  |  |  |  |  | 2           |            |
| -32                   | 60-5199-2     | . BRACKET . . . . .   |               |  |  |  |  |  |  | 2           |            |
|                       |               | (a) Used on inboard position at field level repair.   |               |  |  |  |  |  |  |             |            |
|                       |               | (b) Optional on outboard side of each bracket when replaced at field level.   |               |  |  |  |  |  |  |             |            |

# FLOW PROCESS CHART

SUBJECT Nose Cowl Assembly

DATE 4/4/89

PCN: 15150A WCD: 15150A WCD DATE: 88054

CHART BEGINS \_\_\_\_\_

CHART ENDS \_\_\_\_\_

PREPARED BY: Tom Hall

| SYMBOLS       | DESCRIPTION  | SYMBOLS       | DESCRIPTION   |
|---------------|--|---------------|---|
| 010 ● ◊ D □ ▽ | Receive & Unarchive<br>2122 MARKED                   | 160 ● ◊ D □ ▽ | Replace outer skins<br>S-85655-3 MARKED               |
| ◊ ◊ D □ ▽     | Delay  | 170 ● ◊ D □ ▽ | Replace outer skin<br>S-85655-4                       |
| ◊ ◊ D □ ▽     | Move to MABPCA<br>2122 MARKED                        | 180 ● ◊ D □ ▽ | Replace outer skin<br>S-85655-2                       |
| ◊ ◊ D □ ▽     | Delay  | 190 ● ◊ D □ ▽ | Replace outer skin<br>S-85655-13                      |
| 020 ● ◊ D □ ▽ | Wash   | 200 ● ◊ D □ ▽ | "<br>S-85655-14                                       |
| 021 ● ◊ D □ ▽ | Strip  | 210 ● ◊ D □ ▽ | Repair Webs   |
| ◊ ◊ D □ ▽     | Delay  | 220 ● ◊ D □ ▽ | Repair Frame<br>S-85655-123                           |
| ◊ ◊ D □ ▽     | Move to Bldg 95<br>95 MARKED                         | 230 ● ◊ D □ ▽ | Replace Frame<br>S-85655-123                          |
| ◊ ◊ D □ ▽     | Delay  | 240 ● ◊ D □ ▽ | Remove Corrosion &<br>Treat                           |
| 025 ● ◊ D □ ▽ | Position on Fixture                                  | 250 ● ◊ D □ ▽ | Repair Anti-ice<br>manifold                           |
| 030 ● ◊ D □ ▽ | Shakedown  | 260 ● ◊ D □ ▽ | Repair Latches  |
| ◊ ◊ D □ ▽     | Delay  | 270 ● ◊ D □ ▽ | Replace latches if cracks<br>are found                |
| 040 ◊ ◊ D □ ▽ | Inspect - Fluorescent<br>Bldg 95 MARKED              | 280 ● ◊ D □ ▽ | Replace Latches if wear<br>exceeds limits             |
| ◊ ◊ D □ ▽     | Delay  | 290 ● ◊ D □ ▽ | Repair dents in nose<br>cowl                          |
| 050 ● ◊ D □ ▽ | Treat for Corrosion<br>MARKED                        | 300 ● ◊ D □ ▽ | Replace bad, loose, missing<br>or defective fasteners |
| 060 ● ◊ D □ ▽ | Replace Inner Skin                                   | 310 ● ◊ D □ ▽ | Measure and trim off<br>of outer skins                |
| 061 ● ◊ D □ ▽ | Replace former PIN                                   | 320 ● ◊ D □ ▽ | Place in Fixture                                      |
| 062 ● ◊ D □ ▽ | Replace Structural Plate                             | 325 ● ◊ D □ ▽ | Replace ejector                                       |
| 063 ● ◊ D □ ▽ | Replace air duct bulkhead                            | 330 ● ◊ D □ ▽ | Install Access Covers                                 |
| 064 ● ◊ D □ ▽ | Replace Duct Assy                                    | 340 ● ◊ D □ ▽ | Repair Lap strips                                     |
| 065 ● ◊ D □ ▽ | Repair Attachment Ring                               | 350 ● ◊ D □ ▽ | Replace Lap strips                                    |
| 066 ● ◊ D □ ▽ | Replace attach. ring                                 | 360 ● ◊ D □ ▽ | Replace seal  |
| 070 ● ◊ D □ ▽ | Repair oil cooler tab<br>attach. hole                | 370 ● ◊ D □ ▽ | Remove all Foreign<br>objects                         |
| 100 ● ◊ D □ ▽ | Replace oil cooler support<br>Fittings               | ◊ ◊ D □ ▽     | Delay   |
| 110 ● ◊ D □ ▽ | Repair Probe, pressure check<br>remove nicks & burrs | ◊ ◊ D □ ▽     | Move to Bldg 2280<br>2280 MARKED                      |
| 120 ◊ ◊ D □ ▽ | Inspect probe w/ magna                               | ◊ ◊ D □ ▽     | Delay   |
| 130 ● ◊ D □ ▽ | Replace probe, pressure<br>check                     | 380 ● ◊ D □ ▽ | Final Wash  |
| 140 ● ◊ D □ ▽ | Replace outer skin<br>PIN S-85655-5                  | 385 ● ◊ D □ ▽ | Final Corrosion Treat                                 |
| 150 ● ◊ D □ ▽ | Replace outer skin<br>PIN S-85655-6                  | 390 ● ◊ D □ ▽ | Paint & Apply Finish                                  |



## FLOW PROCESS CHART

SUBJECT Nose and Assembly

DATE 5/4/89

PCN: 15150A WCD: 15150A WCDDATE: 88054

CHART BEGINS operation 10

CHART ENDS excretion 420

PREPARED BY: Tim Hall

[illegible]

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*****
1 15150A * WORK CONTROL DOCUMENT * REGISTER 1. DATE 08054 PAGE 1 OF 5 PAGES
*****
12. ORIG/PROD NR 13. QUANTITY 14. PROD SECTION/ROLL 15. DATE SCHED 16. DATE COMP
1 15150A 1 MBPAB 1 89093 1
*****
17. PART NUMBER 19. ITEM SERIAL NR 18/12. TECH DATA/OPTIONAL
1 5-85655-150 1 SOW OC/1560FL/85-61,
1 DID 24 OCT 84
10. MODEL/DESIGN/SERIES 11. STOCK NR
1 KC 135 1 1560006067420FL
13. DISC 14. NOUN/END ITEM NOUN
1 NOSE COWL ASSY
1 L. HULLINAX/MABEBS/65266
15. DISP-16. PON/
1 STATION/UP NO. 117. WORK TO BE ACCOMPLISHED 110. BLCH 19" 11" 10" 6"
2122 010 RECEIVE, IDENTIFY & UNCRATE. / /
1 MBPCD NOSE COWL
2122 020 WASH INT & EXT IAW T.O. KC 135(K) / /
1 MBPCA A-3-4 PARA 11-7 & SOW OC/1560FL
1 85-61
2122 021 STRIP INT & EXT SURFACES OF NOSE / /
1 MBPCA COWL IAW T.O. KC 135(K) A-3-4 PARA
1 11-13 THRU 11-15 & SOW 85-61.
1 REQD----- NOT REQD-----
1 MOVE TO MBPAB
95 025 POSITION NOSE COWL ON FIXTURE / /
1 MBPAB P/N 5-85655-0 CHECK RING FLATNESS
1 IAW SOW OC 1560 85-61
95 030 SHAKEDOWN AS PER SOW OC/1560FL/85-61 / /
1 MBPAB SEC III
95 040 PERFORM FLOUKESECENT PENETRANT INSP. N /
1 MBPCA IAW SOW OC/1560FL/85-61, SEC III /
95 050 CORROSION TREAT IAW SOW / /
1 MBPAB OC 1560 85-61 & T.O. 1C-135(K) A-3-4
1 SEC 4.
95 060 REPLACE INNER SKIN IAW SOW E /
1 MBPAB OC/1560FL/85-61, SEC III
1 REQD----- NOT REQD-----
95 061 REPLACE FORMER P/N 5-85655-129 / /
1 MBPAB REQD----- NOT REQD-----
95 062 REPLACE STRUCTURAL PLATE P/N / /
1 MBPAB 5-85655-147 REQD----- NOT REQD-----
95 063 REPLACE AIRDUCT BULKHEAD P/N / /
1 MBPAB 5-85655-118 REQD----- NOT REQD-----
95 064 REPLACE DUCT ASST P/N 50-6395 / /
1 MBPAB REQD----- NOT REQD-----
95 070 REPAIR ATTACH / /
1 MBPAB 1C-135(K) A-3-3
*****

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(CONTINUED)

| *****   |              |   |         |       |       |
|---|--------------|---|---------|-------|-------|
| 15150A * WORK CONTROL DOCUMENT * NISIR 1 DATE 88054 PAGE 2 OF 3 PAGES |              |   |         |       |       |
| 15.DISP-16.FDN/   |              |   |         |       |       |
| STATION   | OP NO.       | 17.WORK TO BE ACCOMPLISHED  | 18.MECH | 19"P" | 20"Q" |
|   |              | REQD_____ NOT REQD_____   |         |       |       |
| 95  | 080<br>MBPAB | REPLACE ATTACH RING IAW SOW<br>OC/1560FL/85-61, SEC III . USE "Z"<br>FIXTURE TO LOCATE RING.<br>REQD_____ NOT REQD_____   |         | E     | /     |
| 95  | 090<br>MBPAB | REPAIR OIL COOLER TAB ATTACH HOLE<br>OC/150FL/85-61, SEC III & T.O.<br>1C-135(K)A-3-1<br>REQD_____ NOT REQD_____          |         | /     | /     |
| 95  | 100<br>MBPAB | REPLACE OIL COOLER SUPPORT FITTINGS<br>AND CHECK LOCATION OF MOUNT HOLES<br>IN RING IAW SOW OC/1560FL/85-61,<br>SEC III   |         | /     | /     |
| 95  | 110<br>MBPAB | REPAIR PROBE (PT2) PRESSURE CHECK,<br>REMOVE NICKS & BURRS IAW SOW<br>OC/1560FL/85-61, SEC III<br>REQD_____ NOT REQD_____ |         | /     | /     |
| 95  | 120<br>MBPAB | CHECK PROBE (PT2) WITH VACUUM IAW<br>SOW OC/1560FL/85-61, SEC III   |         | /     | /     |
| 95  | 130<br>MBPAB | REPLACE PROBE (PT2) PRESSURE CHECK<br>IAW SOW OC/1560FL/85-61, SEC III<br>REQD_____ NOT REQD_____                         |         | /     | /     |
| 95  | 140<br>MBPAB | REPLACE OUTER SKIN, P/N 5-85655-5<br>IAW SOW OC/1560FL/85-61, SEC III<br>REQD_____ NOT REQD_____                          |         | E     | /     |
| 95  | 150<br>MBPAB | REPLACE OUTER SKIN P/N 5-85655-6<br>IAW SOW OC/1560FL/85-61, SEC III<br>REQD_____ NOT REQD_____                           |         | /     | /     |
| 95  | 155<br>MBPAB | REPLACE SKIN P/N 5-85655-6 (same part no. 95 of 1500/<br>but there are two skins)<br>REQD_____ NOT REQD_____              |         | /     | /     |
| 95  | 160<br>MBPAB | REPLACE OUTER SKINS, P/N 5-85655-3<br>IAW SOW OC/1560FL/85-61, SEC III<br>REQD_____ NOT REQD_____                         |         | /     | /     |
| 95  | 170<br>MBPAB | REPLACE OUTER SKIN P/N 5-85655-4 IAW<br>SOW OC/1560FL/85-61, SEC III<br>REQD_____ NOT REQD_____                           |         | E     | /     |
| 95  | 180<br>MBPAB | REPLACE OUTER SKIN P/N 5-85655-2 IAW<br>SOW OC/1560FL/85-61, SEC III<br>REQD_____ NOT REQD_____                           |         | /     | /     |
| 95  | 190<br>MBPAB | REPLACE OUTER SKIN P/N 5-85655-13<br>IAW SOW OC/1560FL/85-61, SEC III<br>REQD_____ NOT REQD_____                          |         | /     | /     |
| 95  | 200<br>MBPAB | REPLACE OUTER SKIN P/N 5-85655-14<br>IAW SOW OC/1560FL/85-61, SEC III   |         | /     | /     |

\*\*\*\*\* (CONTINUED) \*\*\*\*\*

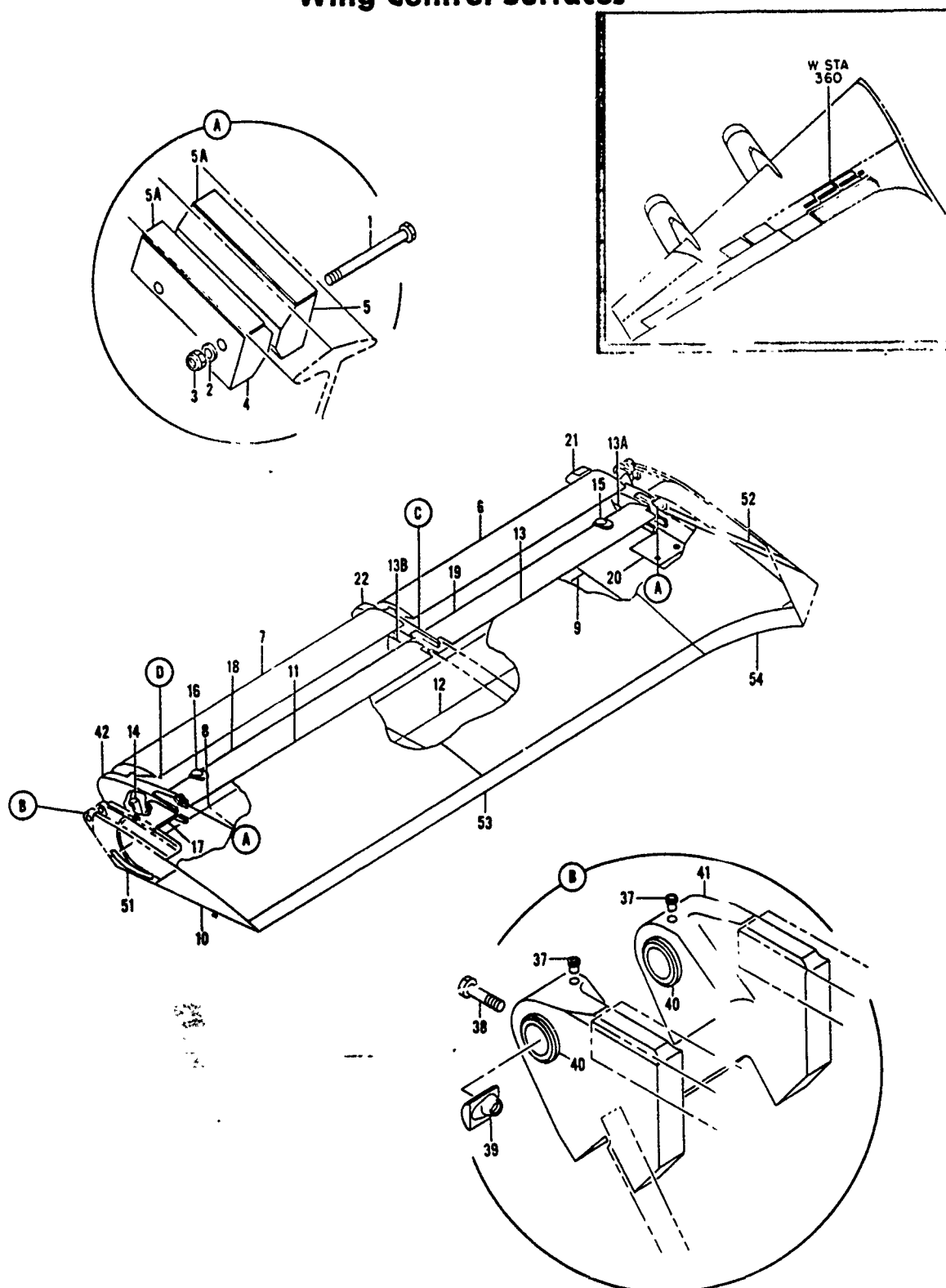
| *****  |       |                                      |           |   |   |  |  |  |  |
|--|-------|--------------------------------------|-----------|---|---|--|--|--|--|
| 15150A * WORK CONTROL DOCUMENT * MISTR 1. DATE 08054 PAGE 3 OF 5 PAGES |       |                                      |           |   |   |  |  |  |  |
| 15.DISP-16.PDN/  |       |                                      |           |   |   |  |  |  |  |
| STATION/OP NO. 117.WORK TO BE ACCOMPLISHED 110.MECH112"P"120"Q"        |       |                                      |           |   |   |  |  |  |  |
|  |       | REQD                                 | NOT REQD  |   |   |  |  |  |  |
| 95   | 210   | REPAIR WEBS IAW SOW OC/1560FL/85-61. |           | / | / |  |  |  |  |
|  | MBPAB | SEC III                              |           |   |   |  |  |  |  |
|  |       | REQD                                 | NOT REQD  |   |   |  |  |  |  |
| 95   | 220   | REPAIR FRAME, P/N 5-85655-123 IAW    |           | / | / |  |  |  |  |
|  | MBPAB | SOW OC/1560FL/85-61, SEC III         |           |   |   |  |  |  |  |
|  |       | REQ'D                                | NOT REQ'D |   |   |  |  |  |  |
| 95   | 230   | REPLACE FRAME, P/N 5-85655-124 IAW   |           | / | / |  |  |  |  |
|  | MBPAB | SOW OC/1560FL/85-61, SEC III         |           |   |   |  |  |  |  |
|  |       | REQD                                 | NOT REQD  |   |   |  |  |  |  |
| 95   | 240   | REMOVE CORROSION & TREAT IAW SOW     |           | / | / |  |  |  |  |
|  | MBPAB | OC/1560FL/85-61, SEC III             |           |   |   |  |  |  |  |
|  |       | REQD                                 | NOT REQD  |   |   |  |  |  |  |
| 95   | 250   | REPAIR ANTI-ICE MANIFOLD IAW SOW     |           | / | / |  |  |  |  |
|  | MBPAB | OC/1560FL/85-61, SEC III             |           |   |   |  |  |  |  |
|  |       | REQD                                 | NOT REQD  |   |   |  |  |  |  |
| 95   | 260   | REPAIR LATCHES IAW SOW               |           | / | / |  |  |  |  |
|  | MBPAB | OC/1560FL/85-61, SEC III             |           |   |   |  |  |  |  |
|  |       | REQD                                 | NOT REQD  |   |   |  |  |  |  |
| 95   | 270   | REPLACE LATCHES IF CRACKS ARE FOUND  |           | / | / |  |  |  |  |
|  | MBPAB | IAW SOW OC/1560FL/85-61, SEC III     |           |   |   |  |  |  |  |
|  |       | REQD                                 | NOT REQD  |   |   |  |  |  |  |
| 95   | 280   | REPLACE LATCHES IF WEAR EXCEEDS      |           | / | / |  |  |  |  |
|  | MBPAB | LIMITS AS STATED IN SOW              |           |   |   |  |  |  |  |
|  |       | OC/1560FL/85-61, SEC III             |           |   |   |  |  |  |  |
|  |       | REQD                                 | NOT REQD  |   |   |  |  |  |  |
| 95   | 290   | REPAIR DENIS IN NOSE COWL IAW SOW    |           | E | / |  |  |  |  |
|  | MBPAB | OC/1560FL/85-61, SEC III             |           |   |   |  |  |  |  |
|  |       | REQD                                 | NOT REQD  |   |   |  |  |  |  |
| 95   | 300   | REPLACE BAD, LOOSE, MISSING OR       |           | / | / |  |  |  |  |
|  | MBPAB | DEFECTIVE FASTENERS IAW SOW          |           |   |   |  |  |  |  |
|  |       | OC/1560FL/85-61, SEC III             |           |   |   |  |  |  |  |
|  |       | REQD                                 | NOT REQD  |   |   |  |  |  |  |
| 95   | 310   | MEASURE AND TRIM AFT END OF OUTER    |           | / | / |  |  |  |  |
|  | MBPAB | SKINS USE LOCAL MFG FIXTURE.         |           |   |   |  |  |  |  |
|  |       | REQD                                 | NOT REQD  |   |   |  |  |  |  |
| 95   | 320   | PLACE NOSE COWL IN FIXTURE,          |           | E | / |  |  |  |  |
|  | MBPAB | P/N 5-85655-0 AND PERFORM FINAL      |           |   |   |  |  |  |  |
|  |       | CHECKS IAW SOW OC/1560FL/85-61,      |           |   |   |  |  |  |  |
|  |       | SEC III                              |           |   |   |  |  |  |  |
| 95   | 325   | REPLACE EJECTOR P/N 20-2264          |           | / | / |  |  |  |  |
|  | MBPAB | REQD-----NOT REQD                    |           |   |   |  |  |  |  |

| *****   |              |  |  |   |   |
|---|--------------|--|--|---|---|
| 15150A * WORK CONTROL DOCUMENT * MESTR 1.DATE 08054 PAGE 4 OF 5 PAGES |              |  |  |   |   |
| 15.DISP-16.FDN/   |              |  |  |   |   |
| STATION/OP NO. 17.WORK TO BE ACCOMPLISHED 18.MECH 19"P" 20"W"         |              |  |  |   |   |
| 95  | 330<br>MBPAB | INSTALL ACCESS COVERS ON NOSE COWL.  |  | / | / |
| 95  | 340<br>MBPAB | REPAIR LAP STRIPS IAW SOW<br>OC/1560FL/85-61, SEC III<br>REQD _____ NOT REQD _____   |  | / |   |
| 95  | 350<br>MBPAB | REPLACE LAP STRIP IAW SOW<br>OC/1560FL/85-61, SEC III<br>REQD _____ NOT REQD _____   |  | / | / |
| 95  | 360<br>MBPAB | REPLACE SEAL (OIL COOLER)<br>REQD _____ NOT REQD _____   |  | / |   |
| 95  | 370<br>MBPAB | REMOVE ALL FOREIGN OBJECTS   |  | L | / |
| 2280  | 380<br>MBPCB | FINAL WASH IAW SOW OC/1560FL/85-61,<br>SEC III   |  | / | / |
| 2280  | 385<br>MBPCB | FINAL CORROSION TREAT IAW SOW<br>OC/1560FL/85-61 & T.O.<br>10-135(K)A-3 4, SEC 4.  |  | / | / |
| 2280  | 390<br>MBPCB | PAINT & APPLY FINISH IAW SOW<br>OC/1560FL/85-61, SEC III   |  | / | / |
| 95  | 400<br>MBPAB | APPLY IDENTIFICATION & MARKINGS AND<br>DECALS IAW SOW OC/1560FL/85-61,<br>SEC III  |  | / | / |
| 95  | 410<br>MBPAB | APPLY SCOTCH TAP #850 TO TRAYING<br>SURFACE IAW T.O. 10-135(K)A-3 1,<br>SEC I  |  | L | / |
| 95  | 420<br>MBPAB | WORK COMPLETE, CONDITION TAG IAW<br>AFM 67-1, MOVE TO CRATING  |  | L | / |
| 95  | 430<br>MBPAB | PARTS WILL HAVE OC ALC FORM 506,<br>587 OR 588 IDENTIFICATION LABELS<br>APPLIED TO COMPLETED ITEM IAW<br>NAOI 66-36.<br>ACCEPTANCE DATE ON THE LABEL ALONG<br>WITH "P" STAMP OF THE PERSON PER-<br>FORMING THE OVERHAUL.<br>CAUTION: SURFACES TO WHICH LABELS<br>ARE APPLIED MUST BE FREE OF CON-<br>TAMINATION.<br>NOTE: COMPLETE "REMARKS" COLUMN OF<br>AFLC FORM 1574 IAW NAOI 66-36.<br>NOTE #2: 00J10 SUPPORT 00B10 MFG<br>DOUBLERS, SHIMS, CLIPS, SPACERS &<br>ETC AS REQD IN B SKILL. |  | L | / |



15191A  
15192A

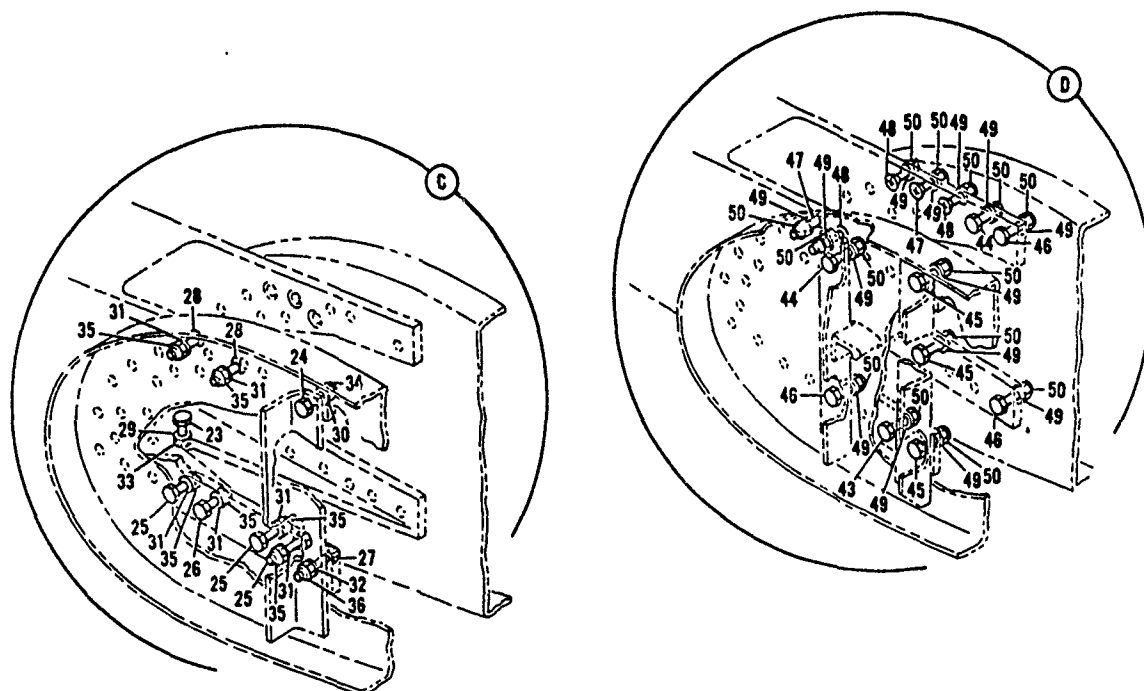
# Wing Control Surfaces



3153-48a

Figure 48. Inboard Flap Installations (Sheet 1 of 2)

## Wing Control Surfaces



3153-48bA

Figure 48. Inboard Flap Installations (Sheet 2 of 2)

| FIGURE &<br>INDEX NO | PART NUMBER    | DESCRIPTION   |   |   |   |   |   |   | UNITS<br>PER<br>ASSY | USE<br>ON<br>CODE |
|----------------------|----------------|---|---|---|---|---|---|---|----------------------|-------------------|
|                      |                | 1   | 2 | 3 | 4 | 5 | 6 | 7 |                      |                   |
| 48 -                 | 5-73131-1      | FLAP INSTL, INBOARD (LH) (FOR NHA SEE FIG. 2) . . . . .   |   |   |   |   |   |   | REF                  |                   |
|                      | 5-73131-2      | FLAP INSTL, INBOARD (RH) (FOR NHA SEE FIG. 2) . . . . .   |   |   |   |   |   |   | REF                  |                   |
|                      | 5-96313        | STOP INSTL, DOWN POSITION, INBOARD AND OUTBOARD FLAP . . . . .  |   |   |   |   |   |   | 2                    |                   |
|                      | 1 NAS464P4A25  | BOLT (FOR REPLACEMENT ORDER NAS1104-25) . . . . .   |   |   |   |   |   |   | 2                    |                   |
|                      | 2 AN960D416L   | WASHER . . . . .  |   |   |   |   |   |   | 2                    |                   |
|                      | 3 NAS679A4W    | NUT (FOR REPLACEMENT ORDER 96-048 (56878) (80539) . . . . .   |   |   |   |   |   |   | 2                    |                   |
|                      |                | H10-48AC (15653) T6S428J (71087) RMLH9075-4W (72962) (BACN10JC4))   |   |   |   |   |   |   |                      |                   |
|                      | 4 3-93742-3    | STOP, DOWN POSITION, INBOARD AND OUTBOARD FLAP . . . . .  |   |   |   |   |   |   | 1                    |                   |
|                      | 5 3-93742-4    | STOP, DOWN POSITION, INBOARD AND OUTBOARD FLAP . . . . .  |   |   |   |   |   |   | 1                    |                   |
|                      | 5A BACS40A7-37 | SHIM, LAM, 0.030 THK (ALTERNATES BACS40B7-37, . . . . .   |   |   |   |   |   |   | AR                   |                   |
|                      |                | BACS40C7-37)  |   |   |   |   |   |   |                      |                   |
|                      | 5-86892-129    | FLAP ASSY, INBOARD (ALTERNATE, ANY AIR FORCE SPARE . . . . .  |   |   |   |   |   |   | 1                    |                   |
|                      |                | FLAP ASSEMBLY (5-86892-1) LH FOR LH INSTALLATION INCORPORATING ALL APPLICABLE TECHNICAL ORDERS) (LH ONLY) |   |   |   |   |   |   |                      |                   |
|                      | 5-86892-130    | FLAP ASSY, INBOARD (ALTERNATE, ANY AIR FORCE SPARE . . . . .  |   |   |   |   |   |   | 1                    |                   |
|                      |                | FLAP ASSEMBLY (5-86892-1) RH FOR RH INSTALLATION INCORPORATING ALL APPLICABLE TECHNICAL ORDERS) (RH ONLY) |   |   |   |   |   |   |                      |                   |
|                      | 6 65-7360-1    | FLAP ASSY, FORE (LH ONLY) (FOR REPLACEMENT ORDER . . . . .  |   |   |   |   |   |   | 1                    | A                 |
|                      | 65-7360-2      | 65-7360-3137) (FOR BREAKDOWN SEE FIG. 56)   |   |   |   |   |   |   |                      |                   |
|                      | 7 65-7360-3    | FLAP ASSY, FORE (RH ONLY) (FOR REPLACEMENT ORDER . . . . .  |   |   |   |   |   |   | 1                    | A                 |
|                      | 65-7360-4      | 65-7360-3138) (FOR BREAKDOWN SEE FIG. 56)   |   |   |   |   |   |   |                      |                   |
|                      |                | FLAP ASSY, FORE (LH ONLY) (FOR REPLACEMENT ORDER . . . . .  |   |   |   |   |   |   | 1                    | A                 |
|                      |                | 65-7360-3135) (FOR BREAKDOWN SEE FIG. 57)   |   |   |   |   |   |   |                      |                   |
|                      |                | FLAP ASSY, FORE (RH ONLY) (FOR REPLACEMENT ORDER . . . . .  |   |   |   |   |   |   | 1                    | A                 |
|                      |                | 65-7360-3136) (FOR BREAKDOWN SEE FIG. 57)   |   |   |   |   |   |   |                      |                   |
|                      | AN4-10A        | (ATTACHING PARTS)   |   |   |   |   |   |   |                      |                   |
|                      |                | BOLT (FOR REPLACEMENT ORDER BACB30NE4-9) . . . . .  |   |   |   |   |   |   | 16                   |                   |

CHANGED 28 MARCH 1969

2-123

C/N 15191A  
15192A



Section II  
Group Assembly Parts List

T.O. 1C-135A-4

| FIGURE &<br>INDEX NO. | PART NUMBER              | DESCRIPTION  | UNITS<br>PER<br>ASSY | USE<br>ON<br>CODE |
|-----------------------|--------------------------|--|----------------------|-------------------|
|                       |                          | 1 2 3 4 5 6 7  |                      |                   |
| 48 -                  | AN960D416<br>AN960PD416L | .. WASHER. ....<br>.. WASHER. ....   | 16<br>AR             |                   |
| 8                     | 5-88721-23               | .. PANEL ASSY, HONEYCOMB, INBOARD FLAP SKIN, LOWER ..<br>FORWARD OUTBOARD HALF (I/W 5-88721-15) (USE<br>5-88721-15 UNTIL EXHAUSTED) (LH ONLY)    | 1                    | F                 |
| 8                     | 5-88721-15               | .. PANEL ASSY, HONEYCOMB, INBOARD FLAP SKIN, LOWER ..<br>FORWARD OUTBOARD HALF (FOR I/W INFO SEE<br>5-88721-23) (ALTERNATE 5-88721-23) (LH ONLY) | 1                    | G                 |
|                       | 5-88721-24               | .. PANEL ASSY, HONEYCOMB, INBOARD FLAP SKIN, LOWER ..<br>FORWARD OUTBOARD HALF (I/W 5-88721-16) (USE<br>5-88721-16 UNTIL EXHAUSTED) (RH ONLY)    | 1                    | F                 |
|                       | 5-88721-16               | .. PANEL ASSY, HONEYCOMB, INBOARD FLAP SKIN, LOWER ..<br>FORWARD OUTBOARD HALF (FOR I/W INFO SEE<br>5-88721-24) (ALTERNATE 5-88721-24) (RH ONLY) | 1                    | G                 |
| 9                     | 5-88720-23               | .. PANEL ASSY, HONEYCOMB, INBOARD FLAP SKIN, LOWER ..<br>FORWARD INBOARD HALF (I/W 5-88720-15) (USE<br>5-88720-15 UNTIL EXHAUSTED) (LH ONLY)     | 1                    | F                 |
| 9                     | 5-88720-15               | .. PANEL ASSY, HONEYCOMB, INBOARD FLAP SKIN, LOWER ..<br>FORWARD INBOARD HALF (FOR I/W INFO SEE<br>5-88720-23) (ALTERNATE 5-88720-23) (LH ONLY)  | 1                    | G                 |
|                       | 5-88720-24               | .. PANEL ASSY, HONEYCOMB, INBOARD FLAP SKIN, LOWER ..<br>FORWARD INBOARD HALF (I/W 5-88720-16) (USE<br>5-88720-16 UNTIL EXHAUSTED) (RH ONLY)     | 1                    | F                 |
|                       | 5-88720-16               | .. PANEL ASSY, HONEYCOMB, INBOARD FLAP SKIN, LOWER ..<br>FORWARD INBOARD HALF (FOR I/W INFO SEE<br>5-88720-24) (ALTERNATE 5-88720-24) (RH ONLY)  | 1                    | G                 |
| 10                    | 50-4669-11               | .. PANEL ASSY, SKIN, HONEYCOMB, LOWER OUTBOARD HALF, ..<br>INBOARD FLAP (LH ONLY) (FOR REPLACEMENT ORDER<br>50-4669-3020)                        | 1                    | F                 |
| 10                    | 50-4669-1                | .. PANEL ASSY, SKIN, HONEYCOMB, LOWER OUTBOARD HALF, ..<br>INBOARD FLAP (ALTERED FROM 50-4669) (FOR<br>REPLACEMENT ORDER 50-4669-3020) (LH ONLY) | 1                    | G                 |
|                       | 50-4669-12               | .. PANEL ASSY, SKIN, HONEYCOMB, LOWER OUTBOARD HALF, ..<br>INBOARD FLAP (FOR REPLACEMENT ORDER 50-4669-3020)<br>(RH ONLY)                        | 1                    | F                 |
|                       | 50-4669-2                | .. PANEL ASSY, SKIN, HONEYCOMB, LOWER OUTBOARD HALF, ..<br>INBOARD FLAP (FOR REPLACEMENT ORDER 50-4669-3020)<br>(RH ONLY)                        | 1                    | G                 |
| 11                    | 50-4669-13               | .. PANEL ASSY, SKIN, HONEYCOMB, UPPER OUTBOARD HALF, ..<br>INBOARD FLAP (FOR REPLACEMENT ORDER 50-4669-3020)<br>(LH ONLY)                        | 1                    | F                 |
| 11                    | 50-4669-3                | .. PANEL ASSY, SKIN, HONEYCOMB, UPPER OUTBOARD HALF, ..<br>INBOARD FLAP (FOR REPLACEMENT ORDER 50-4669-3020)<br>(LH ONLY)                        | 1                    | G                 |
|                       | 50-4669-14               | .. PANEL ASSY, SKIN, HONEYCOMB, UPPER OUTBOARD HALF, ..<br>INBOARD FLAP (FOR REPLACEMENT ORDER 50-4669-3020)<br>(RH ONLY)                        | 1                    | F                 |
|                       | 50-4669-4                | .. PANEL ASSY, SKIN, HONEYCOMB, UPPER OUTBOARD HALF, ..<br>INBOARD FLAP (FOR REPLACEMENT ORDER 50-4669-3020)<br>(RH ONLY)                        | 1                    | G                 |
| 12                    | 50-4668-11               | .. PANEL ASSY, SKIN, HONEYCOMB, LOWER INBOARD HALF, ..<br>INBOARD FLAP (FOR REPLACEMENT ORDER 50-4668-3022)<br>(LH ONLY)                         | 1                    | F                 |
| 12                    | 50-4668-1                | .. PANEL ASSY, SKIN, HONEYCOMB, LOWER INBOARD HALF, ..<br>INBOARD FLAP (FOR REPLACEMENT ORDER 50-4668-3022)<br>(LH ONLY)                         | 1                    | G                 |
|                       | 50-4668-12               | .. PANEL ASSY, SKIN, HONEYCOMB, LOWER INBOARD HALF, ..<br>INBOARD FLAP (FOR REPLACEMENT ORDER 50-4668-3022)<br>(RH ONLY)                         | 1                    | F                 |
|                       | 50-4668-2                | .. PANEL ASSY, SKIN, HONEYCOMB, LOWER INBOARD HALF, ..<br>INBOARD FLAP (FOR REPLACEMENT ORDER 50-4668-3022)<br>(RH ONLY)                         | 1                    | G                 |
| 13                    | 50-4668-13               | .. PANEL ASSY, SKIN, HONEYCOMB, UPPER INBOARD HALF, ..<br>INBOARD FLAP (FOR REPLACEMENT ORDER 50-4668-3022)<br>(LH ONLY)                         | 1                    | F                 |
| 13                    | 50-4668-3                | .. PANEL ASSY, SKIN, HONEYCOMB, UPPER INBOARD HALF, ..<br>INBOARD FLAP (FOR REPLACEMENT ORDER 50-4668-3022)<br>(LH ONLY)                         | 1                    | G                 |
|                       | 50-4668-14               | .. PANEL ASSY, SKIN, HONEYCOMB, UPPER INBOARD HALF, ..<br>INBOARD FLAP (FOR REPLACEMENT ORDER 50-4668-3022)<br>(RH ONLY)                         | 1                    | F                 |

| FIGURE &<br>INDEX NO. | PART NUMBER | DESCRIPTION  | 1 2 3 4 5 6 7 |  |  |  |  |  | UNITS<br>PER<br>ASSY | USE<br>ON<br>CODE |
|-----------------------|-------------|--|---------------|--|--|--|--|--|----------------------|-------------------|
|                       |             |  |               |  |  |  |  |  |                      |                   |
| 48 -                  | 50-4668-4   | . . . PANEL ASSY, SKIN, HONEYCOMB, UPPER INBOARD HALF, . . .<br>INBOARD FLAP (FOR REPLACEMENT ORDER 50-4668-3022)<br>(RH ONLY)     |               |  |  |  |  |  | 1                    | G                 |
| 13A                   | 69-18412-1  | . . . DEPRESSOR ASSY, SEAL, INBOARD FLAP, WING STATION. .<br>287.63 (LH ONLY)  |               |  |  |  |  |  | 1                    | C                 |
|                       | 69-18412-2  | . . . DEPRESSOR ASSY, SEAL, INBOARD FLAP, WING STATION. .<br>287.63 (RH ONLY)  |               |  |  |  |  |  | 1                    | C                 |
| 13B                   | 69-18413-6  | . . . DEPRESSOR ASSY, SEAL, INBOARD FLAP, WING STATION. .<br>360.0 (SUITABLE SUB. FOR 69-18413-1)                                  |               |  |  |  |  |  | 1                    | F                 |
| 13B                   | 69-18413-1  | . . . DEPRESSOR ASSY, SEAL, INBOARD FLAP, WING STATION. .<br>360.0 (WHEN EXHAUSTED USE 69-18413-6)                                 |               |  |  |  |  |  | 1                    | H                 |
| 14                    | 69-18414-11 | . . . DEPRESSOR ASSY, SEAL, INBOARD FLAP, WING STATION. .<br>444.0 (SUITABLE SUB. FOR 69-18414-1) (LH ONLY)                        |               |  |  |  |  |  | 1                    | F                 |
| 14                    | 69-18414-1  | . . . DEPRESSOR ASSY, SEAL, INBOARD FLAP, WING STATION. .<br>444.0 (WHEN EXHAUSTED USE 69-18414-11)<br>(LH ONLY)                   |               |  |  |  |  |  | 1                    | H                 |
|                       | 69-18414-12 | . . . DEPRESSOR ASSY, SEAL, INBOARD FLAP, WING STATION. .<br>444.0 (SUITABLE SUB. FOR 69-18414-2) (RH ONLY)                        |               |  |  |  |  |  | 1                    | F                 |
|                       | 69-18414-2  | . . . DEPRESSOR ASSY, SEAL, INBOARD FLAP, WING STATION. .<br>444.0 (WHEN EXHAUSTED USE 69-18414-12)<br>(RH ONLY)                   |               |  |  |  |  |  | 1                    | H                 |
| 15                    | 69-9610-3   | . . . CAM ASSY, INBOARD FLAP, STATION 419.95 (LH ONLY). . .  |               |  |  |  |  |  | 1                    |                   |
|                       | 69-9610-4   | . . . CAM ASSY, INBOARD FLAP, STATION 419.95 (RH ONLY). . .  |               |  |  |  |  |  | 1                    |                   |
| 16                    | 69-9611-3   | . . . CAM ASSY, INBOARD FLAP, STATION 300.05 (LH ONLY). . .  |               |  |  |  |  |  | 1                    |                   |
|                       | 69-9611-4   | . . . CAM ASSY, INBOARD FLAP, STATION 300.05 (RH ONLY). . .  |               |  |  |  |  |  | 1                    |                   |
| 17                    | 5-86892-25  | . . . SKIN, OUTBOARD NOSE, INBOARD FLAP (LH ONLY). . .   |               |  |  |  |  |  | 1                    |                   |
|                       | 5-86892-26  | . . . SKIN, OUTBOARD NOSE, INBOARD FLAP (RH ONLY). . .   |               |  |  |  |  |  | 1                    |                   |
| 18                    | 5-86892-117 | . . . SKIN, CENTER NOSE, INBOARD FLAP (LH ONLY). . .   |               |  |  |  |  |  | 1                    |                   |
|                       | 5-86892-118 | . . . SKIN, CENTER NOSE, INBOARD FLAP (RH ONLY). . .   |               |  |  |  |  |  | 1                    |                   |
| 19                    | 5-86892-115 | . . . SKIN, INBOARD NOSE, INBOARD FLAP (LH ONLY). . .  |               |  |  |  |  |  | 1                    |                   |
|                       | 5-86892-116 | . . . SKIN, INBOARD NOSE, INBOARD FLAP (RH ONLY). . .  |               |  |  |  |  |  | 1                    |                   |
| 20                    | 5-86892-93  | . . . SKIN, INBOARD FORWARD NOSE, INBOARD FLAP (LH ONLY). .  |               |  |  |  |  |  | 1                    |                   |
|                       | 5-86892-94  | . . . SKIN, INBOARD FORWARD NOSE, INBOARD FLAP (RH ONLY). .  |               |  |  |  |  |  | 1                    |                   |
| 21                    | 5-86894-235 | . . . RIB INSTL, INBOARD ACTUATOR AND TRACK, INBOARD FLAP .<br>(LH ONLY) (FOR BREAKDOWN SEE FIG. 50)                               |               |  |  |  |  |  | 1                    |                   |
|                       | 5-86894-236 | . . . RIB INSTL, INBOARD ACTUATOR AND TRACK, INBOARD FLAP .<br>(RH ONLY) (FOR BREAKDOWN SEE FIG. 50)                               |               |  |  |  |  |  | 1                    |                   |
|                       | 5-86896-75  | . . . RIB INSTL, CENTER TRACK, INBOARD FLAP (LH ONLY). . .   |               |  |  |  |  |  | 1                    |                   |
|                       | 5-86896-76  | . . . RIB INSTL, CENTER TRACK, INBOARD FLAP (RH ONLY). . .   |               |  |  |  |  |  | 1                    |                   |
| 22                    | 5-87846-1   | . . . CARRIAGE ASSY, CENTER, INBOARD FLAP (FOR. . . . .<br>BREAKDOWN SEE FIG. 52)<br>(ATTACHING PARTS)                             |               |  |  |  |  |  | 1                    |                   |
| 23                    | NAS1103-6W  | . . . BOLT (FOR REPLACEMENT ORDER NAS1103-6). . . . .  |               |  |  |  |  |  | 2                    |                   |
| 24                    | NAS1105-9W  | . . . BOLT (FOR REPLACEMENT ORDER NAS1105-9). . . . .  |               |  |  |  |  |  | 2                    |                   |
| 25                    | NAS1104-7W  | . . . BOLT (FOR REPLACEMENT ORDER NAS1104-7). . . . .  |               |  |  |  |  |  | 36                   |                   |
| 26                    | NAS1104-8W  | . . . BOLT (FOR REPLACEMENT ORDER NAS1104-8). . . . .  |               |  |  |  |  |  | 4                    |                   |
| 27                    | NAS1105-9W  | . . . BOLT (FOR REPLACEMENT ORDER NAS1105-9). . . . .  |               |  |  |  |  |  | 2                    |                   |
| 28                    | NAS517-4-7  | . . . SCREW (FOR REPLACEMENT ORDER BACB30LU4-7). . . . .   |               |  |  |  |  |  | 6                    |                   |
| 29                    | AN960D10    | . . . WASHER. . . . .  |               |  |  |  |  |  | 2                    |                   |
| 30                    | AN960D516   | . . . WASHER. . . . .  |               |  |  |  |  |  | 2                    |                   |
| 31                    | AN960D416   | . . . WASHER. . . . .  |               |  |  |  |  |  | 46                   |                   |
| 32                    | AN960D516   | . . . WASHER. . . . .  |               |  |  |  |  |  | 2                    |                   |
| 33                    | NAS679A3W   | . . . NUT (FOR REPLACEMENT ORDER 96-02 (56878) (80539). .<br>H10-3BAC (15653) T6S1032J (71087) RMLH9075-3W<br>(72962) (BACN10JC3)) |               |  |  |  |  |  | 2                    |                   |
| 34                    | MS21042L5   | . . . NUT (REPLACES NAS679A5 OR 96-054 (56878) (80539). .<br>H10-5BAC (15653) T6S524J (71087) RMLH9075-5W<br>(72962) (BACN100C5))  |               |  |  |  |  |  | 2                    |                   |
| 35                    | NAS679A3W   | . . . NUT (FOR REPLACEMENT ORDER 96-048 (56878) (80539) .<br>H10-4BAC (15653) T6S428J (71087) RMLH9075-4W<br>(72962) (BACN10JC4))  |               |  |  |  |  |  | 46                   |                   |
| 36                    | MS21042L5   | . . . NUT (REPLACES NAS679A5 OR 96-054 (56878) (80539). .<br>H10-5BAC (15653) T6S524J (71087) RMLH9075-5W<br>(72962) (BACN10JC5))  |               |  |  |  |  |  | 2                    |                   |
|                       | 5-88108-165 | . . . RIB INSTL, OUTBOARD ACTUATOR, INBOARD FLAP (LH ONLY).  |               |  |  |  |  |  | 1                    |                   |
|                       | 5-88108-166 | . . . RIB INSTL, OUTBOARD ACTUATOR, INBOARD FLAP (RH ONLY).  |               |  |  |  |  |  | 1                    |                   |
|                       | 9-61951-9   | . . . FITTING ASSY, SCREW SUPPORT, FLAP . . . . .  |               |  |  |  |  |  | 1                    |                   |
| 37                    | NAS516-1    | . . . . . FITTING . . . . .  |               |  |  |  |  |  | 2                    |                   |
| 38                    | AN4-10A     | . . . . . BOLT (FOR REPLACEMENT ORDER BACB30NE4-9). . . . .  |               |  |  |  |  |  | 2                    |                   |

Section II  
Group Assembly Parts List

T.O. 1C-135A-4

| FIGURE &<br>INDEX NO. | PART NUMBER | DESCRIPTION   | UNITS<br>PER<br>ASSY | USE<br>ON<br>CODE |
|-----------------------|-------------|---|----------------------|-------------------|
|                       |             | 1 2 3 4 5 6 7   |                      |                   |
| 48 -                  |             |   |                      |                   |
| 39                    | 63-1519     | . . . . NUTPLATE ASSY, CONVEX, WING FLAPS . . . . .           | 2                    |                   |
| 40                    | 3-98762     | . . . . BEARING, SCREW SUPPORT, FLAP. . . . .                 | 2                    |                   |
| 41                    | 9-61951-11  | . . . . FITTING, SCREW SUPPORT, FLAP. . . . .                 | 1                    |                   |
|                       | 5-87849-81  | . . . RIB INSTL, OUTBOARD TRACK, INBOARD FLAP (LH ONLY) . . . | 1                    |                   |
|                       | 5-87849-82  | . . . RIB INSTL, OUTBOARD TRACK, INBOARD FLAP (RH ONLY) . . . | 1                    |                   |
| 42                    | 5-87847-3   | . . . CARRIAGE ASSY, END, INBOARD FLAP (LH ONLY) (FOR . . .   | 1                    |                   |
|                       |             | BREAKDOWN SEE FIG. 49)  |                      |                   |
|                       | 5-87847-4   | . . . CARRIAGE ASSY, END, INBOARD FLAP (RH ONLY) (FOR . . .   | 1                    |                   |
|                       |             | BREAKDOWN SEE FIG. 49)  |                      |                   |
|                       |             | (ATTACHING PARTS)   |                      |                   |
| 43                    | NAS1104-6W  | . . . BOLT (FOR REPLACEMENT ORDER NAS1104-6). . . . .         | 29                   |                   |
| 44                    | NAS1104-7W  | . . . BOLT (FOR REPLACEMENT ORDER NAS1104-7). . . . .         | 3                    |                   |
| 45                    | NAS1104-8W  | . . . BOLT (FOR REPLACEMENT ORDER NAS1104-8). . . . .         | 3                    |                   |
| 46                    | NAS1104-9W  | . . . BOLT (FOR REPLACEMENT ORDER NAS1104-9). . . . .         | 3                    |                   |
| 47                    | NAS517-4-6  | . . . SCREW (FOR REPLACEMENT ORDER BACB30LU4-6). . . . .      | 3                    |                   |
| 48                    | NAS517-4-7  | . . . SCREW (FOR REPLACEMENT ORDER BACB30LU4-7). . . . .      | 3                    |                   |
| 49                    | AN960D416   | . . . WASHER. . . . .   | 44                   |                   |
| 50                    | NAS679A4W   | . . . NUT (FOR REPLACEMENT ORDER 96-048 (56878) (80539) . . . | 44                   |                   |
|                       |             | H10-4BAC (15653) T6S428J (71087) RMLH9075-4W                  |                      |                   |
|                       |             | (72962) (BACN10JC4))  |                      |                   |
| 51                    | 5-86892-65  | . . SEAL, MOHAIR, INBOARD FLAP (MAKE FROM 5680. . . . .       | 1                    | D                 |
|                       |             | BAC1523-20N X 13.3 IN. LG) (FOR I/W INFO SEE                  |                      |                   |
|                       |             | 5-86892-133)  |                      |                   |
| 51                    | 5-86892-133 | . . SEAL, MOHAIR, INBOARD FLAP (MAKE FROM 5680. . . . .       | 1                    | E                 |
|                       |             | BAC1523-20N X 13.3 IN. LG) (I/W 5-86892-65)                   |                      |                   |
|                       |             | (USE 5-86892-65 UNTIL EXHAUSTED)                              |                      |                   |
| 51                    | 5-86892-66  | . . SEAL, MOHAIR, INBOARD FLAP (MAKE FROM 5680. . . . .       | 1                    | D                 |
|                       |             | BAC1523-20N X 48.9 IN. LG) (FOR I/W INFO SEE                  |                      |                   |
|                       |             | 5-86892-134)  |                      |                   |
| 52                    | 5-86892-134 | . . SEAL, MOHAIR, INBOARD FLAP (MAKE FROM 5680. . . . .       | 1                    | E                 |
|                       |             | BAC1523-20N X 48.9 IN. LG) (I/W 5-86892-66                    |                      |                   |
|                       |             | (USE 5-86892-66 UNTIL EXHAUSTED)                              |                      |                   |
|                       | 50-4681-85  | . . TRAILING EDGE INSTL, INBOARD FLAP (LH ONLY) . . . . .     | 1                    |                   |
|                       | 50-4681-86  | . . TRAILING EDGE INSTL, INBOARD FLAP (RH ONLY) . . . . .     | 1                    |                   |
| 53                    | 50-4681-87  | . . . TRAILING EDGE ASSY, INBOARD FLAP (LH ONLY). . . . .     | 1                    |                   |
|                       | 50-4681-88  | . . . TRAILING EDGE ASSY, INBOARD FLAP (RH ONLY). . . . .     | 1                    |                   |
|                       |             | (ATTACHING PARTS)   |                      |                   |
|                       | NAS517-3-4  | . . . SCREW (FOR REPLACEMENT ORDER BACB30LU3-4). . . . .      | 93                   |                   |
|                       | NAS517-3-5  | . . . SCREW (FOR REPLACEMENT ORDER BACB30LU3-5). . . . .      | 2                    |                   |
|                       |             | (ATTACHING PARTS)   |                      |                   |
|                       | 4-5211-15   | . . PANEL INSTL, SKIN, INBOARD FLAP (LH ONLY) . . . . .       | 1                    |                   |
|                       | 4-5211-16   | . . PANEL INSTL, SKIN, INBOARD FLAP (RH ONLY) . . . . .       | 1                    |                   |
| 54                    | 50-6038-29  | . . . TRAILING EDGE ASSY, INBOARD FLAP. . . . .               | 1                    |                   |
|                       |             | A 2201 THRU 2299, 3001 THRU 3099                              |                      |                   |
|                       |             | B DELETED   |                      |                   |
|                       |             | C 2201 THRU 2299, 3029 THRU 3099                              |                      |                   |
|                       |             | D 3001  |                      |                   |
|                       |             | E 2201 THRU 2299, 3002 THRU 3099                              |                      |                   |
|                       |             | F 2201 THRU 2299  |                      |                   |
|                       |             | G 3001 THRU 3099  |                      |                   |
|                       |             | H 3029 THRU 3099  |                      |                   |

# FLOW PROCESS CHART

SUBJECT WING FLAP, INBOARD

DATE 4/4/89

PCN: 15192A

WCD: 15151A

WCD DATE: 88055

15191A

CHART BEGINS

1 of 2

CHART ENDS

PREPARED BY: LARRY

New  
Start on WCD

HISTORY RECORDS  
40/50

60

70

80

NO CHANGE  
in WCD SEQ.

| SYMBOLS     | DESCRIPTION  | SYMBOLS     | DESCRIPTION                                     |
|-------------|--|-------------|---|
| 180 ● ◊ ▢ ▽ | Receive Uncrate<br>2122 MBPCD                            | 180 ● ◊ ▢ ▽ | REPLACE<br>LEADING EDGE RIB WRP                 |
| 190 ○ ◊ ▢ ▽ | Delay  | 190 ● ◊ ▢ ▽ | REPLACE LEADING EDGE<br>ANGLES, CLIPS & CHANNEL |
| 200 ○ ◊ ▢ ▽ | 95 MBPAB<br>Move To 225                                  | 200 ● ◊ ▢ ▽ | REPLACE LEADING EDGE ASSY<br>SKIN               |
| 210 ○ ◊ ▢ ▽ | Delay  | 210 ● ◊ ▢ ▽ | REMOVE NOSE SKIN                                |
| 220 ● ◊ ▢ ▽ | Remove Fure Flaps<br>95 MBPAB                            | 220 ● ◊ ▢ ▽ | INSTALL LOWER INBOARD<br>SKIN                   |
| 230 ● ◊ ▢ ▽ | Remove Honeycomb<br>Panels / DELAY<br>Move To 2122 MBPAB | 230 ● ◊ ▢ ▽ | CLOSEOUT UPPER INBOARD SKIN                     |
| 240 ○ ◊ ▢ ▽ | Delay  | 240 ● ◊ ▢ ▽ | CLOSEOUT UPPER OUTBOARD<br>SKIN                 |
| 250 ● ◊ ▢ ▽ | Plug Drain Holes   | 250 ● ◊ ▢ ▽ | REPLACE WORN CARTRIDGE<br>ASSY                  |
| 260 ● ◊ ▢ ▽ | Clean + Stamp<br>Wash<br>Delay Move To 95                | 260 ● ◊ ▢ ▽ | REPLACE CRACKED OR DAMAGED<br>FAIRINGS          |
| 270 ○ ◊ ▢ ▽ | Delay  | 270 ● ◊ ▢ ▽ | OPEN FASTENER HOLES                             |
| 280 ○ ◊ ▢ ▽ | Delay  | 280 ● ◊ ▢ ▽ | INSTALL LOWER SKIN<br>PANEL                     |
| 290 ○ ◊ ▢ ▽ | Delay  | 290 ● ◊ ▢ ▽ | INSTALL LOWER HONEYCOMB<br>PANEL                |
| 300 ○ ◊ ▢ ▽ | Delay  | 300 ● ◊ ▢ ▽ | INSTALL INNER HONEYCOMB<br>PANEL                |
| 310 ○ ◊ ▢ ▽ | Delay  | 310 ● ◊ ▢ ▽ | INSTALL WING FLAP IN<br>REPAIR JIG 590CA1020    |
| 320 ○ ◊ ▢ ▽ | Delay  | 320 ○ ◊ ▢ ▽ | INSPECT CONDITION &<br>ALIGNMENT                |
| 330 ○ ◊ ▢ ▽ | Delay  | 330 ● ◊ ▢ ▽ | REMOVE FLAP FROM JIG                            |
| 340 ○ ◊ ▢ ▽ | Accomplish SHAKEDOWN<br>95 MBPAB                         | 340 ● ◊ ▢ ▽ | REPLACE ALL BAD FASTENERS                       |
| 350 ○ ◊ ▢ ▽ | Delay  | 350 ● ◊ ▢ ▽ | REMOVE DRILL HOLES                              |
| 360 ○ ◊ ▢ ▽ | Accomplish NDI<br>95 MBPAB                               | 360 ● ◊ ▢ ▽ | REPAIR GROOVES IN<br>CARTRIDGE                  |
| 370 ○ ◊ ▢ ▽ | Delay  | 370 ● ◊ ▢ ▽ | SEAL FLAP                                       |
| 380 ○ ◊ ▢ ▽ | Begin Repair (ALIGNMENT CHECK)<br>95 MBPAB               | 380 ● ◊ ▢ ▽ | TREAT EXTERNAL CORROSION                        |
| 390 ○ ◊ ▢ ▽ | Repair/Replace Honeycomb<br>PANEL                        | 390 ○ ◊ ▢ ▽ | Delay   |
| 400 ○ ◊ ▢ ▽ | REP/REP " (-29) TRAILING<br>EDGE                         | 400 ○ ◊ ▢ ▽ | MOVE To 2280                                    |
| 410 ○ ◊ ▢ ▽ | REP/REP " (-88)<br>TRAILING EDGE                         | 410 ○ ◊ ▢ ▽ | Delay   |
| 420 ○ ◊ ▢ ▽ | REP/REP " (-88)<br>TRAILING EDGE                         | 420 ○ ◊ ▢ ▽ | FINAL WASH (PAINT)<br>2280 MBPAB                |
| 430 ○ ◊ ▢ ▽ | REP/REP " (-88)<br>TRAILING EDGE                         | 430 ○ ◊ ▢ ▽ | Delay   |
| 440 ○ ◊ ▢ ▽ | REP/REP " (-88)<br>TRAILING EDGE                         | 440 ○ ◊ ▢ ▽ | MOVE  |
| 450 ○ ◊ ▢ ▽ | REP/REP " (-88)<br>TRAILING EDGE                         | 450 ○ ◊ ▢ ▽ | Delay   |
| 460 ○ ◊ ▢ ▽ | REP/REP " (-88)<br>TRAILING EDGE                         | 460 ○ ◊ ▢ ▽ | REPLACE BEARINGS (SOURCE)                       |

### FLOW PROCESS CHART

**SUBJECT**

DATE 4/4/89

PCN: 15191A  
15192A

WCD: 15/51A

WCDDATE: 88055

## CHART BEGINS

PREPARED BY: Laney

**CHART ENDS**

| SYMBOLS |  | DESCRIPTION            | SYMBOLS |  | DESCRIPTION |
|---------|--|------------------------|---------|--|-------------|
| 420     |  | REPLACE FOREFLAP       |         |  |             |
| 430     |  | INSTALL FOREFLAP       |         |  |             |
| 440     |  | REPLACE WORN SEALS     |         |  |             |
| 450     |  | IDENTIFY CONDITION TAG |         |  |             |
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2. ORIG/PROD NR 13. QUANTITY 14. PROD SECTION/RCC 15. DATE SCHED 16. DATE COMP  
MABPAB 39093

7. PART NUMBER 19. ITEM SERIAL NR 18/12. TECH DATA/OPTIONAL  
S.O.W. UC-1560FL/82-67  
10. MODEL/DESIGN/SERIES 11. STOCK NR S.O.W. OL-1560FL/83-149  
C 135 1C-135(K)A-3-4

15. MISC 16. HOUN/END ITEM HOUN  
WING FLAP, INBOARD  
MICHAEL TYTANIC/MABERS/65261

NSN C/N  
5 86892 119 15600060674/11L 15151A  
5 86892 121 15600060674/11L 15151A  
5 86892 123 15600060674/11L 15151A  
5 86892 120 15600060674/11L 15152A  
5 86892 112 1560006210781FL 15153A  
5 86892 127 1560006566065FL 15184A  
5 86892 128 1560006566066FL 15185A  
5 86892 130 1560006566201FL 15192A  
5 86892 129 1560006566200FL 15191A  
5 86892 131 1560006566202FL 15193A  
5 86892 132 1560006566203FL 15194A  
5 86892 136 1560009675260FL 15287A

15. DISP-16. PDM/STAT/STATION NO. 17. WORK TO BE ACCOMPLISHED 18. MECH 19. P 20. Q  
2122 010 RECEIVE AND UNCRATE. 1 NC / /  
MBPCD REQ'D NOT REQ'D  
2122 020 CLEAN & STRIP PAINT FROM FLAP 4 4W / /  
MBPCA (INCLUDING FLAP TRACK WELL) IAW  
NOTE: ON PDM LINE GENERATED FLAP  
CLEAN FLAP TRACK WELL & CARRIAGE  
ASSYS. ASSURE ENTIRE ASSY IS FREE  
OF ALL DIRTY PAINT & GREASE.  
2122 030 PLUG ALL DRAIN HOLES TO PREVENT 4W / /  
MBPCA PAINT STRIPPER FROM ENTERING INTO  
INTERIOR OF ASSY.  
NOTE: OMIT IF PDM LINE GENERATED  
FLAP.  
2122 040 REMOVE FOREFLAPS & ASSURE FOREFLAP 2 DS / /  
95 MBPAB SUPPLEMENTAL SHEET WILL ACCOMPANY  
APPROPRIATE ITEM.  
2122 050 REMOVE 2 EA UPPER 3 EA LOWER 3 DS / /  
95 MBPAB HONEYCOMB PANELS FOR ACCESS.  
2122 060 ACCOMPLISH INTERIOR WASH, UPPER & 5 4W / /  
MBPCA LOWER, FOR CORROSION & CRACKS  
DETERMINATION. MOVE TO MABERS  
REQ'D NOT REQ'D  
2122 070 ACCOMPLISH COMPLETE SHAKEDOWN INSP 6 DS / /  
95 MBPAB OF FLAP IAW SOW, ANNOTATE DISCREP-  
ANCIES. MOVE TO OLD 3001.

(CONTINUED)

|    |              |  |    |   |   |
|----|--------------|--|----|---|---|
|    |              | NOTE: THE ITEM(S) INPUT ON THIS 959<br>WILL BE OVERHAULED IN ACCORDANCE<br>WITH INSTRUCTIONS CONTAINED IN THE<br>SOW AND THE TECH ORDERS & DIRECTIONS<br>CONTAINED IN SECT 10 & TAB "A" OF<br>THE SOW. |    |   |   |
| 95 | 080<br>MBPAB | INSP DRAIN HOLES IN FLAP CARRIAGES<br>FOR CRACKS WITH EDDY CURRENT.<br>"N" STAMP RECD IAW 1C-135-36, SEC V,<br>PART 2.   | AI | / |   |
| 95 | 090<br>MBPAB | ACCOMPLISH ALIGNMENT CHECK IAW<br>(I.E.).<br>RECD _____ NOT RECD _____   | DS | / |   |
| 95 | 100<br>MBPAB | REPAIR/REPLACE UPPER HONEYCOMB PANEL<br>IAW 1C-135(K)A-3-1, SEC X<br>RECD _____ NOT RECD _____   | DS | / |   |
| 95 | 110<br>MBPAB | REPAIR/REPLACE DAMAGED (-29) SMALL<br>TRAILING EDGE IAW 1C-135(K)A-3-1<br>RECD _____ NOT RECD _____  | DS | / | / |
|    |              | NOTE: HONEYCOMB TRAILING EDGE MAY<br>REQUIRE TRIMMING.<br>CAUTION: GAP BETWEEN HONEYCOMB<br>PANELS & TRAILING EDGE MUST<br>BE MAINTAINED AS SHOWN IN<br>T.O. 1C-135(K)A-3-1. FIG 10-6.                 |    |   |   |
| 95 | 120<br>MBPAB | REPAIR/REPLACE (-87 OR 88) LARGE<br>TRAILING EDOL IAW 1C-135(K)A-3-1.<br>RECD _____ NOT RECD _____   | DS | / | / |
| 95 | 130<br>MBPAB | REPAIR /REPLACE INBOARD SKINS<br>RECD _____ NOT RECD _____   | DS | / | / |
| 95 | 140<br>MBPAB | REPAIR/REPLACE INBOARD RIB AND<br>LONGERON<br>RECD _____ NOT RECD _____  | DS | / | / |
| 95 | 150<br>MBPAB | REPAIR/REPLACE OUTBOARD RIB AND<br>LONGERON<br>RECD _____ NOT RECD _____   | DS | / | / |
| 95 | 160<br>MBPAB | REPAIR/REPLACE LOWER HONEYCOMB<br>PANELS IAW 1C-135(K)A-3-1, SEC X<br>RECD _____ NOT RECD _____  | DS | / | / |
| 95 | 170<br>MBPAB | REPLACE CRACKED TRAILING EDGE RIBS<br>RECD _____ NOT RECD _____  | DS | / | / |
| 95 | 180<br>MBPAB | REPLACE CRACKED/DAMAGED LEADING EDGE<br>RIBS & WEBS<br>RECD _____ NOT RECD _____<br>NOTE: END ITEM WILL HAVE OC-ALC<br>FORM 586, 587, 588 IDENTIFICATION   | DS | / | / |

(CONTINUED)

|  |       |                                      |  |  |    |   |   |  |  |
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| *****  |       |                                      |  |  |    |   |   |  |  |
| 15151A * WORK CONTROL DOCUMENT - MISTR 1. DATE 00055 PAGE 3 OF 5 PAGES |       |                                      |  |  |    |   |   |  |  |
| 15.DISP-16.PDN/  |       |                                      |  |  |    |   |   |  |  |
| STATION/ID NO. 17.WORK TO BE ACCOMPLISHED 18.MLCH 19"P" 20"Q"          |       |                                      |  |  |    |   |   |  |  |
|  |       | LABELS APPLIED TO COMPLETED ITEM 1AW |  |  |    |   |   |  |  |
|  |       | AFLCR 66-51, CHAPTER 1.              |  |  |    |   |   |  |  |
|  |       | NOTE: ACCEPTANCE DATE ON THE LABEL   |  |  |    |   |   |  |  |
|  |       | WITH "M" STAMP FOR THE PERSON        |  |  |    |   |   |  |  |
|  |       | PERFORMING THE OVERHAUL IS REQD.     |  |  |    |   |   |  |  |
|  |       | CAUTION: SURFACE TO WHICH LABELS     |  |  |    |   |   |  |  |
|  |       | ARE APPLIED MUST BE FREE OF          |  |  |    |   |   |  |  |
|  |       | CONTAMINATION.                       |  |  |    |   |   |  |  |
| 95   | 190   | REPLACE CRACKED DAMAGED LEADING EDGE |  |  | DS | / | / |  |  |
|  | MBPAB | ANGLES CLIPS & CHANNELS.             |  |  |    |   |   |  |  |
|  |       | REQD _____ NOT REQD _____            |  |  |    |   |   |  |  |
| 95   | 200   | REPLACE CRACKED OR DAMAGED LEADING   |  |  | DS | / | / |  |  |
|  | MBPAB | EDGE NOSE TRIM REPLACE MAGNETICUM    |  |  |    |   |   |  |  |
|  |       | WITH REPAIRING.                      |  |  |    |   |   |  |  |
|  |       | REQD _____ NOT REQD _____            |  |  |    |   |   |  |  |
| 95   | 210   | REMOVL NOSE SKINS IF CRACKS ARE      |  |  | DS | / | / |  |  |
|  | MBPAB | FOUND IN END RIBS.                   |  |  |    |   |   |  |  |
|  |       | REQD _____ NOT REQD _____            |  |  |    |   |   |  |  |
| 95   | 220   | INSTALL LOWER INBOARD SKIN           |  |  | DS | / | / |  |  |
|  | MBPAB | REQD _____ NOT REQD _____            |  |  |    |   |   |  |  |
| 95   | 230   | ACCOMPLISH CLOSEOUT & INSTALL UPPER  |  |  | DS | / | / |  |  |
|  | MBPAB | INBOARD SKIN WHICH INCLUDES INTERNAL |  |  |    |   |   |  |  |
|  |       | CORROSION TREATMENT & REPLACEMENT    |  |  |    |   |   |  |  |
|  |       | OF IMPAIRED FASTENERS.               |  |  |    |   |   |  |  |
| 95   | 240   | ACCOMPLISH CLOSEOUT & INSTALL UPPER  |  |  | DS | / | / |  |  |
|  | MBPAB | OUTBOARD HONEYCOMB PANEL WHICH       |  |  |    |   |   |  |  |
|  |       | INCLUDES INTERNAL CORROSION          |  |  |    |   |   |  |  |
|  |       | TREATMENT & REPLACEMENT OF IMPAIRED  |  |  |    |   |   |  |  |
|  |       | FASTENERS.                           |  |  |    |   |   |  |  |
| 95   | 250   | REPLACE CRACKED OR WORN FLAP         |  |  | DS | / | / |  |  |
|  | MBPAB | CARRIAGES. INSURE FLAP IS IN         |  |  |    |   |   |  |  |
|  |       | FIXTURE PRIOR TO FINAL ATTACHMENT.   |  |  |    |   |   |  |  |
|  |       | REQD _____ NOT REQD _____            |  |  |    |   |   |  |  |
| 95   | 260   | REPLACE CRACKED OR DAMAGED FAIRINGS. |  |  | DS | / | / |  |  |
|  | MBPAB | REQD _____ NOT REQD _____            |  |  |    |   |   |  |  |
| 95   | 270   | REMOVE SEAL DEPRESSOR & OPEN         |  |  | DS | / | / |  |  |
|  | MBPAB | FASTENER HOLES.                      |  |  |    |   |   |  |  |
|  |       | REQD _____ NOT REQD _____            |  |  |    |   |   |  |  |
| 95   | 280   | ACCOMPLISH CLOSEOUT & INSTALL LOWER  |  |  | DS | / | / |  |  |
|  | MBPAB | IBOARD SKIN PANEL, INCLUDES          |  |  |    |   |   |  |  |
|  |       | INTERNAL CORROSION TREATMENT &       |  |  |    |   |   |  |  |
|  |       | REPLACEMENT OF IMPAIRED FASTENERS.   |  |  |    |   |   |  |  |
| 95   | 290   | ACCOMPLISH CLOSEOUT & INSTALL LOWER  |  |  | DS | / | / |  |  |
|  | MBPAB | CENTER HONEYCOMB PANEL, INCLUDES     |  |  |    |   |   |  |  |
|  |       | CORROSION TREATMENT & REPLACEMENT OF |  |  |    |   |   |  |  |
|  |       | IMPAIRED FASTENERS.                  |  |  |    |   |   |  |  |



15151A \* WORK CONTROL DOCUMENT \* NISIR 1 DATE 88055 PAGE 4 OF 6 PAGES  
 15.DISP 16.PDN/  
 STATION/OP NO. 17.WORK TO BE ACCOMPLISHED 18.MECH 19"P" 20"Q"

|    |              |   |    |   |   |
|----|--------------|---|----|---|---|
| 95 | 300<br>MBPAB | ACCOMPLISH CLOSEOUT & INSTALL<br>OUTBOARD HONEYCOMB PANEL, INCLUDES<br>INTERNAL CORROSION TREATMENT &<br>REPLACEMENT OF IMPAIRED FASTENERS.   | DS | / | / |
| 95 | 310<br>MBPAB | INSTALL WING FLAP IN REPAIR JIG<br>P/N 5900A1020.   | DS | / | / |
| 95 | 320<br>MBPAB | ACCOMPLISH INSP & ALIGNMENT CHECK<br>PRIOR TO REMOVAL FROM REPAIR JIG   | DS | / | / |
| 95 | 330<br>MBPAB | REMOVE FLAP FROM REPAIR JIG.  | DS | / | / |
| 95 | 340<br>MBPAB | REPLACE ALL LOOSE, SHARED OR<br>MISSING FASTENERS PERMANENTLY.<br>REQD _____ NOT REQD _____   | DS | / | / |
| 95 | 350<br>MBPAB | IF NO CRACKS ARE FOUND IN CARRIAGE<br>REWORK DRAIN HOLES IAW FIGS 1, 2 & 3<br>OF SOW.<br>REQD _____ NOT REQD _____  | DS | / | / |
| 95 | 360<br>MBPAB | REPAIR GROOVE IN CARRIAGE CAUSED<br>BY LATCHES & ROLLERS IAW<br>IC-135(K)A 3-3, FIG 2-23.<br>REQD _____ NOT REQD _____  | DS | E | / |
| 95 | 370<br>MBPAB | FILL ALL SKIN, TRAILING EDGE & SKIN<br>PANEL ACCESS COVER GAPS WITH<br>ENVIRONMENTAL SEALANT.   | DS | / | / |
| 95 | 380<br>MBPAB | CLEAN/TREAT EXTERNAL CORROSION IAW<br>IC-135(K)A-3-4, PAGE 4-13 TO 4-22.<br>REQD _____ NOT REQD _____<br>MOVE TO MBPCB, BLDG 2280<br>NOTE: OMIT IF DM LINE GENERATED<br>FLAP.<br>NOTE: NON-STOCKLISTED PARTS & PARTS<br>STOCKLISTED AS FIELD OR DEPT W/O<br>CAPABLE.<br>NOTE: OVERHAUL OF FLAP ASSY SHALL<br>BE ACCOMPLISHED IN 500 5-3-11 &<br>JIG 5900A1020 TO INSURE CORRECT<br>DIMENSIONS & ALIGNMENT. REMOVAL OF<br>MORE THAN TWO PANELS AT ONE TIME<br>WILL REQUIRE THE FLAP TO BE PLACED<br>IN FIXTURE 5900J1020.<br>NOTE: USE SKINS & PANELS REMOVED AS<br>TEMPLATES TO DETERMINE SIZE,<br>LOCATION & SPACING OF RIVET HOLES.<br>NOTE: REPLACEMENT HONEYCOMB PANELS<br>THAT REQUIRE LEAK RIMMING WILL HAVE<br>THOSE EDGES REMOVED PRIOR TO<br>INSTALLATION W/ JIG 31733.<br>LOWER PANELS WILL REQUIRE DRAIN<br>HOLES WILL HAVE L HOLES OF THE<br>HOLES SEALED BEFORE CAREFUL NOT TO | DS | / | / |

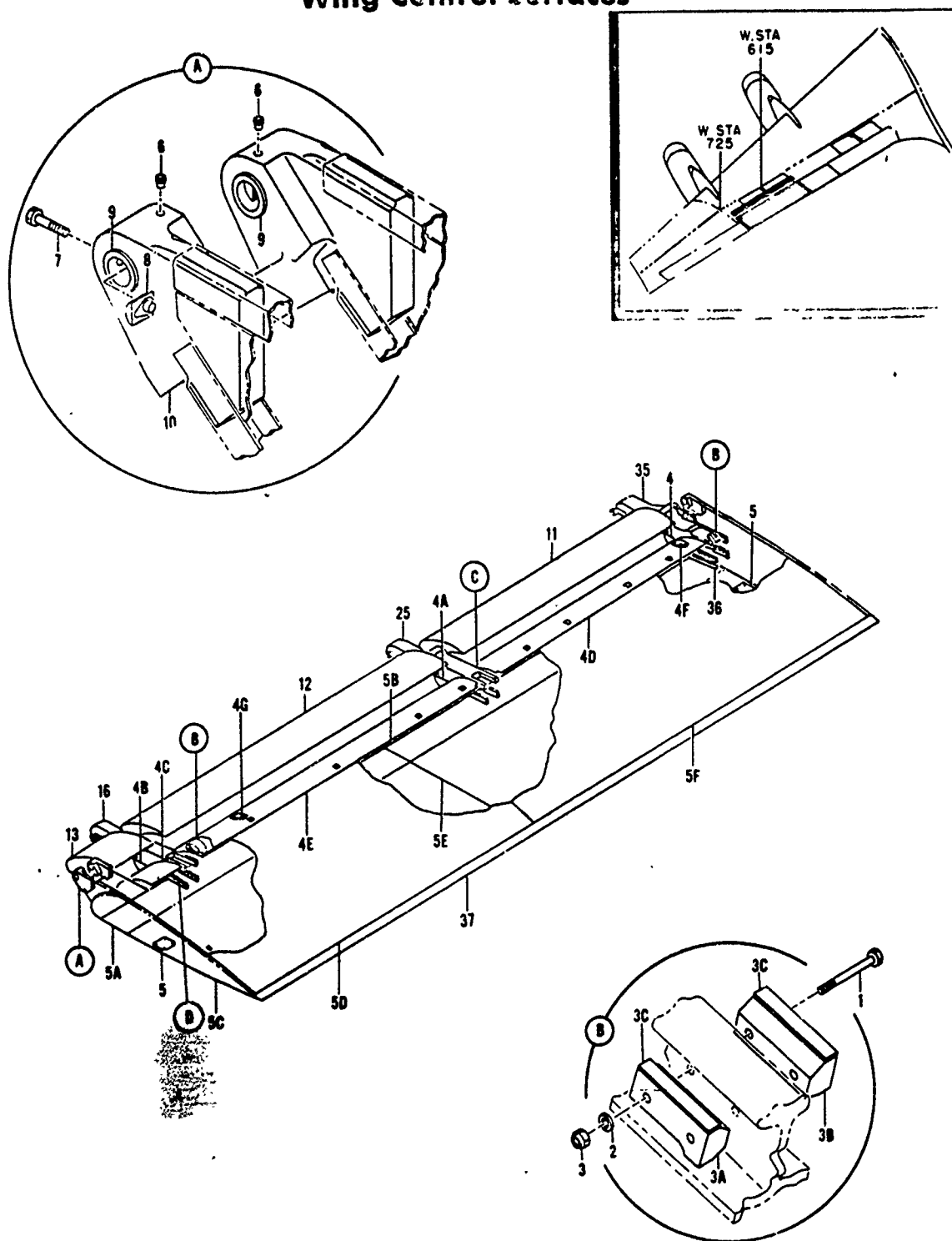
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| 15151A * WORK CONTROL DOCUMENT * AIRCRAFT 1. DATE 80055 PAUL 5.01 6 PAGES |       |   |    |   |   |
| 15.DISP-16.PDN/   |       |   |    |   |   |
| STATION/OP NO. 117.WORK TO BE ACCOMPLISHED 118.ALCH119"120"0"             |       |   |    |   |   |
|   |       | LET EXCESS SEALER CREATE A DAMMING EFFECT. ALL FASTENERS WILL BE INSTALLED WET USING MIL S 81734, (MIL S-8802 OR EPOXY PAINT MIL P-2377 MAY BE USED AS AN OPTION)   |    |   |   |
| 2280  | 390   | FINAL WASH & CORROSION TREATMENT  | DS | / | / |
| PAINT   | MBPAB | NOTE: OMIT IF PDM LINE GENERATED FLAP.  |    |   |   |
| 2280  | 400   | PAINT FLAP IAW 1C-135(K)A-3-1, 1C-135(K)A-3-4 & 1-1-4 & 1-18 USING MIL-P-87112 POLYSULFIDE PRIMER & HIGH GLOSS GRY ALL C-83286, COLOR 1647 PAINT, MARKINGS TO BE INSTALLED IAW DWG 5-86892.   | DS | / | / |
|   | MBPAB | NOTE: OMIT IF PDM LINE GENERATED FLAP.  |    |   |   |
|   |       | MOVE TO MBPAB, BLDG 95  |    |   |   |
| 95  | 410   | REPLACE ALL FLAP ATTACH, BEARING SUPPORTS & SERVICE (CLEAN/GREASE) & REPLACE BEARING.   | DS | / | / |
|   | MBPAB | REQD _____ NOT REQD _____   |    |   |   |
| 95  | 420   | REPLACE DEFECTIVE FOREFLAP ATTACH NUT PLATES 1 CARRIAGES ASSY.  | DS | / | / |
|   | MBPAB | REQD _____ NOT REQD _____   |    |   |   |
|   |       | CAUTION: WHEN OVERHAULING FLAP ASSY 1560009675259FL & 1560009675260FL IT IS MANDATORY TO USE THE LATEST PREFERRED FOREFLAPS IN ALL POSITIONS  |    |   |   |
| 95  | 430   | INSTALL FOREFLAPS & ASSURE INSIDE MEASUREMENTS & POSITION IAW DWG 5-86892 & 1C-135(K)A-2-8, FIG. 5-61. NOTE: FLAP ASSY 1560006566200FL WILL HAVE FOREFLAPS P/N 65-7360-1 OR -3137 & 65-7360-3 OR -3138 & 65-7360-4, FLAP ASSY 1560009675259FL & -3137 INSTALLED. FLAP ASSY 1560009675260FL WILL HAVE FOREFLAPS P/N 65-7360-3136 & 3138 INSTALLED. | DS | E | / |
|   | MBPAB |   |    |   |   |
| 95  | 440   | REPLACE ALL WORN OR DAMAGED SEALS   | DS | / | / |
|   | MBPAB | REQD _____ NOT REQD _____   |    |   |   |
| 95  | 450   | WORK COMPLETED, CONDITION TAG   | DS | E | / |
|   | MBPAB | DATE _____  |    |   |   |
|   |       | IAW AFM 67-1  |    |   |   |
|   |       | MOVE TO CRATING   |    |   |   |
|   |       | NOTE: MOVE TO AIRCRAFT IF PDM LINE GENERATED FLAP.  |    |   |   |
|   |       | SERIAL# _____ DATE _____  |    |   |   |
|   |       | NOTE: PART WILL HAVE UD-ALL FORM 586 587 & 588 IDENTIFICATION LABELS  |    |   |   |
|   |       | APPLIED TO COMPLETE ITEM IAW AFLCR  |    |   |   |
| (CONTINUED)   |       |   |    |   |   |

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 15151A \* WORK CONTROL DOCUMENT \* MICTR J. DATE 80055 PAGE 3 OF 6 PAGES  
 115.DISP-16.PDN/  
 STATION/OP NO. 117.WORK TO BE ACCOMPLISHED 118.MATERIALS REQUIRED

66-51.  
 ACCEPTANCE DATE ON THE LABEL ALONG  
 WITH "M" STAMP OF THE PERSON PER  
 FORMING THE OVERHAUL.  
 CAUTION: SURFACE TO WHICH LABELS ARE  
 APPLIED MUST BE FREE OF DIRT.  
 COORDINATION: DATE:  
 HARRIS MICHAEL TYANIC 23 FEB 80  
 HARRIS PHIL DUNCAN 23 FEB 80  
 HARRIS GAIL MCCOY 23 FEB 80  
 HARRIS ALD DRYLES 23 FEB 80

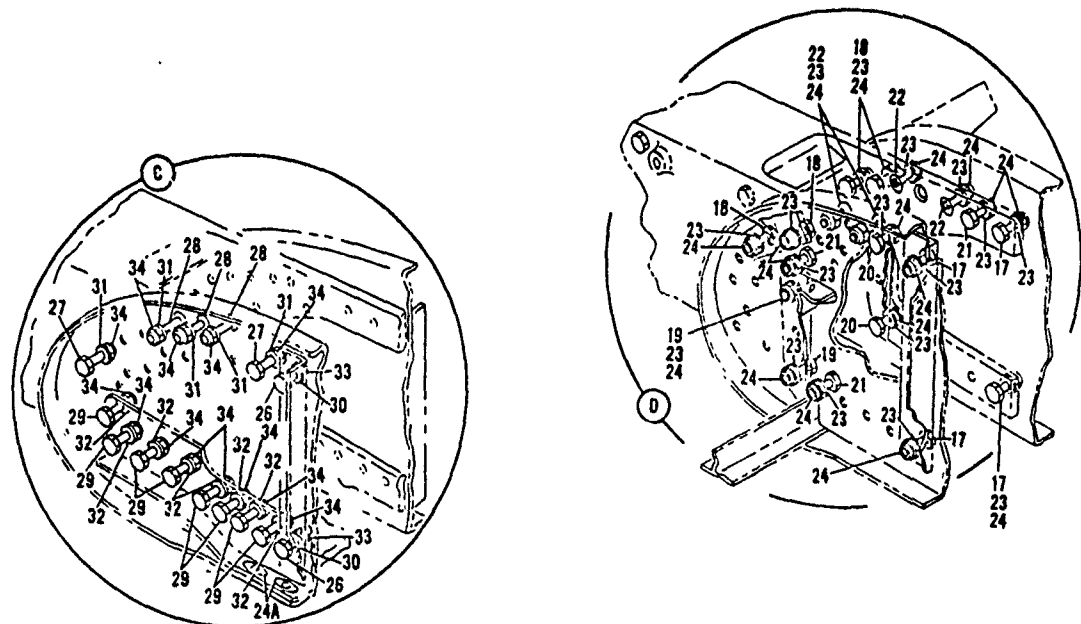
# Wing Control Surfaces



3153-44a

Figure 44. Outboard Flap Installations (Sheet 1 of 2)

## Wing Control Surfaces



3153-44b

Figure 44. Outboard Flap Installations (Sheet 2 of 2)

| FIGURE & INDEX NO. | PART NUMBER | DESCRIPTION   | UNITS PER ASSY | USE ON CODE |
|--------------------|-------------|---|----------------|-------------|
| 44 -               | 5-73132-1   | FLAP INSTL, OUTBOARD (LH) (FOR NHA SEE FIG. 2)  | REF            |             |
|                    | 5-73132-2   | FLAP INSTL, OUTBOARD (RH) (FOR NHA SEE FIG. 2)  | REF            |             |
| 1                  | 5-95315     | STOP INSTL, DOWN POSITION, OUTBOARD FLAP  | 2              |             |
| 2                  | NAS464P4A25 | BOLT (FOR REPLACEMENT ORDER NAS1104-25)   | 2              |             |
| 3                  | AN960D416L  | WASHER  | 2              |             |
|                    | NAS679A4W   | NUT (FOR REPLACEMENT ORDER 96-048 (03680) (80539) H10-4BAC (15653) T6S428J (71087) RMLH9075-4W (72962) (BACN10JC4))   | 2              |             |
| 3A                 | 3-93742-3   | STOP, FLAP, DOWN POSITION (LH)  | 1              |             |
| 3B                 | 3-93742-4   | STOP, FLAP, DOWN POSITION (RH)  | 1              |             |
| 3C                 | BACS40A7-37 | SHIM, LAM, 0.030 THK (ALTERNATES BACS40B7-37, BACS40C7-37)  | AR             |             |
|                    | 5-87851-155 | FLAP ASSY, OUTBOARD (ALTERNATE, ANY AIR FORCE SPARE FLAP ASSEMBLY (5-87851-( )) LH FOR LH INSTALLATION INCORPORATING ALL APPLICABLE TECHNICAL ORDERS) (LH ONLY) | 1              |             |
|                    | 5-87851-156 | FLAP ASSY, OUTBOARD (ALTERNATE, ANY AIR FORCE SPARE FLAP ASSEMBLY (5-87851-( )) RH FOR RH INSTALLATION INCORPORATING ALL APPLICABLE TECHNICAL ORDERS) (RH ONLY) | 1              |             |
|                    | 65-24498-5  | DEPRESSORS INSTL, OUTBOARD FLAP (LH ONLY)   | 1              | A           |
|                    | 65-24498-6  | DEPRESSORS INSTL, OUTBOARD FLAP (RH ONLY)   | 1              | A           |
| 4                  | 69-18383-1  | DEPRESSOR ASSY, OUTBOARD FLAP, WING STATION 546.30 (LH ONLY)  | 1              | A           |
|                    | 69-18383-2  | DEPRESSOR ASSY, OUTBOARD FLAP, WING STATION 546.30 (RH ONLY)  | 1              | A           |
| 4A                 | 69-18384-1  | DEPRESSOR ASSY, OUTBOARD FLAP, WING STATION 615.00  | 1              | A           |
| 4B                 | 69-18385-1  | DEPRESSOR ASSY, OUTBOARD FLAP, WING STATION 700.50  | 1              | A           |
| 4C                 | 5-87851-143 | SKIN, NOSE, OUTBOARD, OUTBOARD FLAP (LH ONLY)   | 1              |             |
|                    | 5-87851-144 | SKIN, NOSE, OUTBOARD, OUTBOARD FLAP (RH ONLY)   | 1              |             |

CHANGED 29 SEPTEMBER 1968

2-109

Section II  
Group Assembly Parts List

T.O. 1C-135A-4

| FIGURE &<br>INDEX NO. | PART NUMBER | DESCRIPTION  | UNITS<br>PER<br>ASSY | USE<br>ON<br>CODE |
|-----------------------|-------------|--|----------------------|-------------------|
|                       |             | 1 2 3 4 5 6 7  |                      |                   |
| 44 -                  |             |  |                      |                   |
| 4D                    | 5-87851-141 | .. SKIN, NOSE, INBOARD, OUTBOARD FLAP (LH ONLY). . . . .   | 1                    |                   |
|                       | 5-87851-142 | .. SKIN, NOSE, INBOARD, OUTBOARD FLAP (RH ONLY). . . . .   | 1                    |                   |
| 4E                    | 5-87851-139 | .. SKIN, NOSE, CENTER, OUTBOARD FLAP (LH ONLY). . . . .  | 1                    |                   |
|                       | 5-87851-140 | .. SKIN, NOSE, CENTER, OUTBOARD FLAP (RH ONLY). . . . .  | 1                    |                   |
| 4F                    | 69-9609-3   | .. CAM ASSY, OUTBOARD FLAP, STATION 549.99 (LH ONLY). . .  | 1                    |                   |
|                       | 69-9609-4   | .. CAM ASSY, OUTBOARD FLAP, STATION 549.99 (RH ONLY). . .  | 1                    |                   |
| 4G                    | 69-9337-1   | .. CAM ASSY, OUTBOARD FLAP, STATION 680.07 . . . . .   | 1                    |                   |
| 5                     | 63-8483     | .. STRIP, BUMPER, ACTUATOR, OUTBOARD FLAP. . . . .   | 2                    |                   |
| 5A                    | 5-88723-15  | .. PANEL ASSY, HONEYCOMB, LOWER FORWARD OUTBOARD HALF, .<br>OUTBOARD FLAP SKIN (FOR I/W INFO SEE 5-88723-23)<br>(ALTERNATE 5-88723-23) (LH ONLY) | 1                    | F                 |
|                       | 5-88723-23  | .. PANEL ASSY, HONEYCOMB, LOWER FORWARD OUTBOARD HALF, .<br>OUTBOARD FLAP SKIN (I/W 5-88723-15) (USE<br>5-88723-15 UNTIL EXHAUSTED) (LH ONLY)    | 1                    | G                 |
|                       | 5-88723-16  | .. PANEL ASSY, HONEYCOMB, LOWER FORWARD OUTBOARD HALF, .<br>OUTBOARD FLAP SKIN (FOR I/W INFO SEE 5-88723-24)<br>(ALTERNATE 5-88723-24) (RH ONLY) | 1                    | F                 |
|                       | 5-88723-24  | .. PANEL ASSY, HONEYCOMB, LOWER FORWARD OUTBOARD HALF, .<br>OUTBOARD FLAP SKIN (I/W 5-88723-16) (USE<br>5-88723-16 UNTIL EXHAUSTED) (RH ONLY)    | 1                    | G                 |
| 5B                    | 5-88722-15  | .. PANEL ASSY, HONEYCOMB, LOWER FORWARD INBOARD HALF, .<br>OUTBOARD FLAP SKIN (FOR I/W INFO SEE 5-88722-23)<br>(ALTERNATE 5-88722-23) (LH ONLY)  | 1                    | F                 |
| 5B                    | 5-88722-23  | .. PANEL ASSY, HONEYCOMB, LOWER FORWARD INBOARD HALF, .<br>OUTBOARD FLAP SKIN (I/W 5-88722-15) (USE<br>5-88722-15 UNTIL EXHAUSTED) (LH ONLY)     | 1                    | G                 |
|                       | 5-88722-16  | .. PANEL ASSY, HONEYCOMB, LOWER FORWARD INBOARD HALF, .<br>OUTBOARD FLAP SKIN (FOR I/W INFO SEE 5-88722-24)<br>(ALTERNATE 5-88722-24) (RH ONLY)  | 1                    | F                 |
|                       | 5-88722-24  | .. PANEL ASSY, HONEYCOMB, LOWER FORWARD INBOARD HALF, .<br>OUTBOARD FLAP SKIN (I/W 5-88722-16) (USE<br>5-88722-16 UNTIL EXHAUSTED) (RH ONLY)     | 1                    | G                 |
| 5C                    | 50-4671-1   | .. PANEL ASSY, SKIN, HONEYCOMB, LOWER OUTBOARD HALF, . .<br>OUTBOARD FLAP (FOR REPLACEMENT ORDER<br>50-4671-3022) (LH ONLY)                      | 1                    | F                 |
| 5C                    | 50-4671-11  | .. PANEL ASSY, SKIN, HONEYCOMB, LOWER OUTBOARD HALF, . .<br>OUTBOARD FLAP (FOR REPLACEMENT ORDER<br>50-4671-3022) (LH ONLY)                      | 1                    | G                 |
|                       | 50-4671-2   | .. PANEL ASSY, SKIN, HONEYCOMB, LOWER OUTBOARD HALF, . .<br>OUTBOARD HALF (FOR REPLACEMENT ORDER<br>50-4671-3022) (RH ONLY)                      | 1                    | F                 |
|                       | 50-4671-12  | .. PANEL ASSY, SKIN, HONEYCOMB, LOWER OUTBOARD HALF, . .<br>OUTBOARD FLAP (FOR REPLACEMENT ORDER<br>50-4671-3022) (RH ONLY)                      | 1                    | G                 |
| 5D                    | 50-4671-3   | .. PANEL ASSY, SKIN, HONEYCOMB, UPPER OUTBOARD HALF, . .<br>OUTBOARD FLAP (FOR REPLACEMENT ORDER<br>50-4671-3022) (LH ONLY)                      | 1                    | F                 |
| 5D                    | 50-4671-13  | .. PANEL ASSY, SKIN, HONEYCOMB, UPPER OUTBOARD HALF, . .<br>OUTBOARD FLAP (FOR REPLACEMENT ORDER<br>50-4671-3022) (LH ONLY)                      | 1                    | G                 |
|                       | 50-4671-4   | .. PANEL ASSY, SKIN, HONEYCOMB, UPPER OUTBOARD HALF, . .<br>OUTBOARD FLAP (FOR REPLACEMENT ORDER<br>50-4671-3022) (RH ONLY)                      | 1                    | F                 |
|                       | 50-4671-14  | .. PANEL ASSY, SKIN, HONEYCOMB, UPPER OUTBOARD HALF, . .<br>OUTBOARD FLAP (FOR REPLACEMENT ORDER<br>50-4671-3022) (RH ONLY)                      | 1                    | G                 |
| 5E                    | 50-4670-1   | .. PANEL ASSY, SKIN, HONEYCOMB, LOWER INBOARD HALF, . .<br>OUTBOARD FLAP (FOR REPLACEMENT ORDER<br>50-4670-3022) (LH ONLY)                       | 1                    | F                 |
| 5E                    | 50-4670-11  | .. PANEL ASSY, SKIN, HONEYCOMB, LOWER INBOARD HALF, . .<br>OUTBOARD FLAP (FOR REPLACEMENT ORDER<br>50-4670-3022) (LH ONLY)                       | 1                    | G                 |
|                       | 50-4670-2   | .. PANEL ASSY, SKIN, HONEYCOMB, LOWER INBOARD HALF, . .<br>OUTBOARD FLAP (FOR REPLACEMENT ORDER<br>50-4670-3022) (RH ONLY)                       | 1                    | F                 |
|                       | 50-4670-12  | .. PANEL ASSY, SKIN, HONEYCOMB, LOWER INBOARD HALF, . .<br>OUTBOARD FLAP (FOR REPLACEMENT ORDER<br>50-4670-3022) (RH ONLY)                       | 1                    | G                 |
| 5F                    | 50-4670-3   | .. PANEL ASSY, SKIN, HONEYCOMB, UPPER INBOARD HALF, . .<br>OUTBOARD FLAP (FOR REPLACEMENT ORDER<br>50-4670-3022) (LH ONLY)                       | 1                    | F                 |

| FIGURE &<br>INDEX NO. | PART NUMBER   | DESCRIPTION   | UNITS<br>PER<br>ASSY | USE<br>ON<br>CODE |
|-----------------------|---------------|---|----------------------|-------------------|
|                       |               | 1 2 3 4 5 6 7   |                      |                   |
| 44 -                  |               |   |                      |                   |
| 5F                    | 50-4670-13    | . . PANEL ASSY, SKIN, HONEYCOMB, UPPER INBOARD HALF, . .<br>OUTBOARD FLAP (FOR REPLACEMENT ORDER<br>50-4670-3022) (LH ONLY)     | 1                    | G                 |
|                       | 50-4670-4     | . . PANEL ASSY, SKIN, HONEYCOMB, UPPER INBOARD HALF, . .<br>OUTBOARD FLAP (FOR REPLACEMENT ORDER<br>50-4670-3022) (RH ONLY)     | 1                    | F                 |
|                       | 50-4670-14    | . . PANEL ASSY, SKIN, HONEYCOMB, UPPER INBOARD HALF, . .<br>OUTBOARD FLAP (FOR REPLACEMENT ORDER<br>50-4670-3022) (RH ONLY)     | 1                    | G                 |
| 6                     | 9-61951-8     | . . . FITTING ASSY, SUPPORT, FLAP SCREW . . . . .   | 1                    |                   |
| 7                     | NAS516-1      | . . . FITTING . . . . .   | 2                    |                   |
| 8                     | AN4-10A       | . . . BOLT (FOR REPLACEMENT ORDER BACB3ONE4-9). . . . .   | 2                    |                   |
| 9                     | 63-1519       | . . . NUTPLATE ASSY, CONVEX, WING FLAP. . . . .   | 2                    |                   |
| 10                    | 3-98762       | . . . BEARING, SUPPORT, FLAP SCREW. . . . .   | 2                    |                   |
| 11                    | 9-61951-7     | . . . FITTING, SUPPORT, FLAP SCREW. . . . .   | 1                    |                   |
|                       | 65-7360-5     | . . FLAP ASSY, FORE (LH ONLY) (FOR REPLACEMENT ORDER. . .<br>65-7360-3127) (FOR BREAKDOWN SEE FIG. 53)                          | 1                    | B                 |
|                       | 65-7360-6     | . . FLAP ASSY, FORE (RH ONLY) (FOR REPLACEMENT ORDER. . .<br>65-7360-3128) (FOR BREAKDOWN SEE FIG. 53)                          | 1                    | B                 |
| 12                    | 65-7360-3129  | . . FLAP ASSY, FORE (LH ONLY) (FOR BREAKDOWN SEE. . . . .<br>FIG. 54)   | 1                    |                   |
|                       | 65-7360-3130  | . . FLAP ASSY, FORE (RH ONLY) (FOR BREAKDOWN SEE. . . . .<br>FIG. 54)   | 1                    |                   |
| 13                    | 65-7360-9     | . . FLAP ASSY, FORE (LH ONLY) (FOR BREAKDOWN SEE. . . . .<br>FIG. 55)   | 1                    |                   |
|                       | 65-7360-10    | . . FLAP ASSY, FORE (RH ONLY) (FOR BREAKDOWN SEE. . . . .<br>FIG. 55)   | 1                    |                   |
|                       | AN4-10A       | (ATTACHING PARTS)   |                      |                   |
|                       | (A)AN4-11A    | . . BOLT (FOR REPLACEMENT ORDER BACB3ONE4-9). . . . .   | 20                   |                   |
|                       | NAS1104-3W    | . . BOLT. . . . .   | 20                   |                   |
|                       | AN960D416     | . . BOLT (FOR REPLACEMENT ORDER NAS1104-3). . . . .   | 2                    |                   |
|                       | AN960PD416L   | . . WASHER. . . . .   | 22                   |                   |
|                       | NAS679A4W     | . . WASHER. . . . .   | AR                   |                   |
|                       |               | . . NUT (FOR REPLACEMENT ORDER 96-048 (03680) (80539)<br>H10-4BAC (15653) T6S428J (71087) RMLH9075-4W<br>(72962) (BACN10JC4))   | 22                   |                   |
| 14                    | (DELETED)     |   |                      |                   |
| 15                    | (DELETED)     |   |                      |                   |
|                       | 5-87852-63    | . . RIB INSTL, OUTBOARD TRACK, OUTBOARD FLAP (LH ONLY). .   | 1                    |                   |
|                       | 5-87852-64    | . . RIB INSTL, OUTBOARD TRACK, OUTBOARD FLAP (RH ONLY). .   | 1                    |                   |
| 16                    | 5-87847-7     | . . . CARRIAGE ASSY, END, OUTBOARD FLAP (FOR BREAKDOWN. .<br>SEE FIG. 45)   | 1                    |                   |
|                       |               | (ATTACHING PARTS)   |                      |                   |
| 17                    | NAS1104-8W    | . . . BOLT (FOR REPLACEMENT ORDER NAS1104-8). . . . .   | 4                    |                   |
| 18                    | NAS1104-6W    | . . . BOLT (FOR REPLACEMENT ORDER NAS1104-6). . . . .   | 4                    |                   |
| 19                    | NAS1104-9W    | . . . BOLT (FOR REPLACEMENT ORDER NAS1104-9). . . . .   | 3                    |                   |
| 20                    | NAS1104-7W    | . . . BOLT (FOR REPLACEMENT ORDER NAS1104-7). . . . .   | 3                    |                   |
| 21                    | NAS1104-6W    | . . . BOLT (FOR REPLACEMENT ORDER NAS1104-6). . . . .   | 30                   |                   |
| 22                    | NAS517-4-6    | . . . SCREW (FOR REPLACEMENT ORDER BACB30LU4-6) . . . . .   | 6                    |                   |
| 23                    | AN960D416     | . . . WASHER. . . . .   | 50                   |                   |
| 24                    | NAS679A4W     | . . . NUT (FOR REPLACEMENT ORDER 96-048 (03680) (80539)<br>H10-4BAC (15653) T6S428J (71087) RMLH9075-4W<br>(72962) (BACN10JC4)) | 50                   |                   |
|                       | 5-87852-72    | . . RIB INSTL, CENTER TRACK, OUTBOARD FLAP. . . . .   | 1                    |                   |
| 24A                   | NAS463000416L | . . . SHIM. . . . .   | 4                    |                   |
| 25                    | 5-87846-3     | . . . CARRIAGE ASSY, CENTER, OUTBOARD FLAP (FOR . . . . .<br>BREAKDOWN SEE FIG. 52)   | 1                    |                   |
|                       |               | (ATTACHING PARTS)   |                      |                   |
| 26                    | NAS1105-8W    | . . . BOLT (FOR REPLACEMENT ORDER NAS1105-8). . . . .   | 4                    |                   |
| 27                    | NAS1104-6W    | . . . BOLT (FOR REPLACEMENT ORDER NAS1104-6). . . . .   | 20                   |                   |
| 28                    | NAS517-4-6    | . . . SCREW (FOR REPLACEMENT ORDER BACB30LU4-6) . . . . .   | 6                    |                   |
| 29                    | NAS1104-7W    | . . . BOLT (FOR REPLACEMENT ORDER NAS1104-7). . . . .   | 16                   |                   |
| 30                    | AN960D516     | . . . WASHER. . . . .   | 4                    |                   |
| 31                    | AN960D416     | . . . WASHER. . . . .   | 26                   |                   |
| 32                    | AN960D416L    | . . . WASHER. . . . .   | 16                   |                   |
| 33                    | MS21042L5     | . . . NUT (REPLACES NAS679A5) . . . . .   | 4                    |                   |
| 34                    | NAS679A4W     | . . . NUT (FOR REPLACEMENT ORDER 96-048 (03680) (80539)<br>H10-4BAC (15653) T6S428J (71087) RMLH9075-4W<br>(72962) (BACN10JC4)) | 42                   |                   |

Section II  
Group Assembly Parts List

T.O.1C-135A-4

| FIGURE &<br>INDEX NO         | PART NUMBER | DESCRIPTION  |   |   |   |   |   |   | UNITS<br>PER<br>ASSY | USE<br>ON<br>CODE |
|------------------------------|-------------|--|---|---|---|---|---|---|----------------------|-------------------|
|                              |             | 1  | 2 | 3 | 4 | 5 | 6 | 7 |                      |                   |
| 44 -<br>35<br>36<br>36<br>37 | 5-87841-239 | • • "18 INSTL, INBOARD ACTUATOR AND TRACK, OUTBOARD . .  |   |   |   |   |   |   | 1                    |                   |
|                              | 5-87841-240 | • • "18 INSTL, INBOARD ACTUATOR AND TRACK, OUTBOARD . .  |   |   |   |   |   |   | 1                    |                   |
|                              | 5-87851-91  | • • "18 INSTL, INBOARD ACTUATOR AND TRACK, OUTBOARD . .  |   |   |   |   |   |   | 1                    | D                 |
|                              | 5-87851-161 | • • SEAL, MOHAIR, OUTBOARD FLAP (MAKE FROM 5680 . . . .  |   |   |   |   |   |   | 1                    | E                 |
|                              | 90-4577-49  | • • SEAL, MOHAIR, OUTBOARD FLAP (MAKE FROM 5680 . . . .  |   |   |   |   |   |   | 1                    | E                 |
|                              | 90-4577-50  | • • BAC1523-20 X 14.0)                                   |   |   |   |   |   |   | 1                    |                   |
|                              | 90-4577-51  | • • BAC1523-20N X 14.0)                                  |   |   |   |   |   |   | 1                    |                   |
|                              | 90-4577-52  | • • TRAILING EDGE INSTL, OUTBOARD FLAP (LH ONLY) . . . . |   |   |   |   |   |   | 1                    |                   |
|                              | NASS17-3-4  | • • TRAILING EDGE INSTL, OUTBOARD FLAP (RH ONLY) . . . . |   |   |   |   |   |   | 1                    |                   |
|                              |             | • • TRAILING EDGE ASSY, OUTBOARD FLAP (LH ONLY) . . . .  |   |   |   |   |   |   | 1                    |                   |
|                              |             | • • TRAILING EDGE ASSY, OUTBOARD FLAP (RH ONLY) . . . .  |   |   |   |   |   |   | 1                    |                   |
|                              |             | • • (ATTACHING PARTS)                                    |   |   |   |   |   |   | 1                    |                   |
|                              |             | • • SCREW (FOR REPLACEMENT ORDER 8ACB30LU3-4) . . . .    |   |   |   |   |   |   | 117                  |                   |
|                              |             | -----*   |   |   |   |   |   |   |                      |                   |
|                              |             | A 3029 THRU 3099   |   |   |   |   |   |   |                      |                   |
|                              |             | B 2201 THRU 2299, 3001 THRU 3099                         |   |   |   |   |   |   |                      |                   |
|                              |             | C DELETED  |   |   |   |   |   |   |                      |                   |
|                              |             | D 3001 THRU 3001   |   |   |   |   |   |   |                      |                   |
|                              |             | E 3002 THRU 3099   |   |   |   |   |   |   |                      |                   |
|                              |             | F 3001 THRU 3099   |   |   |   |   |   |   |                      |                   |
|                              |             | G 2201 THRU 2299   |   |   |   |   |   |   |                      |                   |



NOTE:

THIS FOREFLAP  
COMES OFF 15151A  
AT OPS 40 OR  
30 IN NEW AREA,  
AND IS AGSY IN  
OPS 430

FLOW PROCESS CHART

SUBJECT WING FLAP INBOARD FORE FLAP

DATE 4/5/89

PCN: 15191A  
15192A

WCD: 15152A WCD DATE: 88055

CHART BEGINS

PAGE 01

CHART ENDS

PREPARED BY: R. BOLANDS

| WCD<br>OP<br># | SYMBOLS | DESCRIPTION  | WCD<br>OP<br># | SYMBOLS | DESCRIPTION     |
|----------------|---------|--|----------------|---------|-----------------|
|                | ○ ◇ ▢ ▽ | DELAY coming off 15151A<br>95 from OPS 40                  |                | ○ ◇ ▢ ▽ | DELAY           |
|                | ○ ◇ ▢ ▽ | MOVE TO WASH + STRIP<br>2122 MARPCA                        |                | ○ ◇ ▢ ▽ | MOVE TO CRATING |
|                | ○ ◇ ▢ ▽ | DELAY  |                | ○ ◇ ▢ ▽ |                 |
| 15             | ● ◇ ▢ ▽ | STRIP + WASH FORE FLAP                                     |                | ○ ◇ ▢ ▽ |                 |
|                | ○ ◇ ▢ ▽ | DELAY  |                | ○ ◇ ▢ ▽ |                 |
|                | ○ ◇ ▢ ▽ | MOVE TO X-RAY  |                | ○ ◇ ▢ ▽ |                 |
|                | ○ ◇ ▢ ▽ | DELAY  |                | ○ ◇ ▢ ▽ |                 |
| 10             | ● ◇ ▢ ▽ | X-RAY SKINS  |                | ○ ◇ ▢ ▽ |                 |
|                | ○ ◇ ▢ ▽ | DELAY  |                | ○ ◇ ▢ ▽ |                 |
|                | ○ ◇ ▢ ▽ | MOVE TO SHEETMETAL   |                | ○ ◇ ▢ ▽ |                 |
|                | ○ ◇ ▢ ▽ | DELAY  |                | ○ ◇ ▢ ▽ |                 |
| 20             | ● ◇ ▢ ▽ | SHAKEDOWN INSPECTION                                       |                | ○ ◇ ▢ ▽ |                 |
| 25             | ● ◇ ▢ ▽ | CHECK MOUNTING HOLES                                       |                | ○ ◇ ▢ ▽ |                 |
| 30             | ● ◇ ▢ ▽ | R/R EXTERIOR SKINS<br>+ CLEAN                              |                | ○ ◇ ▢ ▽ |                 |
| 40             | ● ◇ ▢ ▽ | CHECK FOR CORROSION<br>ANY REPAIR                          |                | ○ ◇ ▢ ▽ |                 |
| 50             | ● ◇ ▢ ▽ | R/R RIBS   |                | ○ ◇ ▢ ▽ |                 |
| 60             | ● ◇ ▢ ▽ | R/R END ATTACHED<br>PLATE                                  |                | ○ ◇ ▢ ▽ |                 |
| 70             | ● ◇ ▢ ▽ | R/R INTERNAL RIBS  |                | ○ ◇ ▢ ▽ |                 |
| 80             | ● ◇ ▢ ▽ | R/R RUB STRIPS   |                | ○ ◇ ▢ ▽ |                 |
| 90             | ● ◇ ▢ ▽ | R/R FASTENERS  |                | ○ ◇ ▢ ▽ |                 |
| 100            | ● ◇ ▢ ▽ | R/R TRAILING EDGE<br>EXTENSION                             |                | ○ ◇ ▢ ▽ |                 |
|                | ○ ◇ ▢ ▽ | DELAY  |                | ○ ◇ ▢ ▽ |                 |
|                | ○ ◇ ▢ ▽ | MOVE TO WASH + PAINT.<br>IF BATT AIRCRAFT, NO PAINT NEEDED |                | ○ ◇ ▢ ▽ |                 |
|                | ○ ◇ ▢ ▽ |  |                | ○ ◇ ▢ ▽ |                 |
| 110            | ● ◇ ▢ ▽ | PREPARED + PAINT<br>2280 MARPCA                            |                | ○ ◇ ▢ ▽ |                 |
|                | ○ ◇ ▢ ▽ | DELAY  |                | ○ ◇ ▢ ▽ |                 |
| 120            | ○ ◇ ▢ ▽ | MOVE TO SHEETMETAL<br>IF PDM TO AIRCRAFT                   |                | ○ ◇ ▢ ▽ |                 |
|                | ○ ◇ ▢ ▽ | DELAY  |                | ○ ◇ ▢ ▽ |                 |
| 130            | ● ◇ ▢ ▽ | CONDITION TAG  |                | ○ ◇ ▢ ▽ |                 |

| *****   |       |                                      |        |  |  |  |  |  |  |
|---|-------|--------------------------------------|--------|--|--|--|--|--|--|
| 15152A WORK CONTROL DOCUMENT - MISTR 1. DATE 09055 PAGE 1 OF 2 ACLSI  |       |                                      |        |  |  |  |  |  |  |
| *****   |       |                                      |        |  |  |  |  |  |  |
| 2. ORIG/PROD NR 13. QUANTITY 14. PROD SECTION/RCC 15. DATE CHLD 16. DATE COM  |       |                                      |        |  |  |  |  |  |  |
| MABPAB 87073  |       |                                      |        |  |  |  |  |  |  |
| *****   |       |                                      |        |  |  |  |  |  |  |
| 17. PART NUMBER 19. ITEM SERIAL NR 13/12. TECH DATA/OPTIONAL  |       |                                      |        |  |  |  |  |  |  |
| FORE FLAP SUPPLEMENT  |       |                                      |        |  |  |  |  |  |  |
| SOW UC 1560FL/02-67   |       |                                      |        |  |  |  |  |  |  |
| 10. MODEL/DESIGN/SERIES 11. STOCK NR 12. REVISION #1, DID 9 MAR 02  |       |                                      |        |  |  |  |  |  |  |
| U 13N   |       |                                      |        |  |  |  |  |  |  |
| *****   |       |                                      |        |  |  |  |  |  |  |
| 13. MISC 14. NOUN/END ITLM NOUN   |       |                                      |        |  |  |  |  |  |  |
| WING FLAP, INBOARD (FORE FLAP)  |       |                                      |        |  |  |  |  |  |  |
| MICHAEL TYTANIC/MABECS/65261  |       |                                      |        |  |  |  |  |  |  |
| P/N NSN C/N   |       |                                      |        |  |  |  |  |  |  |
| 5-86892-119   |       | 1560006067421FL                      | 15151A |  |  |  |  |  |  |
| 5-86892-121   |       | 1560006067421FL                      | 15151A |  |  |  |  |  |  |
| 5-86892-123   |       | 1560006067421FL                      | 15151A |  |  |  |  |  |  |
| 5-86892-120   |       | 1560006067421FL                      | 15152A |  |  |  |  |  |  |
| 5-86892-112   |       | 1560006210781FL                      | 15160A |  |  |  |  |  |  |
| 5-86892-127   |       | 1560006566065FL                      | 15104A |  |  |  |  |  |  |
| 5-86892-128   |       | 1560006566066FL                      | 15185A |  |  |  |  |  |  |
| 5-86892-127   |       | 1560006566200FL                      | 15191A |  |  |  |  |  |  |
| 5-86892-130   |       | 1560006566201FL                      | 15192A |  |  |  |  |  |  |
| 5-86892-131   |       | 1560006566202FL                      | 15193A |  |  |  |  |  |  |
| 5-86892-132   |       | 1560006566203FL                      | 15194A |  |  |  |  |  |  |
| 5-86892-136   |       | 1560006765200FL                      | 15207A |  |  |  |  |  |  |
| *****   |       |                                      |        |  |  |  |  |  |  |
| 15. STATION/16. WORK NO. 17. WORK TO BE ACCOMPLISHED 18. PRIOR 19. 20. 21. 22. 23. 24. 25. 26. 27. 28. 29. 30. 31. 32. 33. 34. 35. 36. 37. 38. 39. 40. 41. 42. 43. 44. 45. 46. 47. 48. 49. 50. 51. 52. 53. 54. 55. 56. 57. 58. 59. 60. 61. 62. 63. 64. 65. 66. 67. 68. 69. 70. 71. 72. 73. 74. 75. 76. 77. 78. 79. 80. 81. 82. 83. 84. 85. 86. 87. 88. 89. 90. 91. 92. 93. 94. 95. 96. 97. 98. 99. 100. |       |                                      |        |  |  |  |  |  |  |
| 2122  | 005   | STRIP AND WASH FORE FLAP             |        |  |  |  |  |  |  |
|   | MBPCA | 1AW 1C-135(K)A-3-4                   |        |  |  |  |  |  |  |
| 3000  | 010   | X-RAY FORE FLAP, 1) SKIN IS NOT      |        |  |  |  |  |  |  |
|   | MQCIA | REMOVED. "N" STAMP REMOVED 1AW       |        |  |  |  |  |  |  |
|   |       | 1C-135-36, SECT. 11                  |        |  |  |  |  |  |  |
| 95  | 020   | ACCOMPLISH E&I SHAKEDOWN             |        |  |  |  |  |  |  |
|   | MBPAB |                                      |        |  |  |  |  |  |  |
| 95  | 025   | CHECK MOUNTING HOLES IN ATTACHMENT   |        |  |  |  |  |  |  |
|   | MBPAB | BRACKET TO SEE IF WITHIN TOLERANCES. |        |  |  |  |  |  |  |
|   |       | REQ'D _____ NOT REQ'D _____          |        |  |  |  |  |  |  |
| 95  | 030   | REPAIR/REPLACE EXTERIOR SKINS 1AW    |        |  |  |  |  |  |  |
|   | MBPAB | 1C-135(K)A-3-1, FIG 10-5 (INCLUDES   |        |  |  |  |  |  |  |
|   |       | CLEAN & CLOSEOUT).                   |        |  |  |  |  |  |  |
| 95  | 040   | CHECK FOREFLAP FOR CORROSION AND     |        |  |  |  |  |  |  |
|   | MBPAB | WORK IF ANY IS FOUND.                |        |  |  |  |  |  |  |
|   |       | REQ'D _____ NOT REQ'D _____          |        |  |  |  |  |  |  |
| 95  | 050   | REPLACE END RIB                      |        |  |  |  |  |  |  |
|   | MBPAB | REQD _____ NOT REQD _____            |        |  |  |  |  |  |  |
| 95  | 060   | REPLACE END ATTACH PLATE             |        |  |  |  |  |  |  |
|   | MBPAB | REQD _____ NOT REQD _____            |        |  |  |  |  |  |  |
| 95  | 070   | REPLACE INTERNAL RIBS OR FIELD       |        |  |  |  |  |  |  |
|   | MBPAB | REPAIRD RIBS.                        |        |  |  |  |  |  |  |
|   |       | REQD _____ NOT REQD _____            |        |  |  |  |  |  |  |

|  |       |     |                                       |    |   |   |  |  |  |
|--|-------|-----|---------------------------------------|----|---|---|--|--|--|
| *****  |       |     |                                       |    |   |   |  |  |  |
| 15152A * WORK CONTROL DOCUMENT * MISTR 1. DATE 30055 PAGE 2 OF 2 PAGE 2              |       |     |                                       |    |   |   |  |  |  |
| 15. DISP-16. PDM/STATION OF NO. 17. WORK TO BE ACCOMPLISHED 18. MECH 117" P" 120" W" |       |     |                                       |    |   |   |  |  |  |
| 95   | 080   | 110 | REPLACE RUB STRIPS NO. _____          | DS | / | / |  |  |  |
|  | MBPAB |     | REQD _____ NOT REQD _____             |    |   |   |  |  |  |
| 95   | 090   | 120 | REPLACE MISSING, DEFECTIVE OR LOOSE   | DS | / | / |  |  |  |
|  | MBPAB |     | FASTENERS.                            |    |   |   |  |  |  |
|  |       |     | REQD _____ NOT REQD _____             |    |   |   |  |  |  |
| 95   | 100   | 120 | REPLACE CRACKED TRAILING EDGE         | DS | / | / |  |  |  |
|  | MBPAB |     | EXTENSION.                            |    |   |   |  |  |  |
|  |       |     | REQD _____ NOT REQD _____             |    |   |   |  |  |  |
|  |       |     | MOVE TO MBPCB, BLDG 2280              |    |   |   |  |  |  |
|  |       |     | NOTE: UNIT MOVE IF PDM LINE           |    |   |   |  |  |  |
|  |       |     | GENERATED FLAP.                       |    |   |   |  |  |  |
| 2280   | 110   | 140 | FINAL WASH & COORDINATION TAG         | DS | / | / |  |  |  |
|  |       |     | NOTE: UNIT MOVE IF PDM LINE           |    |   |   |  |  |  |
|  |       |     | GENERATED FLAP. <u>PREPARE 2 TAGS</u> |    |   |   |  |  |  |
|  |       |     | TAG JL-135(KYA 3-4 & 1 1 4 & 1 1 0    |    |   |   |  |  |  |
|  |       |     | USING MIL P-87112 POLYSULFIDE PRIMER  |    |   |   |  |  |  |
|  |       |     | AND HIGH GLOSS GRAY MIL-C 83286       |    |   |   |  |  |  |
|  |       |     | COLOR 16473 PAINT.                    |    |   |   |  |  |  |
| 2280   | 120   |     | MOVE TO MBPAB, BLDG 95.               | 3B | / | / |  |  |  |
|  | MBPCB |     | NOTE: MOVE TO AIRCRAFT                |    |   |   |  |  |  |
|  |       |     | SERIAL # _____                        |    |   |   |  |  |  |
|  |       |     | DATE _____                            |    |   |   |  |  |  |
|  |       |     | IF PDM LINE GENERATE FLAP.            |    |   |   |  |  |  |
| 95   | 130   |     | WORK COMPLETED, CONDITION TAG JAW     | DS | / | / |  |  |  |
|  | MBPAB |     | AFM 67-1.                             |    |   |   |  |  |  |
|  |       |     | MOVE TO CRATING. DATE _____           |    |   |   |  |  |  |
|  |       |     | COORDINATION: DATE:                   |    |   |   |  |  |  |
|  |       |     | MABEFS MICHAEL TYTANIC 24 FEB 88      |    |   |   |  |  |  |
|  |       |     | MABSF PHIL DUNCAN 24 FEB 88           |    |   |   |  |  |  |
|  |       |     | MABBF TED HAYES 24 FEB 88             |    |   |   |  |  |  |
|  |       |     | MBPAB M.A. MCCOY 24 FEB 88            |    |   |   |  |  |  |

operation numbers are in sequence of actual operations

Foreflaps worked on WCD 15154A

MABPAB 070 SHARE DOWN  
MARCSA 080 Inspection

| FLOW PROCESS CHART  |         |   |                             |   |
|---|---------|---|-----------------------------|---|
| SUBJECT <u>WING FLAP OUTBOARD</u>                             |         |   | DATE <u>9/5</u>             |   |
| PCN: <u>15188A</u> WCD: <u>15153 A</u> WCD DATE: <u>88055</u> |         |   |                             |   |
| CHART BEGINS <u>15189A</u>                                    |         |   | PAGE <u>1</u> OF <u>2</u>   |   |
| CHART ENDS _____  |         |   | PREPARED BY: <u>LARRY M</u> |   |
| WCD<br>OP<br>#  | SYMBOLS | DESCRIPTION   | WCD<br>OP<br>#              | SYMBOLS DESCRIPTION                                       |
| 010   | ● ◊ ▢ ▽ | RECEIVE PUMPERATE 2122 MABPCB                       | 180                         | ● ◊ ▢ ▽ REP/REP LEADING NOSE SKINS                        |
|   | ○ ◊ ▢ ▽ | DELAY   | 190                         | ● ◊ ▢ ▽ REPAIR NOSE SKINS IF CRACKED                      |
|   | ○ ◊ ▢ ▽ | MOVE  | 200                         | ● ◊ ▢ ▽ REPLACE CRACKED NOSE END RIBS                     |
|   | ○ ◊ ▢ ▽ | DELAY   | 210                         | ● ◊ ▢ ▽ CLOSEOUT (INSTALL UPPER OUTBOARD HONEYCOMB PANEL) |
| 020   | ● ◊ ▢ ▽ | Remove Foreflaps 95 MABPAB                          | 220                         | ● ◊ ▢ ▽ CLOSEOUT (INSTALL UPPER INBOARD HONEYCOMB PANEL)  |
|   | ○ ◊ ▢ ▽ |   | 230                         | ● ◊ ▢ ▽ REPLACE WORN CARRIAGES                            |
|   | ○ ◊ ▢ ▽ |   | 240                         | ● ◊ ▢ ▽ REP/REP DAMAGED FAIRINGS                          |
|   | ○ ◊ ▢ ▽ |   | 250                         | ● ◊ ▢ ▽ REMOVE SEAL DEPRESSOR                             |
| 030   | ● ◊ ▢ ▽ | Remove Honeycomb Panels                             | 260                         | ● ◊ ▢ ▽ CLOSEOUT (INSTALL LOWER INBOARD HONEYCOMB PANEL)  |
|   | ○ ◊ ▢ ▽ | DELAY   | 270                         | ● ◊ ▢ ▽ CLOSEOUT (INSTALL LOWER OUTBOARD HONEYCOMB PANEL) |
|   | ○ ◊ ▢ ▽ | MOVE TO 2122  | 280                         | ● ◊ ▢ ▽ INSTALL IN JIG                                    |
|   | ○ ◊ ▢ ▽ | DELAY   | 290                         | ● ◊ ▢ ▽ INSPECT ALIGNMENT                                 |
| 040   | ● ◊ ▢ ▽ | Plug all drain holes 2122 MABPCA                    | 300                         | ● ◊ ▢ ▽ REMOVE FROM JIG                                   |
|   | ○ ◊ ▢ ▽ |   | 310                         | ● ◊ ▢ ▽ REPLACE BAD FASTENERS                             |
|   | ○ ◊ ▢ ▽ |   | 320                         | ● ◊ ▢ ▽ REWORK DRAIN HOLES                                |
|   | ○ ◊ ▢ ▽ |   | 330                         | ● ◊ ▢ ▽ REPAIR BROOKES                                    |
| 050   | ● ◊ ▢ ▽ | Clean & Strip                                       | 340                         | ● ◊ ▢ ▽ ACCOMPLISH AERO SEALANT                           |
|   | ○ ◊ ▢ ▽ |   | 350                         | ● ◊ ▢ ▽ CLEAN/TREAT CORROSION                             |
| 060   | ● ◊ ▢ ▽ | ACCOMPLISH NDZ 2122 MABPCA                          |                             | ○ ◊ ▢ ▽ DELAY   |
|   | ○ ◊ ▢ ▽ | REMOVE 2122   |                             | ○ ◊ ▢ ▽ MOVE TO 2280                                      |
| 070   | ● ◊ ▢ ▽ | REPAIR (ALIGNMENT CHECK) 95 MABPAB                  |                             | ○ ◊ ▢ ▽ DELAY   |
| 100   | ● ◊ ▢ ▽ | REP/REP UPPER HONEYCOMB PANEL                       | 360                         | ● ◊ ▢ ▽ FINAL WASH + PAINT 2280 MABPCB                    |
| 110   | ● ◊ ▢ ▽ | REP/REP TRAILING EDGE                               |                             | ○ ◊ ▢ ▽ DELAY   |
| 120   | ● ◊ ▢ ▽ | REP/REP INBOARD RIB LONGERON                        |                             | ○ ◊ ▢ ▽ MOVE TO 95  |
| 130   | ● ◊ ▢ ▽ | REP/REP OUTBOARD RIB LONGERON                       |                             | ○ ◊ ▢ ▽ DELAY   |
| 140   | ● ◊ ▢ ▽ | REP/REP LOWER HONEYCOMB PANELS                      | 370                         | ● ◊ ▢ ▽ ATTACH + SERVICE BARRINGS 95 MABPAB               |
| 150   | ● ◊ ▢ ▽ | REPLACE CRACKED TRAILING EDGE RIBS                  | 380                         | ● ◊ ▢ ▽ REPLACE DEFECTIVE OVERLAP ATTACH PLATES           |
| 160   | ● ◊ ▢ ▽ | REPLACE CRACKED OR DAMAGED LEADING EDGE CLIPS, ETC. | 390                         | ● ◊ ▢ ▽ INSTALL FOREFLAPS                                 |
| 170   | ● ◊ ▢ ▽ | REPLACE LEADING EDGE NOSE RIBS & WEBS               | 400                         | ● ◊ ▢ ▽ REPLACE WORN OR DAMAGED SEALS                     |

SUBJECT \_\_\_\_\_ DATE 4/5  
PCN: 15188A WCD: 15153A WCD DATE: \_\_\_\_\_  
15189A  
CHART BEGINS \_\_\_\_\_ 2 of 2  
CHART ENDS \_\_\_\_\_ PREPARED BY: LARRY M.

[illegible]

1. 15153A \* WORK CONTROL DOCUMENT \* 1. DATE 88055 PAGE 1 OF 1

2. ORIO/PROD NR 13. QUANTITY 14. PROD SECTION/KCC 15. DATE 88055  
MBPAB 89093

7. PART NUMBER 19. ITEM SERIAL NR 18/12. TECH DATA/OPTIONAL  
1. STATEMENT OF WORK FILE  
10. MODEL/DESIGN/SERIES 11. STOCK NR 2. BILL IN ANY ADD'L  
C-135 WORK REQUIREMENTS.

13. RUCC 14. NOUN/END ITEM NOUN  
WING FLAP, GUIDO  
MILLER TITANIC, MAREBS/65261

| P/N         | NSN             | C/N    |
|-------------|-----------------|--------|
| 5-87851-145 | 1560006067423FL | 15153A |
| 5-87851-146 | 1560006067424FL | 15154A |
| 5-87851-136 | 1560006210789FL | 15171A |
| 5-87851-153 | 1560006470303FL | 15176A |
| 5-87851-154 | 1560006470304FL | 15177A |
| 5-87851-155 | 1560006566180FL | 15188A |
| 5-87851-156 | 1560006566181FL | 15189A |
| 5-87851-159 | 1560006566204FL | 15195A |
| 5-87851-160 | 1560006566205FL | 15196A |
| 5-87851-163 | 1560006609837FL | 15255A |

16. DJSP 16. PDN/ 17. WORK TO BE ACCOMPLISHED 18. MLCH 19. P 20. Q

|      |       |  |   |    |  |  |
|------|-------|--|---|----|--|--|
| 2122 | 010   | RECEIVE AND UNCRATE.   | ① | DC |  |  |
|      | MBPCD | REQ'D NOT REQ'D  |   |    |  |  |
| 2122 | 020   | CLEAN AND STRIP PAINT FROM FLAP  |   | 4W |  |  |
|      | MBPCA | (INCLUDE FLAP TRACK WELL) IAW 1C-135<br>(K)A-3-4, SEC. XI. NOTE: ON PDM LINE<br>GENERATED FLAP CLEAN FLAP TRACK WELL<br>AND CARRIAGE ASSYS. ASSURE ENTIRE<br>ASSY. IS FREE OF ALL DIRT, PAINT AND<br>GREASE. | ④ |    |  |  |
| 2122 | 030   | PLUG ALL DRAIN HOLES TO PREVENT<br>PAINT STRIPPER FROM ENLITING INTO<br>INTERIOR OF FLAP ASSY.<br>NOTE: OMIT IF PDM LINE GENERATED<br>FLAP.  |   | 4W |  |  |
| 95   | 040   | REMOVE FOREFLAPS & ASSURE FOR FLAP<br>SUPPLEMENTAL SHEET WILL ACCOMPANY<br>APPROPRIATE ITEM. SEE WCD 15154A.   | ② | DS |  |  |
| 95   | 050   | REMOVE 2 EA UPPER AND 2 EA LOWER<br>HONEYCOMB PANELS FOR ACCESS.   | ③ | DS |  |  |
| 2122 | 060   | ACCOMPLISH INTERIOR WASH, UPPER AND<br>LOWER FLAP FOR CORROSION. MOVE TO<br>MBPAB.<br>REQ'D NOT REQ'D  | ⑤ | 4W |  |  |
| 95   | 070   | ACCOMPLISH SHUTDOWN INSPECTION OF<br>FLAP IAW SOV. ANNOTATE DISCREPANCIES<br>NOTE: THE ITEM(S) INPUT ON THIS 959<br>WILL BE OVERHAULED IN ACCORDANCE   | ⑥ | DS |  |  |

(CONTINUED)



|  |       |                                    |           |             |   |  |        |  |  |
|--|-------|------------------------------------|-----------|-------------|---|--|--------|--|--|
| *****                                      |       |                                    |           |             |   |  |        |  |  |
| 15153A * WORK CONTROL DOCUMENT *           |       |                                    |           | DATE 8/1/79 |   |  | PAGE 6 |  |  |
| 115.01SP-16.PDN/                           |       |                                    |           |             |   |  |        |  |  |
| STATION/OP NO. 117.WORK TO BE ACCOMPLISHED |       |                                    |           | 118.FLIGHT/ |   |  | 119.WH |  |  |
|  |       | REQ'D                              | NOT REQ'D |             |   |  |        |  |  |
| 95   | 200   | REPLACE CRACKED NOSE END RING.     | DS        | /           |   |  |        |  |  |
|  | MBPAB | REQ'D                              | NOT REQ'D |             |   |  |        |  |  |
|  | 210   | ACCOMPLISH CLOSEOUT & INSPECT GILL | DS        | /           | / |  |        |  |  |
|  | MBPAB | OUTBOARD HONEYCOMB PANELS INCLUDES |           |             |   |  |        |  |  |
|  |       | INTERNAL CORROSION TREATMENT &     |           |             |   |  |        |  |  |
|  |       | REPLACEMENT OF DAMAGED FASTENERS.  |           |             |   |  |        |  |  |
|  |       | REQ'D                              | NOT REQ'D |             |   |  |        |  |  |
|  | 220   | ACCOMPLISH CLOSEOUT & INSPECT GILL |           |             |   |  |        |  |  |
|  | MBPAB | OUTBOARD HONEYCOMB PANELS INCLUDES |           |             |   |  |        |  |  |
|  |       | INTERNAL CORROSION TREATMENT AND   |           |             |   |  |        |  |  |
|  |       | REPLACEMENT OF DAMAGED FASTENERS.  |           |             |   |  |        |  |  |
|  |       | REQ'D                              | NOT REQ'D |             |   |  |        |  |  |
| 95   | 230   | REPLACE CRACKED OR WORN FLAP       | DS        | /           | / |  |        |  |  |
|  | MBPAB | CARRIAGES. INSURE FLAP IS IN PLACE |           |             |   |  |        |  |  |
|  |       | PRIOR TO FINAL ATTACHMENT.         |           |             |   |  |        |  |  |
|  |       | REQ'D                              | NOT REQ'D |             |   |  |        |  |  |
| 95   | 240   | REPAIR/REPLACE CRACKED OR DAMAGED  | DS        | /           | / |  |        |  |  |
|  | MBPAB | FAIRINGS.                          |           |             |   |  |        |  |  |
|  |       | REQ'D                              | NOT REQ'D |             |   |  |        |  |  |
| 95   | 250   | REMOVE GLASS DEPRESSOR AND PLUG    | DS        | /           | / |  |        |  |  |
|  | MBPAB | OPEN FASTENERS HOLES.              |           |             |   |  |        |  |  |
|  |       | REQ'D                              | NOT REQ'D |             |   |  |        |  |  |
| 95   | 260   | ACCOMPLISH CLOSEOUT AND INSTALL    | DS        | /           | / |  |        |  |  |
|  | MBPAB | LOWER INBOARD HONEYCOMB PANEL.     |           |             |   |  |        |  |  |
|  |       | INCLUDES INTERNAL CORROSION        |           |             |   |  |        |  |  |
|  |       | TREATMENT AND REPLACEMENT OF       |           |             |   |  |        |  |  |
|  |       | IMPAIRED FASTENERS.                |           |             |   |  |        |  |  |
|  |       | REQ'D                              | NOT REQ'D |             |   |  |        |  |  |
| 95   | 270   | ACCOMPLISH CLOSEOUT AND INSTALL    | DS        | /           | / |  |        |  |  |
|  | MBPAB | LOWER OUTBOARD HONEYCOMB PANEL.    |           |             |   |  |        |  |  |
|  |       | INCLUDES INTERNAL CORROSION        |           |             |   |  |        |  |  |
|  |       | TREATMENT AND REPLACEMENT OF       |           |             |   |  |        |  |  |
|  |       | IMPAIRED FASTENERS.                |           |             |   |  |        |  |  |
|  |       | REQ'D                              | NOT REQ'D |             |   |  |        |  |  |
| 95   | 280   | INSTALL WING FLAP IN REPAIR JIG    | DS        | /           | / |  |        |  |  |
|  | MBPAB | P/N 590CA1030.                     |           |             |   |  |        |  |  |
| 95   | 290   | ACCOMPLISH INSPECTION & ALIGNMENT  | DS        | /           | / |  |        |  |  |
|  | MBPAB | CHECK PRIOR TO REMOVAL FROM JIG.   |           |             |   |  |        |  |  |
| 95   | 300   | REMOVE FLAP FROM REPAIR FIXTURE.   | DS        | /           | / |  |        |  |  |
|  | MBPAB |                                    |           |             |   |  |        |  |  |
| 95   | 310   | REPLACE ALL EX. DAMAGED/LOOSE      | DS        | /           | / |  |        |  |  |
|  | MBPAB | PULLED OR BENT FASTENERS.          |           |             |   |  |        |  |  |
|  |       | REQ'D                              | NOT REQ'D |             |   |  |        |  |  |

OK  
MBPAB



(CONTINUED)

| *****          |   |                      |      |    |      |
|----------------|---|----------------------|------|----|------|
| 10100A         | WORK CONTROL DOCUMENT   | 1. DATE CHANGES      | TABL | OR | 1980 |
| 115.DEP        | LG.PONV   |                      |      |    |      |
| STATION/OP NO. | 117.WORK TO BE ACCOMPLISHED   | 118.FLIGHT/TEST/PROG |      |    |      |
|                | OR - 3127 AND 65-7360-7 AND 65-7360-3129 INSTALLED.<br>FLAP AGGT. 1560006666181PL WILL HAVE<br>FOREFLAPS FOR 65-7360-10 OF 3127<br>AND 65-7360-6 OR 65-7360-3127  |                      |      |    |      |
| 430            | REPLACE ALL BURN OR DAMAGED SEALS.<br>REPAIR ALL CRACKS IN REINFORCED CONCRETE<br>NOTES: NON STOCKED PARTS & MATERIALS<br>WILL BE LOCALLY FABRICATED IF<br>NECESSARY.<br>NOTE: OVERHAUL OF FLAP ASSEMBLY BE<br>ACCOMPLISHED IAW DML 5-87003 & JTR<br>SPECIFICATIONS TO INSURE CORRECT<br>ALIGNMENT & ADJUSTMENT. REMOVAL OF<br>MORE THAN 2 PANELS AT ONE TIME WITH<br>EXPOSED JOINTS TO BE PLACED IN<br>FIXTURE 57051030.<br>NOTE: USE GRIND & PANELS REQUIRED AS<br>TEMPLATE TO DETERMINE SIZE,<br>LOCATION & SPACING OF RIVETS HOLES.<br>NOTE: REPLACEMENT OF HIGHLOUND<br>PANELS THAT REQUIRE EDGE TRIMMING<br>WILL HAVE THOSE EDGES RESEALED PRIOR<br>TO INSTALLATION WITH MIL-S-8833.<br>LOWER PANELS THAT REQUIRE DRAIN<br>HOLES WILL HAVE THE EDGES OF THE<br>SEALING BEING CAREFUL NOT TO LET<br>EXCESS SEALER CREATE A DAMPING<br>EFFECT. ALL FASTENERS WILL BE INST.<br>WET USING MIL-S-81733 (MIL-S-8807)<br>OR EPOXY PAINT MIL P2337 MAY BE USED<br>AS AN OPTION. |                      |      |    |      |
| 430            | WORK COMPLETED. CONDITION TAG<br>DATE _____<br>JAW AFM 67-1<br>MOVE TO CRATING<br>NOTE: MOVE TO AIRCRAFT IF FROM LINE<br>GENERATED FLAP.<br>SERIAL# _____ DATE _____<br>NOTE: PART WILL HAVE OC-ALC FORM 506<br>587, & 588 IDENTIFICATION LABELS<br>APPLIED TO COMPLETE ITEM IAW AFMCR<br>66-51.<br>ACCEPTANCE DATE ON THE LABEL ALONG<br>WITH "M" STAMP TO THE PERSON<br>PERFORMING THE OVERHAUL.<br>CAUTION: SURFACE TO WHICH LABELS ARE<br>APPLIED MUST BE FREE OF DIRT  |                      |      |    |      |
|                | COORDINATION  | DATE                 |      |    |      |
|                | MABLEFS MICHAEL T. HARRIS   | 23 FEB 88            |      |    |      |
|                | MABSFS PHIL DUNCAN  | 23 FEB 88            |      |    |      |
|                | MABPAB M.A. BERRY   | 23 FEB 88            |      |    |      |

(CONTINUED)

118. FILED IN 1-11-2000

23 FEB 68

NOTE:

THIS FOREFLAP  
COMES OFF 15153A  
AT OPERATION 40  
OR 30 IN THE NEW  
SEQUENCE. AND IS  
ASSEMBLY IN OPS 390.

# FLOW PROCESS CHART

SUBJECT WING FLAP, OUTBOARD FORE FLAP DATE 4/5/89

PCN: 15188A WCD: 15154A WCD DATE: 88055  
15189A

CHART BEGINS \_\_\_\_\_ PAGE 1 OF 1

CHART ENDS \_\_\_\_\_ PREPARED BY: R. BOLANOS

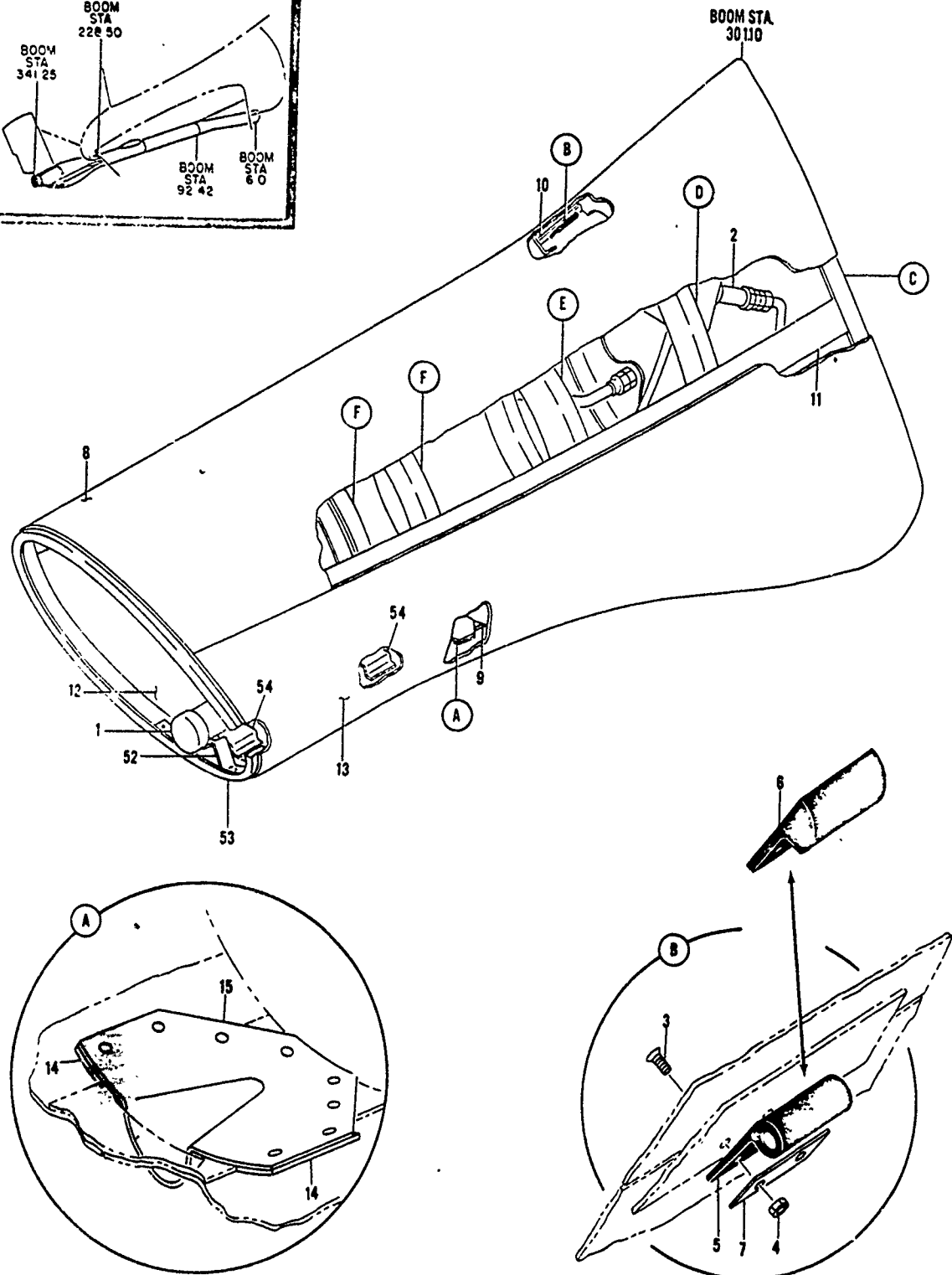
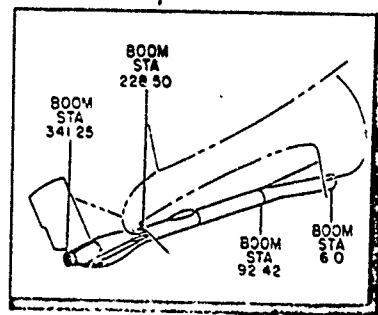
| WCD<br>OP<br># | SYMBOLS | DESCRIPTION                               | WCD<br>OP<br># | SYMBOLS | DESCRIPTION   |
|----------------|---------|---|----------------|---------|---|
|                |         | DELAY<br>MABPAB                           |                |         | DELAY   |
|                |         | MOVE TO WASH ?<br>STRIP<br>MABPCA         | 140<br>145     |         | WORK COMPLETE TAG   |
|                |         | DELAY                                     |                |         | DELAY   |
| 05             |         | STRIP & WASH<br>2122<br>MABPCA            |                |         | IF PDM MOVE TO AIRCRAFT LINE<br>OTHERWISE MOVE TO CRATING |
|                |         | DELAY                                     |                |         |   |
|                |         | MOVE TO X-RAY (From 30)<br>3001<br>MABPCA |                |         |   |
|                |         | DELAY                                     |                |         |   |
| 20             |         | X-RAY FORE FLAP                           |                |         |   |
|                |         | DELAY                                     |                |         |   |
|                |         | MOVE TO SHEETMETAL<br>95<br>MABPAB        |                |         |   |
|                |         | DELAY                                     |                |         |   |
| 30             |         | R/R PIN                                   |                |         |   |
| 40             |         | SHAKEDOWN ACC EYE                         |                |         |   |
| 50             |         | CHECK FOR CORROSION                       |                |         |   |
| 55             |         | R/R BRACKET                               |                |         |   |
| 60             |         | R/R EXTERIOR SKINS &<br>CLEAN             |                |         |   |
| 80             |         | R/R RIBS                                  |                |         |   |
| 90             |         | R/R END ATTACH PLATE                      |                |         |   |
| 100            |         | R/R INTERNAL RIB                          |                |         |   |
| 110            |         | REPLACE R/R STRIP                         |                |         |   |
| 120            |         | REPLACE DEFECTIVE RIVETS                  |                |         |   |
| 130            |         | " CRACKED TRAILING<br>EDGE EXTRUSION      |                |         |   |
|                |         | DELAY                                     |                |         |   |
|                |         | MOVE TO WASH / PAINT<br>2200<br>MABPCA    |                |         |   |
|                |         | DELAY                                     |                |         |   |
| 140            |         | FINAL WASH & TREAT<br>FOR CORROSION       |                |         |   |
| 150            |         | PAINT                                     |                |         |   |
|                |         | DELAY                                     |                |         |   |
|                |         | MOVE TO SHEETMETAL<br>95<br>MABPAB        |                |         |   |

| *****  |        |                                      |    |   |   |  |  |  |  |
|--|--------|--------------------------------------|----|---|---|--|--|--|--|
| 1515-A WORK CONTROL DOCUMENT - BULK 1. DATE MOVED PAGE 1 OF 2              |        |                                      |    |   |   |  |  |  |  |
| *****  |        |                                      |    |   |   |  |  |  |  |
| 12. ORIG/PROD NR 13. QUANTITY 14. PROD SECTION/REL 15. DATE MOVED 16. DATE |        |                                      |    |   |   |  |  |  |  |
| 17. PART NUMBER 19. ITEM SERIAL NR 18/12. TECH DATA/OPTIONAL               |        |                                      |    |   |   |  |  |  |  |
| 10. MOD. E. DESIGN/SERIES 11. STOCK NR                                     |        |                                      |    |   |   |  |  |  |  |
| 13. DISC 14. NOON/END ITEM NOON  |        |                                      |    |   |   |  |  |  |  |
| 15. DISC 16. PDR   |        |                                      |    |   |   |  |  |  |  |
| 17. WORK TO BE ACCOMPLISHED  |        |                                      |    |   |   |  |  |  |  |
| 18. NCL 19. P 20. R  |        |                                      |    |   |   |  |  |  |  |
| 212  | 005    | STRIP AND WASH FORE FLAP             | 4W | / | / |  |  |  |  |
|  | MBPAB  | IAW IC-135(R)A-3-4                   |    |   |   |  |  |  |  |
|  |        | MOVE TO MCCIA                        |    |   |   |  |  |  |  |
| 3001   | 020    | X-RAY FOR FLAP, IF SKIN IS NOT       | RN | N | / |  |  |  |  |
|  | MCCIA  | REMOVED. NO STAMP REQUIRED           |    |   |   |  |  |  |  |
|  |        | IAW IC 135-36 SECTION PART 2.        |    |   |   |  |  |  |  |
| 95   | 030    | IF P/N 65-7360-7 OR 8 IS INSTALLED   | DS | / | / |  |  |  |  |
|  | MABPAB | REPLACE WITH 65-7360 3129 & 3130     |    |   |   |  |  |  |  |
|  |        | REQ'D NOT REQ'D                      |    |   |   |  |  |  |  |
| 95   | 040    | ACC E&I SHAKEDOWN                    | DS | / | / |  |  |  |  |
|  | MABPAB |                                      |    |   |   |  |  |  |  |
| 95   | 045    | CHECK FOREFLAP FOR CORROSION AND     | DS | / | / |  |  |  |  |
|  | MABPAB | WORK IF ANY IS FOUND                 |    |   |   |  |  |  |  |
|  |        | REQ'D NOT REQ'D                      |    |   |   |  |  |  |  |
| 95   | 055    | CHECK MOUNTING BOLTS IN ATTACHMENT   | DS | / | / |  |  |  |  |
|  | MABPAB | BRACKET TO SEE IF WITHIN TOLERANCES. |    |   |   |  |  |  |  |
|  |        | REQ'D NOT REQ'D                      |    |   |   |  |  |  |  |
| 95   | 060    | REPAIR/REPLACE EXTERIOR SKINS        | DS | / | / |  |  |  |  |
|  | MABPAB | IAW IC-135(R)A-3.1, FIG 10-5         |    |   |   |  |  |  |  |
|  |        | (INCLUDES CLEAN & FLAREOUT).         |    |   |   |  |  |  |  |
|  |        | REQ'D NOT REQ'D                      |    |   |   |  |  |  |  |
| 95   | 080    | REPLACE END RIB.                     | DS | / | / |  |  |  |  |
|  | MABPAB | REQ'D NOT REQ'D                      |    |   |   |  |  |  |  |
| 95   | 090    | REPLACE END ATTACHMENT               | DS | / | / |  |  |  |  |
|  | MABPAB | REQ'D NOT REQ'D                      |    |   |   |  |  |  |  |

|   |        |                                      |           |  |  |  |  |  |  |
|---|--------|--------------------------------------|-----------|--|--|--|--|--|--|
| *****   |        |                                      |           |  |  |  |  |  |  |
| 15154A * WORK CONTROL DOCUMENT * MSTR 1 DATE 00055 PAGE 2 |        |                                      |           |  |  |  |  |  |  |
| 16.00N  |        |                                      |           |  |  |  |  |  |  |
| 17.00N 117.00N TO BE ACCOMPLISHED                         |        |                                      |           |  |  |  |  |  |  |
| 95  | 100    | REPLACE INTERNAL RIBS ON FIELD       | DS        |  |  |  |  |  |  |
|   | MABPAB | REPAIRED RIBS.                       |           |  |  |  |  |  |  |
|   |        | REQ'D..... NOT REQ'D.....            |           |  |  |  |  |  |  |
| 105   | 110    | REPLACE RUB STRIPS.....              | DS        |  |  |  |  |  |  |
|   | MABPAB | REQ'D..... NOT REQ'D.....            |           |  |  |  |  |  |  |
| 125   | 120    | REPLACE MISSING OR DEFECTIVE RIVETS. | DS        |  |  |  |  |  |  |
|   | MABPAB | REQ'D..... NOT REQ'D.....            |           |  |  |  |  |  |  |
| 145   | 130    | REPLACE EXPOSED RAILING EDGE         | DS        |  |  |  |  |  |  |
|   | MABPAB | EXTRUSION.                           |           |  |  |  |  |  |  |
|   |        | REQ'D..... NOT REQ'D.....            |           |  |  |  |  |  |  |
|   |        | MOVE TO MABPAB.                      |           |  |  |  |  |  |  |
| 2000  | 140    | FINAL WASH & CORROSION TREAT         | DS        |  |  |  |  |  |  |
|   | MABPAB | NOTE: UNIT IF PDM LINE GENERATED     |           |  |  |  |  |  |  |
|   |        | FLAP                                 |           |  |  |  |  |  |  |
| 2200  | 150    | PREPARE & PAINT JAW TO EXPOSED 3 & 5 | DS        |  |  |  |  |  |  |
|   | MABPAB | 1 1 G USING MIL P 87112 POLYURETHANE |           |  |  |  |  |  |  |
|   |        | PRIMER & HIGH GLOSS GRAY MIL-O-83262 |           |  |  |  |  |  |  |
|   |        | COLOR 16473 PAINT.                   |           |  |  |  |  |  |  |
|   |        | UNIT IF PDM LINE GENERATED FLAP.     |           |  |  |  |  |  |  |
|   |        | MOVE TO MABPAB,BLDG. 75              |           |  |  |  |  |  |  |
| 95  | 160    | NOTE: MOVE TO AIRCRAFT SERIAL#.....  | DS        |  |  |  |  |  |  |
|   | MABPAB | DATE.....                            |           |  |  |  |  |  |  |
|   |        | IF PDM LINE GENERATED FLAP.          |           |  |  |  |  |  |  |
| 95  | 165    | WORK COMPLETED, CONDITION TAG JAW    | DS        |  |  |  |  |  |  |
|   | MABPAB | AFM 67-1.                            |           |  |  |  |  |  |  |
|   |        | MOVE TO CRATING. DATE.....           |           |  |  |  |  |  |  |
|   | 170    | MABEFS MICHAEL TITARI                | 23 FEB 88 |  |  |  |  |  |  |
|   |        | MABEFS PHIL DUNCAN                   | 23 FEB 88 |  |  |  |  |  |  |
|   |        | MABPAB M. A. MCCOY                   | 23 FEB 88 |  |  |  |  |  |  |
|   |        | MABBF TED HAYES                      | 23 FEB 88 |  |  |  |  |  |  |

| FIGURE &<br>INDEX NO. | PART NUMBER  | DESCRIPTION  | UNITS<br>PER<br>ASSY | USE<br>ON<br>CODE |
|-----------------------|--------------|--|----------------------|-------------------|
|                       |              | 1 2 3 4 5 6 7  |                      |                   |
| 1892 -                | 50-4694-1    | TAIL CONE ASSY, STATION 301.10 TO 341.25, BOOM . . . . .<br>(FOR REPLACEMENT ORDER 50-4694-18) (FOR NHA SEE<br>FIG. 1890)      | REF                  | A                 |
|                       | 50-4694-18   | TAIL CONE ASSY, STATION 301.10 TO 341.25, BOOM (FOR . .<br>NHA SEE FIG. 1890)  | REF                  |                   |
|                       | 50-4694-2C   | TAIL CONE ASSY, STATION 301.10 TO 341.35, BOOM (FOR . .<br>SPARES ONLY) (PARTS KITS AVAILABLE)<br>PARTIAL BREAKDOWN FOLLOWS    | REF                  |                   |
| 1                     | 50-5125      | • LIGHT INSTL, TAIL CONE, BOOM (FOR BREAKDOWN SEE . . .<br>FIG. 1893)  | REF                  | C                 |
| 1                     | 50-5125-1    | • LIGHT INSTL, TAIL CONE, BOOM (FOR BREAKDOWN SEE . . .<br>FIG. 1893)  | REF                  | D                 |
| 2                     | 5-961 2-53   | • HYDRAULIC INSTL, FLYING BOOM (FOR BREAKDOWN SEE . . .<br>FIG. 1929)  | REF                  |                   |
|                       | 50-4694-2    | • STRUCTURE ASSY, TAIL CONE, STATION 301.10 TO 341.25,<br>BOOM   | REF                  | A                 |
|                       | 50-4694-19   | • STRUCTURE ASSY, TAIL CONE, STATION 301.10 TO 341.25,<br>BOOM (USED ON 50-4694-16)  | REF                  | B                 |
|                       | 50-4694-21   | • STRUCTURE ASSY, TAIL CONE, STATION 301.10 TO 341.25,<br>BOOM (USED ON 50-4694-20)  | REF                  |                   |
| 3                     | NAS514P632-6 | • SCREW (X) (LH) . . . . .   | 2                    | G                 |
| 4                     | NAS519A066   | • NUT (X) (LH) . . . . .   | 2                    | G                 |
| 5                     | 50-4694-12   | • BUMPER, TAIL CONE, STATION 301.10 TO 341.25, BOOM . .  | REF                  | H                 |
| 6                     | 50-4694-11   | • BUMPER, TAIL CONE, STATION 301.10 TO 341.25, BOOM . .  | REF                  | J                 |
| 6                     | 50-4694-16   | • BUMPER, TAIL CONE, STATION 301.10 TO 341.25, BOOM . .  | 1                    | K                 |
| 7                     | 50-4694-10   | • STRAP, TAIL CONE, STATION 301.10 TO 341.25, BOOM . .<br>(MAKE FROM 2024-T6 ALUM CLAD 0.051 THK. APPROX.<br>SIZE 1.10 X 1.00) | REF                  | G                 |
| 8                     | 50-4694-9    | • SKIN, TAIL CONE, STATION 301.10 TO 341.25, BOOM . .  | 1                    |                   |
|                       | 50-4694-3    | • WELD ASSY, TAIL CONE, STATION 301.10 TO 341.25, . .<br>BOOM  | REF                  | L                 |
|                       | 50-4694-15   | • WELD ASSY, TAIL CONE, STATION 301.10 TO 341.25, . .<br>BOOM  | REF                  | M                 |
| 9                     | 50-4694-4    | • SPLICE, TAIL CONE, STATION 301.10 TO 341.25, BOOM . .  | REF                  | L                 |
| 9                     | 50-4694-14   | • SPLICE, TAIL CONE, STATION 301.10 TO 341.25, BOOM . .  | REF                  | M                 |
| 10                    | 50-4694-5    | • SPLICE, TAIL CONE, STATION 301.10 TO 341.25, BOOM . .  | REF                  |                   |
| 11                    | 50-4694-6    | • SPLICE, TAIL CONE, STATION 301.10 TO 341.25, BOOM . .  | REF                  |                   |
| 12                    | 50-4694-7    | • SKIN, LOWER, TAIL CONE, STATION 301.10 TO 341.25<br>BOOM (LH)  | 1                    |                   |
| 13                    | 50-4694-8    | • SKIN, LOWER, TAIL CONE, STATION 301.10 TO 341.25<br>BOOM (LH)  | 1                    |                   |
| 14                    | 50-4694-13   | • FILLER, TAIL CONE, STATION 301.10 TO 341.25 . . . .  | REF                  | N                 |
| 15                    | 66-2944      | • CUP, DRAIN, TAIL CONE, BOOM FAIRING . . . . .  | 1                    | P                 |
|                       | 50-5135      | • FRAME INSTL, STATION 301.10, BOOM (USED ON . . . .<br>50-4694-21)  | REF                  | A                 |
|                       | 50-5135-6    | • FRAME INSTL, STATION 301.10, BOOM (USED ON . . . .<br>50-4694-19)  | REF                  | B                 |
|                       | 50-5135-9    | • FRAME INSTL, TAIL CONE, STATION 301.10, BOOM (USED<br>ON 50-4694-21)   | REF                  |                   |
| 16                    | 50-5135-3    | • SPLICE, TAIL CONE, STATION 301.10, BOOM . . . . .  | 1                    |                   |
| 17                    | 50-5135-4    | • SPLICE, TAIL CONE, STATION 301.10, BOOM . . . . .  | REF                  |                   |
| 18                    | 50-5135-5    | • FILLER, TAIL CONE, STATION 301.10, BOOM . . . . .  | 2                    |                   |
| 19                    | 50-5135-5    | • FILLER, TAIL CONE, STATION 301.10, BOOM (USED ON<br>50-5135, -6)   | 16                   |                   |
| 20                    | 50-5135-10   | • TAB, TAIL CONE, STATION 301.10, BOOM (USED ON . .<br>50-5135-9)  | REF                  |                   |
| 21                    | 50-5135-1    | • FRAME, HALF, TAIL CONE, STATION 301.10, BOOM . .   | 1                    | A                 |
| 22                    | 50-5135-7    | • FRAME, HALF, TAIL CONE, STATION 301.10, BOOM . .   | 1                    | A                 |
| 23                    | 50-5135-2    | • FRAME, HALF, TAIL CONE, STATION 301.10, BOOM . .   | 1                    | A                 |
| 24                    | 50-5135-8    | • FRAME, HALF, TAIL CONE, STATION 301.10, BOOM . .   | 1                    | A                 |
|                       | 50-6037      | • FRAME INSTL, TAIL CONE, STATION 309.15, BOOM . . . .   | REF                  |                   |
| 25                    | 50-6037-4    | • CHANNEL, FRAME SPLICE, TAIL CONE, STATION . . . .<br>309.15, BOOM  | 1                    |                   |
| 26                    | 50-6037-3    | • CHANNEL, FRAME SPLICE, TAIL CONE, STATION . . . .<br>309.15, BOOM  | 1                    |                   |
| 27                    | 50-6037-5    | • STRIP, FRAME REINFORCING, TAIL CONE, STATION . .<br>309.15, BOOM   | REF                  |                   |
| 28                    | 50-6037-6    | • STRIP, FRAME REINFORCING, TAIL CONE, STATION . .<br>309.15, BOOM   | REF                  |                   |
| 29                    | 50-6037-7    | • BRACKET, FRAME TEE, TAIL CONE, STATION . . . . .<br>309.15, BOOM   | 1                    | P                 |
| 30                    | 50-6037-1    | • FRAME, HALF, TAIL CONE, STATION 309.15, BOOM . .   | 1                    |                   |
| 31                    | 50-6037-2    | • FRAME, HALF, TAIL CONE, STATION 309.15, BOOM . .   | 1                    |                   |

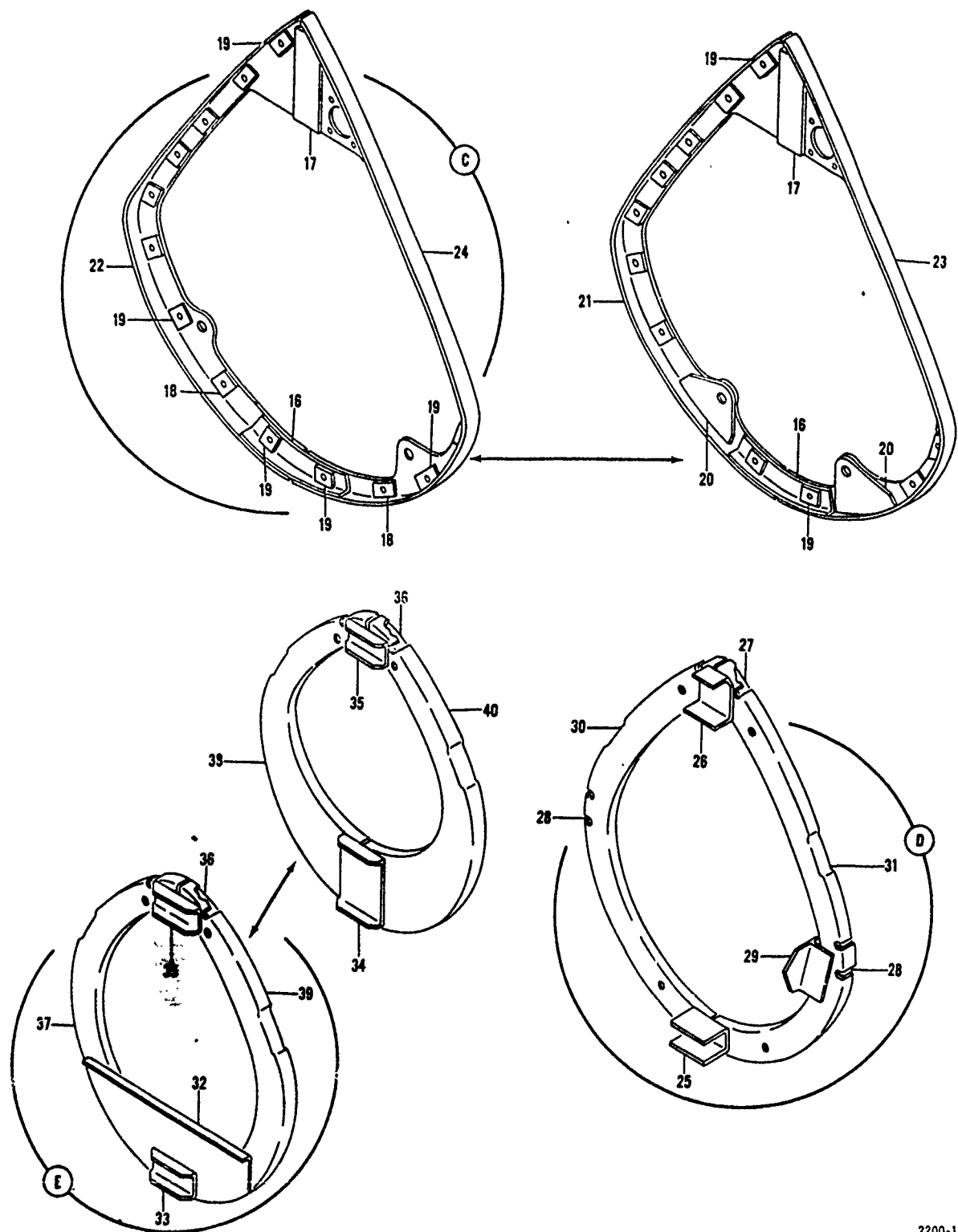
# Aerial Refueling Boom



2200-1892a

Figure 1892. Boom Station 301.10 to 341.25 Tail Cone Assembly (Sheet 1 of 3)

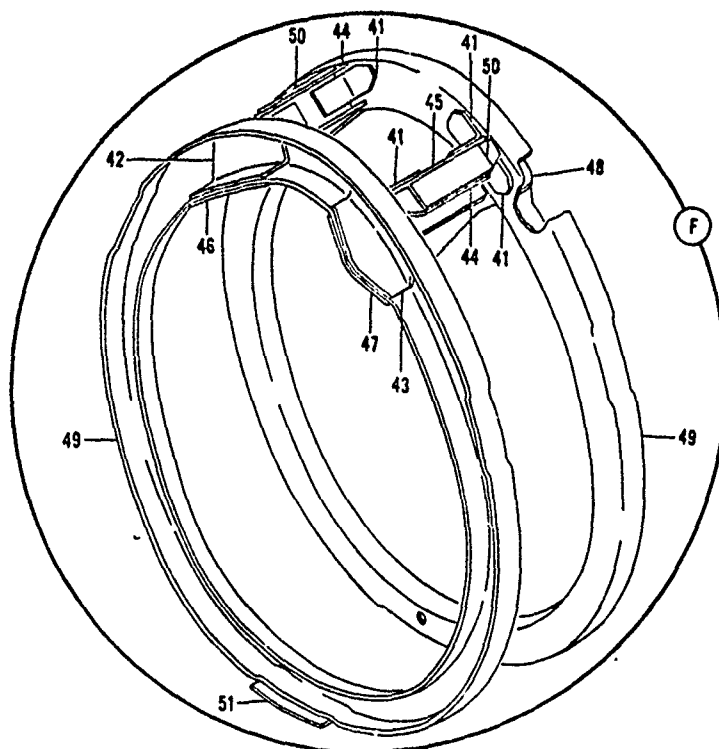


**Aerial Refueling Boom**

2200-1892b

**Figure 1892. Boom Station 301.10 to 341.25 Tail Cone Assembly (Sheet 2 of 3)**

## Aerial Refueling Boom



2200-1892c

Figure 1892. Boom Station 301.10 to 341.25 Tail Cone Assembly (Sheet 3 of 3)

| FIGURE &<br>INDEX NO. | PART NUMBER  | DESCRIPTION  |    |    |    |    |    |    | UNITS<br>PER<br>ASSY | USE<br>ON<br>CODE |
|-----------------------|--------------|--------------|----|----|----|----|----|----|----------------------|-------------------|
|                       |              | 1            | 2  | 3  | 4  | 5  | 6  | 7  |                      |                   |
| 1892 -                | 50-6034      | ..           | .. | .. | .. | .. | .. | .. | REF                  | L                 |
|                       | 50-6034-6    | ..           | .. | .. | .. | .. | .. | .. | REF                  | M                 |
| 32                    | 66-2936      | ..           | .. | .. | .. | .. | .. | .. | REF                  | P                 |
| 33                    | 50-6034-3    | ..           | .. | .. | .. | .. | .. | .. | REF                  | L                 |
|                       |              | 317.20, BOOM |    |    |    |    |    |    |                      |                   |
| 34                    | 50-6034-9    | ..           | .. | .. | .. | .. | .. | .. | 1                    | M                 |
|                       |              | 317.20, BOOM |    |    |    |    |    |    |                      |                   |
| 35                    | 50-6034-4    | ..           | .. | .. | .. | .. | .. | .. | 1                    |                   |
|                       |              | 317.20, BOOM |    |    |    |    |    |    |                      |                   |
| 36                    | 50-6034-5    | ..           | .. | .. | .. | .. | .. | .. | 1                    |                   |
|                       |              | 317.20, BOOM |    |    |    |    |    |    |                      |                   |
| 37                    | 50-6034-1    | ..           | .. | .. | .. | .. | .. | .. | REF                  | L                 |
| 38                    | 50-6034-2    | ..           | .. | .. | .. | .. | .. | .. | 1                    | M                 |
| 39                    | 50-6034-3    | ..           | .. | .. | .. | .. | .. | .. | REF                  | L                 |
| 40                    | 50-6034-4    | ..           | .. | .. | .. | .. | .. | .. | 1                    | M                 |
|                       | 50-6012      | ..           | .. | .. | .. | .. | .. | .. | REF                  |                   |
|                       | 50-6012-7    | ..           | .. | .. | .. | .. | .. | .. | REF                  |                   |
|                       |              | (KD)         |    |    |    |    |    |    |                      |                   |
| 42                    | 50-6012-5    | ..           | .. | .. | .. | .. | .. | .. | 1                    |                   |
| 43                    | 50-6012-6    | ..           | .. | .. | .. | .. | .. | .. | 1                    |                   |
| 44                    | 50-6012-3    | ..           | .. | .. | .. | .. | .. | .. | 2                    |                   |
| 45                    | 50-6012-4    | ..           | .. | .. | .. | .. | .. | .. | 2                    |                   |
| 46                    | 50-6012-1    | ..           | .. | .. | .. | .. | .. | .. | REF                  |                   |
|                       |              | TAIL CONE    |    |    |    |    |    |    |                      |                   |
| 47                    | 50-6012-2    | ..           | .. | .. | .. | .. | .. | .. | REF                  |                   |
|                       |              | TAIL CONE    |    |    |    |    |    |    |                      |                   |
| 48                    | 50-6012-9    | ..           | .. | .. | .. | .. | .. | .. | REF                  |                   |
| 49                    | 50-6012-8    | ..           | .. | .. | .. | .. | .. | .. | 2                    |                   |
| 50                    | BACS40A15-48 | ..           | .. | .. | .. | .. | .. | .. | AR                   |                   |
|                       |              | (KD)         |    |    |    |    |    |    |                      |                   |

| FIGURE &<br>INDEX NO. | PART NUMBER   | DESCRIPTION  | UNITS<br>PER<br>ASSY | USE<br>ON<br>CODE |
|-----------------------|---------------|--|----------------------|-------------------|
|                       |               | 1 2 3 4 5 6 7  |                      |                   |
| 1892 -                |               |  |                      |                   |
| 51                    | BACS40B13-320 | . . . SHIM, LAM, 0.062 THK (ALTERNATES BACS40C13-320, .<br>BACS40D13-320) (KD)   | AK                   |                   |
|                       | 50-6043       | . . FRAME INSTL, FAIRING, STATION 333.46 TO . . . . .<br>341.25, BOOM  | REF                  | E                 |
|                       | 50-6043-3     | . . FRAME INSTL, FAIRING, STATION 333.46 TO . . . . .<br>341.25, BOOM  | REF                  | N                 |
|                       | 50-6043-5     | . . FRAME INSTL, FAIRING, STATION 333.46 TO . . . . .<br>341.25, BOOM  | REF                  | M                 |
| 52                    | 50-6043-2     | . . . BRACKET, FRAME LIGHT SUPPORT, FAIRING, STATION .<br>333.46 TO 341.25, BOOM   | REF                  | L                 |
| 53                    | 50-6043-1     | . . . FRAME, FAIRING, STATION 333.46 TO 341.25, BOOM .   | REF                  | E                 |
| 53                    | 50-6043-4     | . . . FRAME, FAIRING, STATION 333.46 TO 341.25, BOOM .   | REF                  | N                 |
| 53                    | 50-6043-6     | . . . FRAME, FAIRING, STATION 333.46 TO 341.25, BOOM .   | 1                    | M                 |
| 54                    | 66-18464-1    | . . . BRACKET, NOZZLE LIGHT SUPPORT, REFUELING BOOM . .<br>(MAKE FROM 9535 2024-D CLAU QQ-A-362 TEMPER<br>4.0 X 1.5 X 0.032) | 2                    |                   |
|                       |               | A BOOM UNIT 1-1 THRU 1-119   |                      |                   |
|                       |               | B BOOM UNIT 3-120 AND ON   |                      |                   |
|                       |               | C BOOM UNIT 1-1 THRU 1-99  |                      |                   |
|                       |               | D BOOM UNIT 1-100 AND ON   |                      |                   |
|                       |               | E BOOM UNIT 1-1 THRU 1-3   |                      |                   |
|                       |               | F BOOM UNIT 1-4 THRU 1-119   |                      |                   |
|                       |               | G BOOM UNIT 1-5 AND ON   |                      |                   |
|                       |               | H BOOM UNIT 1-5 THRU 1-11  |                      |                   |
|                       |               | J BOOM UNIT 1-12 THRU 1-29   |                      |                   |
|                       |               | K BOOM UNIT 1-30 AND ON  |                      |                   |
|                       |               | L BOOM UNIT 1-1 THRU 1-16  |                      |                   |
|                       |               | M BOOM UNIT 1-17 AND ON  |                      |                   |
|                       |               | N BOOM UNIT 1-4 THRU 1-16  |                      |                   |
|                       |               | P BOOM UNIT 1-4 AND ON   |                      |                   |

# FLOW PROCESS CHART

SUBJECT Beam Tail Cone

DATE 4/5/89

PCN: 15175A WCD: 15175A WCD DATE: 89073

CHART BEGINS Operation 010

CHART ENDS Operation 440

PREPARED BY: Tim Hall

see supplementary  
sheet for  
020 + 030

| SYMBOLS       | DESCRIPTION                        | SYMBOLS       | DESCRIPTION                                 |
|---------------|------------------------------------|---------------|---|
| 010 ● ◊ ◊ ◊ ◊ | Receive and Unrate<br>2122 MABP60  | 210 ● ◊ ◊ ◊ ◊ | Repair AFT Frame Supt<br>6012-8             |
| 020 ○ ◊ ◊ ◊ ◊ | Delay                              | 230 ● ◊ ◊ ◊ ◊ | Repair Frame<br>6043-6                      |
| 030 ○ ◊ ◊ ◊ ◊ | Move to Bldg 95<br>95 MABPAB       | 240 ● ◊ ◊ ◊ ◊ | Repair Defective fasteners<br>d/c Nut plate |
| 040 ○ ◊ ◊ ◊ ◊ | Delay                              | 250 ● ◊ ◊ ◊ ◊ | Replace cup drain                           |
| 050 ● ◊ ◊ ◊ ◊ | Remove Hyd Tubing<br>& valves      | 260 ● ◊ ◊ ◊ ◊ | Replace bumper<br>4694-11                   |
| 060 ● ◊ ◊ ◊ ◊ | Remove all wiring<br>& lights      | 270 ● ◊ ◊ ◊ ◊ | Replace strap<br>4694-10                    |
| 070 ○ ◊ ◊ ◊ ◊ | Delay                              | 280 ● ◊ ◊ ◊ ◊ | Replace support                             |
| 080 ○ ◊ ◊ ◊ ◊ | Move to 2122                       | 290 ● ◊ ◊ ◊ ◊ | Replace 2 eq. isolator<br>vibrators         |
| 090 ○ ◊ ◊ ◊ ◊ | Delay                              | 300 ● ◊ ◊ ◊ ◊ | Treat corrosion                             |
| 100 ● ◊ ◊ ◊ ◊ | Strip paint<br>2122 MABPAB         | 310 ● ◊ ◊ ◊ ◊ | Remove Tail Cone<br>From Fixture            |
| 110 ○ ◊ ◊ ◊ ◊ | Delay                              | 320 ○ ◊ ◊ ◊ ◊ | Delay                                       |
| 120 ○ ◊ ◊ ◊ ◊ | Move To 95<br>95 MABPAB            | 330 ○ ◊ ◊ ◊ ◊ | Move To Bldg 2280<br>2280 MABPAB            |
| 130 ○ ◊ ◊ ◊ ◊ | Delay                              | 340 ○ ◊ ◊ ◊ ◊ | Delay                                       |
| 140 ● ◊ ◊ ◊ ◊ | Shakedown                          | 350 ● ◊ ◊ ◊ ◊ | Wash  |
| 150 ● ◊ ◊ ◊ ◊ | Install Tail Cone                  | 360 ● ◊ ◊ ◊ ◊ | Paint                                       |
| 160 ● ◊ ◊ ◊ ◊ | Repair Skin - 9                    | 370 ● ◊ ◊ ◊ ◊ | Paint - anti-corrosion                      |
| 170 ● ◊ ◊ ◊ ◊ | Replace splice                     | 380 ○ ◊ ◊ ◊ ◊ | Delay                                       |
| 180 ● ◊ ◊ ◊ ◊ | Repair Skin - 8                    | 390 ○ ◊ ◊ ◊ ◊ | Move to Bldg 95<br>95 MABPAB                |
| 190 ● ◊ ◊ ◊ ◊ | Replace -14 splice                 | 400 ○ ◊ ◊ ◊ ◊ | Delay                                       |
| 200 ● ◊ ◊ ◊ ◊ | Repair Skin                        | 410 ● ◊ ◊ ◊ ◊ | Inspect Wiring &<br>light                   |
| 210 ● ◊ ◊ ◊ ◊ | Replace -5 splice                  | 420 ● ◊ ◊ ◊ ◊ | Repair Wiring                               |
| 220 ● ◊ ◊ ◊ ◊ | Smooth out scratches,<br>joints    | 430 ● ◊ ◊ ◊ ◊ | Repair Terminals                            |
| 230 ● ◊ ◊ ◊ ◊ | Repair -7 Frame Half               | 440 ● ◊ ◊ ◊ ◊ | Repair Light fixtures                       |
| 240 ● ◊ ◊ ◊ ◊ | Repair Frame Half-8<br>5135        | 450 ● ◊ ◊ ◊ ◊ | Replace lamps                               |
| 250 ● ◊ ◊ ◊ ◊ | Repair -1 Frame Half<br>6037       | 460 ● ◊ ◊ ◊ ◊ | Conduct Continuity<br>check                 |
| 260 ● ◊ ◊ ◊ ◊ | Repair -2 Frame Half<br>Frame half | 470 ● ◊ ◊ ◊ ◊ | Reinstall Hyd. Tubing<br>& valves           |
| 270 ● ◊ ◊ ◊ ◊ | Repair 6034-7 Frame<br>Half        | 480 ○ ◊ ◊ ◊ ◊ | Delay                                       |
| 280 ● ◊ ◊ ◊ ◊ | Repair 6034-8 Frame<br>Half        | 490 ○ ◊ ◊ ◊ ◊ | Move to MABPAB<br>95 MABPAB                 |
| 290 ● ◊ ◊ ◊ ◊ | Repair FWD. Frame<br>Supt. 6012-8  | 500 ○ ◊ ◊ ◊ ◊ | Delay                                       |

SUBJECT Boon Tail Cone DATE 4/5/89

DATE 4/5/89

PCN: 15175A WCD: 15175A WCD DATE: 89073

CHART ENDS 440

PREPARED BY: Tim Ho

| SYMBOLS |  | DESCRIPTION         | SYMBOLS |  | DESCRIPTION |
|---------|--|---------------------|---------|--|-------------|
| 105     |  | Check & repair Fuel |         |  |             |
| 106     |  | Dump mechanism      |         |  |             |
|         |  | Condition Tag       |         |  |             |
|         |  |                     |         |  |             |
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Supplementary

### FLOW PROCESS CHART

SUBJECT Hyd. Tubing & Valves For 'Boom Tail Cone' DATE 4/5/89

PCN: 15175A WCD: 15175A WCD DATE: 8907?

**CHART BEGINS.**

**CHART ENDS**

PREPARED BY: Tim Hall

[illegible]

\*\*\*\*\*  
 1. 15175A \* WORK CONTROL DOCUMENT \* MISIR 1. DATE 89073 PAGE 1 OF 4 PAGE 01  
 \*\*\*\*\*  
 12. ORIO/PROD NR 13. QUANTITY 14. PROD SECTION/RCC 15. DATE SCHLD 16. DATE CONF  
 15175A 1 MBPAB 89073 1  
 17. PART NUMBER 19. ITEM SERIAL NR 18/12. TECH DATA/OPTIONAL  
 50 4694-13 1 1.0. 643 4 3, 1-1A-14  
 10. MODEL/DESIGN/SERIES 11. STOCK NR 12. STATE NR 13. WORK C/N:  
 KC-135 1 1560006317598FL 00-1560FL/82-103/01 DATLD  
 14. RICE 14. HOUR/END 11. HOUR 1.0. 10 135(K)A-2-12-1  
 BOOM TAIL CONE  
 PHYLLIS HEAD/MBEBS/65265  
 15. DISP 16. PDN/  
 16. STATION 17. WORK TO BE ACCOMPLISHED 18. MCH 12" 120" 0"  
 2122 010 RELIEVE AND UNCRATE. /  
 MBPAB MOVE TO BLDG 95, MBPAB.  
 95 020 REMOVE ALL HYD. TUBING AND VALVES /  
 MBPAB ROUTE TUBING TO NIPIN 3, BLDG 210 /  
 UN AFIC FORM 945  
 210 030 CONDITION INSPECT & FUNCTIONAL TEST KN /  
 MBPAB TUBING & VALVES. RETURN TO BLDG /  
 95, MBEBS.  
 95 040 REMOVE ALL WIRING & LIGHTS. ATTACH /  
 MBPAB WIRING HARNESS 957 ROUTE TO MBPDC. /  
 MOVE TAIL CONE TO BLDG 2122, MBPCA.  
 2122 050 STRIP ALL EXTERIOR & INTERIOR PAINT /  
 MBPCA 1AW 1.0. 1C-135(K)A-3-4. /  
 MOVE TO BLDG 95.  
 95 060 ACCOMPLISH SHAKEDOWN INSPECTION 1AW /  
 MBPAB WORK STATEMENT ADD ANY ADD'L. /  
 CALLOUTS AS REQUIRED. /  
 BLDG 95.  
 95 070 INSTALL TAIL CONE IN FIXTURE /  
 MBPAB NO. 600CJ809 FOR WORK. FIXTURE /  
 NO. 8147573 MAY BE USED TO AID /  
 IN LOCATING NUT PLATE HOLES ON /  
 FRAMES 50-5135-7 AND 50-5135-8  
 95 080 SKIN P/N 50-4694-9 L  
 MBPAB REPAIR\_\_REPLACE\_\_NOT REQ'D\_\_  
 95 090 REPLACE SPLICE P/N 50-4694-6 /  
 MBPAB REQ'D\_\_NOT REQ'D\_\_ /  
 95 100 SKIN P/N 50-4694-3. E /  
 MBPAB REPAIR\_\_REPLACE\_\_NOT REQ'D\_\_  
 95 110 REPLACE SPLICE 50-4694-14. /  
 MBPAB REQ'D\_\_NOT REQ'D\_\_





STATION OF NO. 117. WORK TO BE ACCOMPLISHED

118.NELH119"F"120"Q"

|      |       |                                       |   |   |
|------|-------|---------------------------------------|---|---|
| 95   | 280   | REPLACE SUPPORT, LIGHT, P/N 60-3662-1 | / | / |
|      | MBPAB |                                       |   |   |
|      | 290   | REPLACE 2 LAMP HOUSING FOR TAIL,      | / | / |
|      | MBPAB | P/N 60-3662-1                         |   |   |
| 95   | 300   | REMOVE CORROSION AND TREAT IAW        | / | / |
|      | MBPAB | 10-135(K)A-3-4.                       |   |   |
|      |       | REPAIR__NOT REQ'D__                   |   |   |
| 95   | 310   | REMOVE TAIL CONE FROM FLATURE.        | / | / |
|      | MBPAB | MOVE TO BLDG 2280, MBPCB              |   |   |
| 2280 | 320   | ACCOMPLISH FINAL WASH                 | / | / |
|      | MBPCB |                                       |   |   |
| 2280 | 330   | PAINT INTERIOR AND EXTERIOR WITH      | / | / |
|      | MBPCB | EPOXY PRIMER MIL-P 87112, PSN 8010    |   |   |
|      |       | 00-082-2477.                          |   |   |
| 2280 | 340   | PAINT EXTERIOR WITH ANTI-CORROSION    | / | / |
|      | MBPCB | FINISH MIL-C-83206-B, PSN 8010 00     |   |   |
|      |       | 693-2614. (STENCIL ON WARNING)        |   |   |
|      |       | MOVE TO BLDG. 95, MBPAA.              |   |   |
| 95   | 360   | INSPECT WIRING AND LIGHTS IAW 6A3-4   | / | / |
|      | MBPAA | 3. REINSTALL ALL WIRING AND LIGHTS    |   |   |
|      |       | IAW DRAWING 5-96333. CONDUCT CONTIN   |   |   |
|      |       | UITY CHECK ON INSTALLED BARNERS.      |   |   |
|      |       | ALSO REFERENCE T.O. 3-1A-1-1 AND      |   |   |
|      |       | T.O. 10-135(K)A-2-12-1.               |   |   |
| 95   | 370   | WIRING IAW 6A3-4-3 & DRAWING 5-9633   | / | / |
|      | MBPAA | REPAIR__REPLACE__NOT REQ'D__          |   |   |
| 95   | 380   | TERMINALS                             | / | / |
|      | MBPAA | REPAIR__REPLACE__NOT REQ'D__          |   |   |
| 95   | 390   | LIGHT FIXTURES.                       | / | / |
|      | MBPAA | REPAIR__REPLACE__NOT REQ'D__          |   |   |
| 95   | 400   | REPLACE ALL LAMPS.                    | / | / |
|      | MBPAA |                                       |   |   |
| 95   | 410   | CONDUCT CONTINUITY CHECK ON           | / | / |
|      | MBPAA | COMPLETED ITEM.                       |   |   |
| 95   | 420   | REINSTALL HYDRAULIC TUBING & VALVES   | / | / |
|      | MBPAA | IN BOOM TAIL CONL ASSY IAW DRAWING    |   |   |
|      |       | 5-96162.                              |   |   |
| 95   | 425   | CHECK FULL DUMP MECHANISM. WITH       | / | / |
|      | MBPAB | MECHANISM AND CHECK AGAINST THE       |   |   |
|      |       | RUBBER BUMPER. MANUALLY MOVE THE      |   |   |
|      |       | MECHANISM ARM INBOARD TOWARD THE      |   |   |
|      |       | CENTERLINE OF THE BOOM ASSEMBLY       |   |   |
|      |       | TO DETERMINE WORK. IF ARM PLAY        |   |   |

X - (CONTINUED)

| *****  |       |                                      |  |  |  |  |  |  |  |
|--|-------|--------------------------------------|--|--|--|--|--|--|--|
| 15175A * WORK CONTROL DOCUMENT * MSIR 1.DATE 89073 PAGE 4 OF 4 PAGES                                     |       |                                      |  |  |  |  |  |  |  |
| 15.DISP-16.PDN/  |       |                                      |  |  |  |  |  |  |  |
| STATION/OP NO. 117.WORK TO BE ACCOMPLISHED 118.MECH119"P"120"Q"  |       |                                      |  |  |  |  |  |  |  |
| EXCEEDS ALLOWABLE LIMITS OF 0.70,<br>REPAIR FUEL DUMP MECHANISM ASSEMBLY.<br>REF. T.O. 6A3-4-3, FIG 5-5. |       |                                      |  |  |  |  |  |  |  |
| 95   | 430   | ROUTE ITEM TO MBPAC WITH THIS 959.   |  |  |  |  |  |  |  |
|  | MBPAA |                                      |  |  |  |  |  |  |  |
| 95   | 440   | WORK COMPLETED. CONDITION TAG        |  |  |  |  |  |  |  |
|  | MBPAB | DATE _____ MOVE TO CRATING.          |  |  |  |  |  |  |  |
|  |       | CONDITION TAGGED 1AW AFM 67-1.       |  |  |  |  |  |  |  |
|  |       | NOTE: COMPLETE "REMARKS" COLUMN OF   |  |  |  |  |  |  |  |
|  |       | AFIC FORM 3574 1AW NAOI 66 35.       |  |  |  |  |  |  |  |
|  |       | NOTE: PART WILL HAVE DC ALL FORMS    |  |  |  |  |  |  |  |
|  |       | 506,507, & 508 IDENTIFICATION LABELS |  |  |  |  |  |  |  |
|  |       | APPLIED TO COMPLETED ITEM 1AW AFICR  |  |  |  |  |  |  |  |
|  |       | 66-51 ACCEPTANCE DATA ON THE LABEL   |  |  |  |  |  |  |  |
|  |       | ALONG WITH "M" STAMP OF THE PERSON   |  |  |  |  |  |  |  |
|  |       | PERFORMING THE OVERHAUL.             |  |  |  |  |  |  |  |
|  |       | CAUTION: SURFACES TO WHICH LABELS    |  |  |  |  |  |  |  |
|  |       | ARE APPLIED MUST BE FREE OF          |  |  |  |  |  |  |  |
|  |       | CONTAMINATION.                       |  |  |  |  |  |  |  |
| COORDINATION   |       |                                      |  |  |  |  |  |  |  |
|  |       | MABEBS PHYLLIS HEALD 22 MARCH 89     |  |  |  |  |  |  |  |
|  |       | MABSCS CONNIE WEBBER 22 MARCH 89     |  |  |  |  |  |  |  |
|  |       | MABPAB JESSIE JACOBS 22 MARCH 89     |  |  |  |  |  |  |  |
|  |       | MAQBF TED HAYES 22 MARCH 89          |  |  |  |  |  |  |  |

15178A

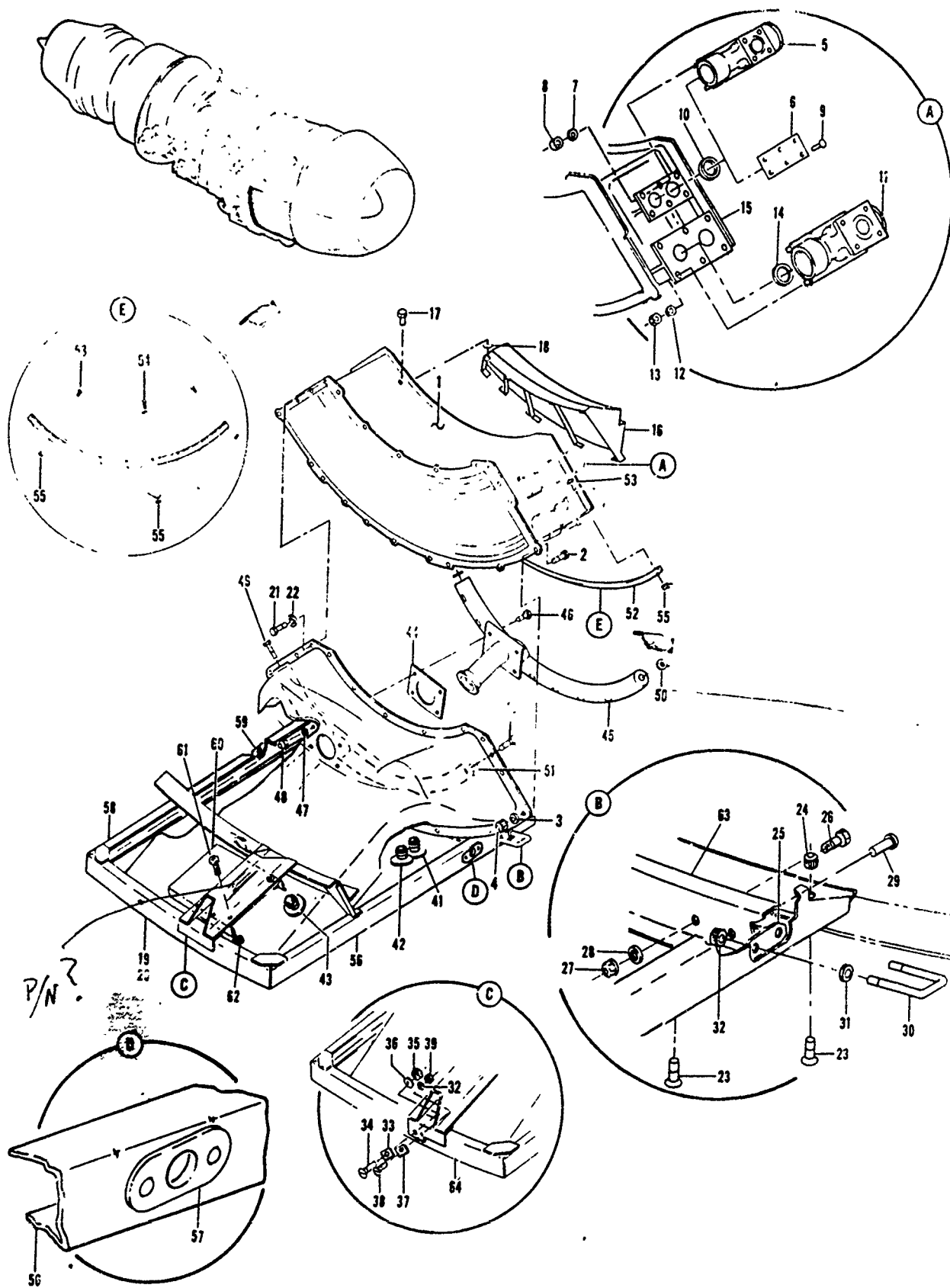


Figure 4-22. Engine and Generator Drive Oil Cooler Installation

| FIGURE &<br>INDEX NO. | PART NUMBER | DESCRIPTION   | UNITS<br>PER<br>ASSY | USE<br>ON<br>CODE |
|-----------------------|-------------|---|----------------------|-------------------|
|                       |             | 1 2 3 4 5 6 7   |                      |                   |
| 4-22                  | 5-88456     | COOLER INSTL, Engine and generator drive oil. . . . .     | Ref                  |                   |
|                       |             | (see figure 4-2, index 8)                                 |                      |                   |
| -1                    | 998A1       | . COOLER ASSY, Engine and generator drive oil. . . . .    | 1                    |                   |
|                       |             | (57733) (Boeing Specification 10-2571-8) (optional        |                      |                   |
|                       |             | 65-13008) (for T.O. covering parts breakdown see          |                      |                   |
|                       |             | introduction to Section IV.)                              |                      |                   |
|                       |             | (ATTACHING PARTS)   |                      |                   |
| -2                    | NAS1303-4   | . BOLT (Replaces AN3-5A) (for replacement, order. . . . . | 15                   |                   |
|                       |             | BACB30NF3D4)  |                      |                   |
| -3                    | AN960D10    | . WASHER. . . . .   | 11                   |                   |
| -4                    | MS21042L3   | . NUT, Self-locking 500°F (replaces NAS679A3W) (for . . . | 15                   |                   |
|                       |             | replacement, order BACN10JC3)                             |                      |                   |
|                       |             | -----*  |                      |                   |
| -5                    | G712504     | . . VALVE ASSY., Generator drive oil bypass and relief. . | 1                    | C                 |
|                       |             | (57733) (Boeing Specification 10-2571-4)                  |                      |                   |
| -6                    | No Number   | . . COVER PLATE (Fabricate from 0.125 to 0.250. . . . .   | 1                    | D                 |
|                       |             | inch thick aluminum, 2.820 x 1.916, drill 6 each          |                      |                   |
|                       |             | holes 0.193 inch diameter to match core)                  |                      |                   |
|                       |             | (ATTACHING PARTS)   |                      |                   |
| -7                    | AN960D10    | . . WASHER. . . . .                                       | 6                    |                   |
| -8                    | MS21042L3   | . . NUT, Self-locking 500°F (replaces NAS679A3W). . . . . | 6                    |                   |
|                       |             | (for replacement, order BACN10JC3)                        |                      |                   |
| -9                    | NAS1303-4   | . . BOLT (Replaces AN3-5A). . . . .                       | 6                    | D                 |
|                       |             | -----*  |                      |                   |
| -10                   | MS29561-211 | . . GASKET, O-ring (BACG10T16) (optional PRP 1847-211 . . | 2                    |                   |
|                       |             | (25184), SRC-CZ1415-16 (95272), 47-071-2-211              |                      |                   |
|                       |             | (83259))  |                      |                   |
| -11                   | G712503     | . . VALVE ASSY., Engine oil bypass and relief. . . . .    | 1                    |                   |
|                       |             | (57733) (Boeing Specification 10-2571-3)                  |                      |                   |
|                       |             | (ATTACHING PARTS)   |                      |                   |
| -12                   | AN960PD416  | . . WASHER. . . . .                                       | 6                    |                   |
| -13                   | MS21042L4   | . . NUT, Self-locking 500°F (replaces NAS679A4W). . . . . | 6                    |                   |
|                       |             | (for replacement, order BACN10JC4)                        |                      |                   |
|                       |             | -----*  |                      |                   |
| -14                   | MS29561-217 | . . GAS T, O-ring (BACG10T22) (optional PRP 1847-217 . .  | 2                    |                   |
|                       |             | (25184), SRC-CZ1415-22 (95272), 47-071-2-217              |                      |                   |
|                       |             | (83259))  |                      |                   |
| -15                   | G715802     | . . CORE ASSY, Oil cooler (57733) (Boeing . . . . .       | 1                    |                   |
|                       |             | Specification 10-2571-9) (optional G712502                |                      |                   |
|                       |             | (57733) (Boeing Specification 10-2571-2) with             |                      |                   |
|                       |             | holes drilled for hail shield attachment)                 |                      |                   |
| -16                   | G715800     | . . SHIELD, Hail (57733) (Boeing Specification. . . . .   | 1                    |                   |
|                       |             | 10-2571-10)   |                      |                   |
|                       |             | (ATTACHING PARTS)   |                      |                   |
| -17                   | MS9316-04   | . . SCREW (96906) (optional NAS603-13 or NAS603-13P). . . | 5                    |                   |
| -18                   | AN960D10    | . . WASHER. . . . .                                       | AR                   |                   |
|                       |             | -----*  |                      |                   |
| -19                   | 50-2458-35  | . TAB ASSY., Oil cooler exit duct (optional 50-2458). . . | 1                    | A                 |
| -20                   | 50-2458-41  | . TAB ASSY., Oil cooler exit duct (optional 50-2458-37) . | 1                    | B                 |
|                       |             | (ATTACHING PARTS)   |                      |                   |
| -21                   | NAS1303-8V  | . BOLT (For replacement, order BACB30NE3-8) . . . . .     | 6                    |                   |
| -22                   | AN960PD10L  | . WASHER. . . . .   | 6                    |                   |
| -23                   | NAS517-4-2  | . SCREW, (Optional MS24694S99 when nose cowl doubler. . . | 6                    |                   |
|                       |             | is installed)   |                      |                   |
| -24                   | MS21042L4   | . NUT, Self-locking 500°F (replaces NAS679A4W) (for . . . | 2                    |                   |
|                       |             | replacement, order BACN10JC4)                             |                      |                   |
|                       |             | -----*  |                      |                   |
| -25                   | 68C35396-1  | . . FITTING, U-bolt . . . . .                             | 2                    |                   |
| -26                   | NAS1103-3   | . . BOLT. . . . .   | 3                    |                   |
| -27                   | MS21042-3   | . . NUT, Self-locking . . . . .                           | 3                    |                   |
| -28                   | AN960PD10   | . . WASHER. . . . .                                       | 3                    |                   |
| -29                   | MS2047AD6-8 | . . RIVET . . . . .                                       | 1                    |                   |
| -30                   | 9-66304-1   | . . U-BOLT. . . . .                                       | 2                    |                   |
|                       |             | (ATTACHING PARTS)   |                      |                   |
| -31                   | AN316-SR    | . . NUT . . . . .   | 4                    |                   |
| -32                   | H23-5       | . . NUT (15653) (BACN10B-L5L) (optional FN22A-524 . . . . | 4                    |                   |
|                       |             | (03680), LH3393-054 (72962) VN406-A-054                   |                      |                   |
|                       |             | (92215))  |                      |                   |
|                       |             | -----*  |                      |                   |

| FIGURE &<br>INDEX NO. | PART NUMBER   | DESCRIPTION |   |   |   |   |   |   | A   |
|-----------------------|---------------|-------------|---|---|---|---|---|---|-----|
|                       |               | 1           | 2   | 3 | 4 | 5 | 6 | 7 |     |
| 4-22(Cont)            |               |             |   |   |   |   |   |   |     |
| -33                   | 50-2458-804   | . .         | BLOCK, Bearing. . . . .                                     |   |   |   |   |   | 1   |
|                       |               |             | (ATTACHING PARTS)   |   |   |   |   |   |     |
| -34                   | NAS334CPA6    | . .         | BOLT. . . . .   |   |   |   |   |   | 1   |
| -35                   | MS21042L4     | . .         | NUT, Self-locking 500°F (replaces NAS679A4W). . . . .       |   |   |   |   |   | 1   |
|                       |               |             | (optional BACN10JC4)  |   |   |   |   |   |     |
| -36                   | AN960D416L    | . .         | WASHER. . . . .   |   |   |   |   |   | 1   |
| -37                   | 50-2458-805   | . .         | STOP. . . . .   |   |   |   |   |   | 1   |
|                       |               |             | (ATTACHING PARTS)   |   |   |   |   |   |     |
| -38                   | NAS514P1032-8 | . .         | SCREW . . . . .   |   |   |   |   |   | 1   |
| -39                   | MS21042L3     | . .         | NUT, Self-locking 500°F (replaces NAS679A3W). . . . .       |   |   |   |   |   | 1   |
|                       |               |             | (optional BACN10JC3)  |   |   |   |   |   |     |
| -40                   | AN960C10L     | . .         | WASHER. . . . .   |   |   |   |   |   | 1   |
| -41                   | BACF22H6-3    | . .         | FLANGE, Flared tube (used on 50-2458-37) . . . . .          |   |   |   |   |   | 1   |
| -42                   | BACF22H8-3    | . .         | FLANGE, Flared tube . . . . .                               |   |   |   |   |   | 1   |
| -43                   | BACF22J6D     | . .         | FLANGE, Straight thread . . . . .                           |   |   |   |   |   | 1   |
|                       | 50-6379-21    | . .         | DUCT ASSY, Oil cooler exit (used on 50-2458-11) . . . . .   |   |   |   |   |   | 1   |
|                       | 50-6379       | . .         | DUCT ASSY, Oil cooler exit (used on 50-2458, . . . . .      |   |   |   |   |   | 1   |
|                       |               |             | 50-2458-35, 50-2458-37)                                     |   |   |   |   |   |     |
| -44                   | 60-5730       | . .         | GASKET. . . . .   |   |   |   |   |   | 1   |
| -45                   | 90-6937-4     | . .         | TUBE ASSY, Air ejector. . . . .                             |   |   |   |   |   | 1   |
|                       |               |             | (ATTACHING PARTS)   |   |   |   |   |   |     |
| -46                   | NAS1304-3     | . .         | BOLT (Replaces AN4-5A) (optional BACB3ONE4-3) . . . . .     |   |   |   |   |   | 4   |
| -47                   | AN960D416L    | . .         | WASHER. . . . .   |   |   |   |   |   | 4   |
| -48                   | MS21012L4     | . .         | NUT, Self-locking 500°F (replaces NAS679A4W). . . . .       |   |   |   |   |   | 4   |
|                       |               |             | (optional BACN10JC4)  |   |   |   |   |   |     |
| -49                   | NAS1304-9H    | . .         | BOLT (Replaces AN4H10A) (for replacement order. . . . .     |   |   |   |   |   | 2   |
|                       |               |             | BACB3ONE4H9)  |   |   |   |   |   |     |
| -50                   | AN960-416     | . .         | WASHER. . . . .   |   |   |   |   |   | 2   |
| -51                   | 60-5732       | . .         | SPACER, Ejector tube. . . . .                               |   |   |   |   |   | 2   |
| -52                   | 90-7940       | . .         | DEPRESSOR, Seal (for replacement order 90-7940-1) . . . . . |   |   |   |   |   | 1   |
|                       |               |             | (ATTACHING PARTS)   |   |   |   |   |   |     |
| -53                   | MS9316-04     | . .         | SCREW (Optional NAS603-6) . . . . .                         |   |   |   |   |   | 3   |
| -54                   | MS9316-06     | . .         | SCREW (Optional NAS603-10). . . . .                         |   |   |   |   |   | 6   |
| -55                   | MS21042L3     | . .         | NUT, Self-locking 500°F (replaces NAS679A3W). . . . .       |   |   |   |   |   | AR  |
|                       |               |             | (optional BACN10JC3)  |   |   |   |   |   |     |
| -56                   | 50-2458-27    | . .         | LONGERON RH . . . . .                                       |   |   |   |   |   | 1 E |
| -57                   | 3-74650       | . .         | STRIKER PLATE . . . . .                                     |   |   |   |   |   | 1   |
| -58                   | 50-2458-28    | . .         | LONGERON LH . . . . .                                       |   |   |   |   |   | 1 E |
| -59                   | 3-74650       | . .         | STRIKER PLATE . . . . .                                     |   |   |   |   |   | 1   |
| -60                   | (a) 36-7367-1 | . .         | SUPPORT . . . . .   |   |   |   |   |   | 1   |
|                       |               |             | (ATTACHING PARTS)   |   |   |   |   |   |     |
| -61                   | (a) NAS603-8P | . .         | SCREW . . . . .   |   |   |   |   |   | 4   |
| -62                   | (a) MS21042L3 | . .         | NUT . . . . .   |   |   |   |   |   | 2   |
| -63                   | 50-2458-3     | . .         | LATCH SUPPORT . . . . .                                     |   |   |   |   |   | 1   |
| -64                   | 50-2458-10    | . .         | FRAME . . . . .   |   |   |   |   |   | 1   |
|                       |               | A           | Use with 50-4678  |   |   |   |   |   |     |
|                       |               | B           | Use with 50-4678-36   |   |   |   |   |   |     |
|                       |               | C           | Used on 5-96388 oil system                                  |   |   |   |   |   |     |
|                       |               | D           | Used on 5-96388-1 oil system                                |   |   |   |   |   |     |
|                       |               | E           | Used on 50-2458-35, -37, and -41 tab assy                   |   |   |   |   |   |     |
|                       |               | (a)         | Added by T.O. 1C-135-920                                    |   |   |   |   |   |     |

# FLOW PROCESS CHART

SUBJECT Oil Cooler Txb Assy

DATE 4/4/89

PCN: 15178A WCD: 15178A WCDDATE: 88054

CHART BEGINS Operation 010

CHART ENDS Operation 260

PREPARED BY: Tim Hall

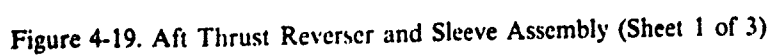
| SYMBOLS     | DESCRIPTION   | SYMBOLS     | DESCRIPTION                               |
|-------------|---|-------------|---|
| 10 ● ◊ ▢ ▽  | RECEIVE UNCRATE<br>2122 MBPCA                               | 140 ● ◊ ▢ ▽ | Replace Frame<br>95 MBPCA                 |
| ○ ◊ ▢ ▽     | DELAY   | 150 ● ◊ ▢ ▽ | Replace Hot Set Brackets                  |
| ○ ◊ ▢ ▽     | MOVE  | 160 ● ◊ ▢ ▽ | Replace support brackets                  |
| ○ ◊ ▢ ▽     | DELAY   | 170 ● ◊ ▢ ▽ | Replace support<br>Frame                  |
| 12 ● ◊ ▢ ▽  | CLEAN OIL COOLER TAB<br>2122 MBPCA                          | 180 ● ◊ ▢ ▽ | Replace air ejector<br>Tube assy & gasket |
| 15 ● ◊ ▢ ▽  | STRIP PAINT<br>2122 MBPCA                                   | 190 ● ◊ ▢ ▽ | Replace cover plate<br>(skin)             |
| 18 ● ◊ ▢ ▽  | ABRAIVE BLAST<br>2122 MBPCA                                 | 200 ● ◊ ▢ ▽ | Replace bearing block                     |
| ○ ◊ ▢ ▽     | DELAY   | 210 ● ◊ ▢ ▽ | Replace striking plates                   |
| ○ ◊ ▢ ▽     | MOVE TO 95  | 220 ● ◊ ▢ ▽ | Replace Flange Flared<br>Tube (Large)     |
| ○ ◊ ▢ ▽     | DELAY   | 230 ● ◊ ▢ ▽ | Replace Flange Flared<br>Tube (Small)     |
| 22 ● ◊ ▢ ▽  | ACCOMPLISH SHAKEDOWN<br>INSPECTION<br>95 MBPCA              | ○ ◊ ▢ ▽     | Delay                                     |
| ○ ◊ ▢ ▽     | DELAY   | ○ ◊ ▢ ▽     | Move to Bldg 2280<br>2280 MBPCA           |
| ○ ◊ ▢ ▽     | MOVE TO 3001  | ○ ◊ ▢ ▽     | Delay                                     |
| ○ ◊ ▢ ▽     | DELAY   | 240 ● ◊ ▢ ▽ | Prime interior<br>surfaces                |
| 26 ● ◊ ▢ ▽  | WELD<br>3001 MTPW   | ○ ◊ ▢ ▽     | Delay                                     |
| ○ ◊ ▢ ▽     | DELAY   | ○ ◊ ▢ ▽     | Move to Bldg 95<br>95 MBPCA               |
| ○ ◊ ▢ ▽     | MOVE TO 95  | ○ ◊ ▢ ▽     | Delay                                     |
| ○ ◊ ▢ ▽     | DELAY   | ○ ◊ ▢ ▽     | Condition T92                             |
| 30 ● ◊ ▢ ▽  | REPAIR/TREAT CORROSION<br>95 MBPCA                          | ○ ◊ ▢ ▽     |   |
| 40 ● ◊ ▢ ▽  | REPLACE FASTENERS   | ○ ◊ ▢ ▽     |   |
| 50 ● ◊ ▢ ▽  | Replace 'U' Bolt Bracket                                    | ○ ◊ ▢ ▽     |   |
| 60 ● ◊ ▢ ▽  | Delete one bolt nearest 'U'<br>bolt & substitute with rivet | ○ ◊ ▢ ▽     |   |
| 70 ● ◊ ▢ ▽  | Replace stop 95<br>needed                                   | ○ ◊ ▢ ▽     |   |
| 80 ● ◊ ▢ ▽  | Replace rib   | ○ ◊ ▢ ▽     |   |
| 90 ● ◊ ▢ ▽  | Replace R.H. longeron                                       | ○ ◊ ▢ ▽     |   |
| 100 ● ◊ ▢ ▽ | Replace L.H. longeron                                       | ○ ◊ ▢ ▽     |   |
| 110 ● ◊ ▢ ▽ | Replace Latch Support                                       | ○ ◊ ▢ ▽     |   |
| 120 ● ◊ ▢ ▽ | Replace 'U' bolt  | ○ ◊ ▢ ▽     |   |
| 130 ● ◊ ▢ ▽ | Replace Lap strip   | ○ ◊ ▢ ▽     |   |



| *****  |              |   |          |        |        |
|--|--------------|---|----------|--------|--------|
| 15170A * WORK CONTROL DOCUMENT * MISTR 1. DATE 88054 PAGE 2 OF 3 PAGES |              |   |          |        |        |
| 15. DISP 16. PDN/  |              |   |          |        |        |
| STATION  | UP NO.       | 17. WORK TO BE ACCOMPLISHED   | 18. MECH | 19 "P" | 20 "Q" |
| 95   | 090<br>MBPAB | REPLACE LONGERON R.H. P/N 50-2458-28<br>IAW SOW, PARA 4<br><br>REQ'D _____ NOT REQ'D _____    |          | E      | /      |
| 95   | 100<br>MBPAB | REPLACE LONGERON L.H. P/N 50-2458-27<br>IAW SOW, PARA 4<br><br>REQ'D _____ NOT REQ'D _____    |          | E      | /      |
| 95   | 110<br>MBPAB | REPLACE LATCH SUPPORT P/N 50-2458-3<br><br>REQ'D _____ NOT REQ'D _____                        |          | /      | /      |
| 95   | 120<br>MBPAB | REPLACE "U" BOLT P/N 9-66304-1 (2EA)<br><br>REQ'D _____ NOT REQ'D _____                       |          | /      | /      |
| 95   | 130<br>MBPAB | REPLACE LAP STRIP P/N 50-2458-29<br><br>REQ'D _____ NOT REQ'D _____                           |          | /      | /      |
| 95   | 140<br>MBPAB | REPLACE FRAME P/N 50-2458-10<br><br>REQ'D _____ NOT REQ'D _____                               |          | E      | /      |
| 95   | 150<br>MBPAB | REPLACE HOT SCT BRCKT P/N 69-1147-1<br><br>REQ'D _____ NOT REQ'D _____                        |          | /      | /      |
| 95   | 160<br>MBPAB | REPLACE SUPPORT BRCKT P/N 66-1143-801<br><br>REQ'D _____ NOT REQ'D _____                      |          | /      | /      |
| 95   | 170<br>MBPAB | REPLACE SUPPORT FRAME<br>P/N 50-2458-33<br><br>REQ'D _____ NOT REQ'D _____                    |          | /      | /      |
| 95   | 180<br>MBPAB | REPLACE AIR EJECTOR TUBE ASSY<br>P/N 90-6937-4 & GASKET P/N 60-5730<br>REQD-----NOT REQD----- |          | E      | /      |
| 95   | 190<br>MBPAB | RPLC CVR PLATE (SKIN) P/N 50-2458-1<br><br>REQ'D _____ NOT REQ'D _____                        |          | /      | /      |
| 95   | 200<br>MBPAB | REPLACE BEARING BLOCK<br>P/N 50-2458-804<br><br>REQ'D _____ NOT REQ'D _____                   |          | /      | /      |
| 95   | 210<br>MBPAB | REPLACE STRIKE PLATES (2EA)<br>P/N 3-74650<br><br>REQ'D _____ NOT REQ'D _____                 |          | /      | /      |



| *****   |              |   |         |       |       |
|---|--------------|---|---------|-------|-------|
| 15178A * WORK CONTROL DOCUMENT 11011- 1, DATE 00054 PAGE 3 OF 3 PAGES |              |   |         |       |       |
| 15.DISP-16.PDN/   |              |   |         |       |       |
| STATION/OP NO.  |              | 17.WORK TO BE ACCOMPLISHED  | 18.MECH | 19"P" | 20"Q" |
| 95  | 220<br>MBPAB | REPLACE FLANGE FLARED TUBE (LARGE)<br>P/N BACF22H8-3<br><br>REQ'D _____ NOT REQ'D _____   | /       | /     |       |
| 95  | 230<br>MBPAB | REPLACE FLANGE FLARED TUBE (SMALL)<br>P/N BACF22H6-3<br><br>REQ'D _____ NOT REQ'D _____<br>MOVE TO BLDG 2280 MBPCB  | /       | /     |       |
| 2280  | 240<br>MBPCB | INTERIOR SURFACES FINISHED WITH TWO<br>COATS OF EPOXY PRIMER MIL P-23377<br>MOVE TO BLDG 95 MBPAB   | /       | /     |       |
| 95  | 250<br>MBPAB | CONDITION TAG AND DICAL, RETURN TO<br>SUPPLY SERVICEABLE.   | /       | E     | /     |
| 95  | 260<br>MBPAB | CONDITION TAGGED IAW AFM 67-1.<br>NOTE: COMPLETE "REMARKS" COLUMN ON<br>AFIC FORM 1574 IAW MAOI 66-36<br>NOTE: PART WILL HAVE OC-ALC FORM 586<br>587 OR 588 ID LABEL APPLIED TO<br>COMPLETED END ITEM IAW AFICR 66-51<br>WITH ACCEPTANCE DATE ON LABEL ALONG<br>WITH "M" STAMP OF THE PERSON PER-<br>FORMING THE OVERHAUL. CAUTION: SUR-<br>FACES TO WHICH LABELS ARE APPLIED<br>MUST BE FREE OF CONTAMINATION. | /       | E     | /     |
|   |              | COORDINATION:   | DATE:   |       |       |
|   |              | MABEBS LARRY MULLINAX   | 3-28-87 |       |       |
|   |              | MAQBF TED HAYES   | 3 28-87 |       |       |
|   |              | MABSCS CONNIE WEBBER  | 3 28-87 |       |       |
|   |              | MABPAB JESSIE JACOBS  | 3 28 87 |       |       |



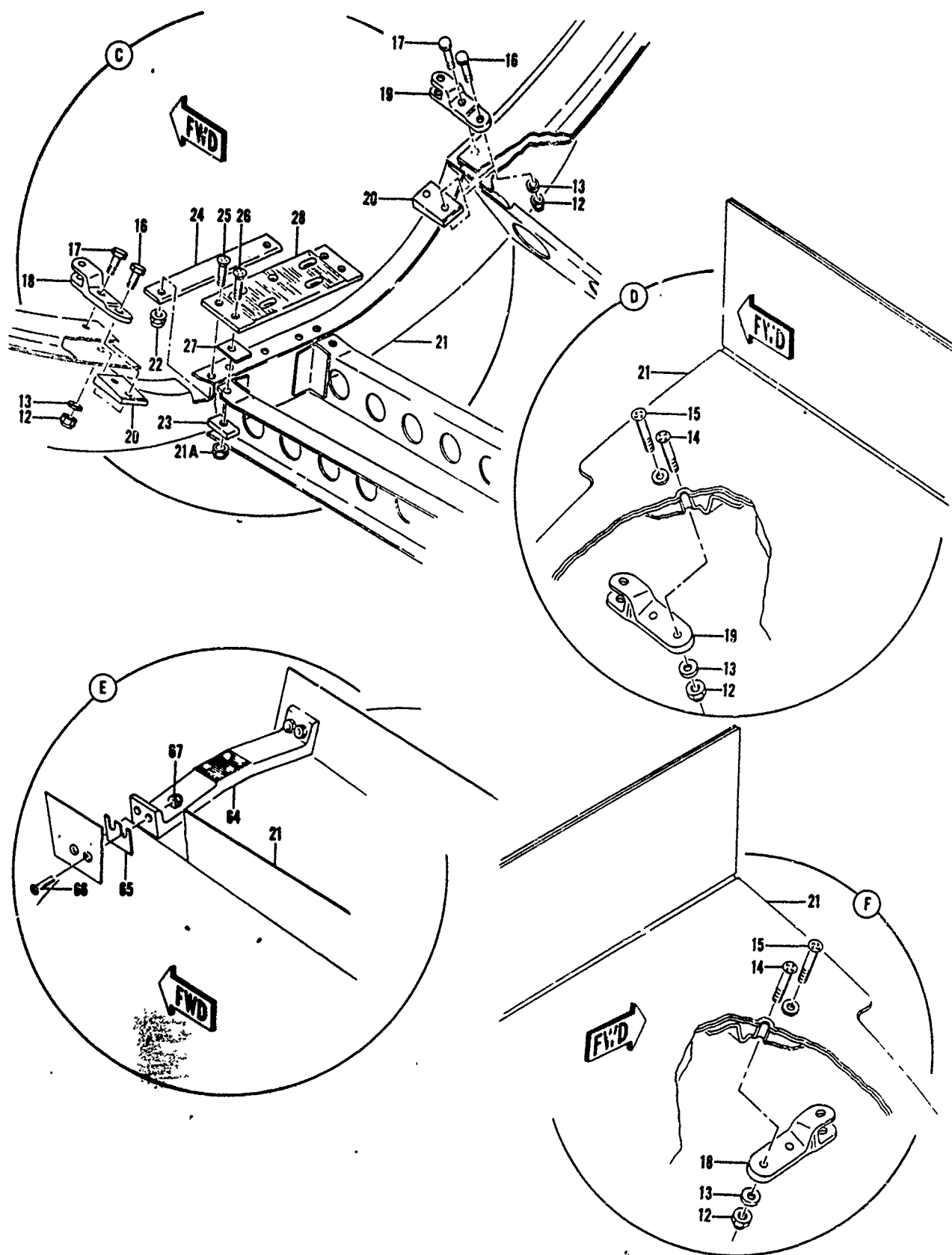


Figure 4-19. Aft Thrust Reverser and Sleeve Assembly (Sheet 2 of 3)

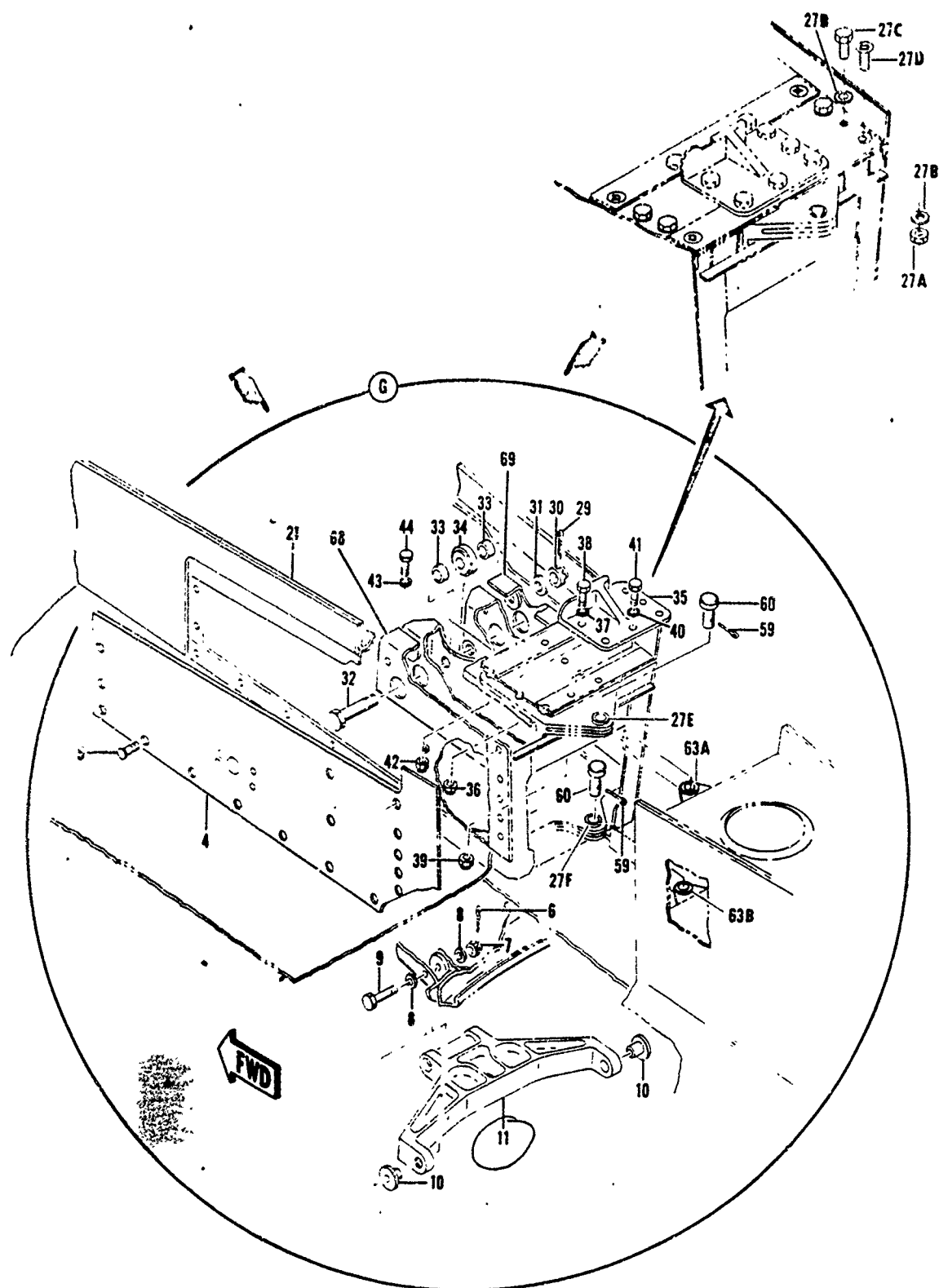


Figure 4-19. Aft Thrust Reverser and Sleeve Assembly (Sheet 3 of 3)

65-10505-269-9N

T.O. 1C-135A-10

15236A

| FIGURE &<br>INDEX NO. | PART NUMBER     | DESCRIPTION   | QUANTITY<br>PER<br>ASSY | USE<br>CODE |
|-----------------------|-----------------|---|-------------------------|-------------|
| 4-19                  | 65-10505-402    | SLEEVE ASSY, Aft thrust reverser (Optional 65-10505-401, 65-10505-353 and 65-10505-269; 65-10505-402 preferred for replacement) (See figure 4-18, index 43) | Ref                     |             |
| -1                    | 65-10505-11     | . ACCESS PANEL ASSY, Bottom and sides . . . . .   | 3                       |             |
| -2                    | NAS517-3-3      | (ATTACHING PARTS)   |                         |             |
| -3                    | NAS517-3-2      | . SCREW (Used on side access panels). . . . .   | 32                      |             |
|                       |                 | . SCREW (Used on bottom access panels). . . . .   | 16                      |             |
| -4                    | 65-10505-360    | . PANEL ASSY, Access (optional 65-10505-268, 65-10505-360 preferred for replacement)  | 1                       |             |
|                       | 65-10505-361    | . PANEL ASSY, Access (opposite 65-10505-360) (optional 65-10505-251, 65-10505-361 preferred for replacement)  | 1                       |             |
|                       |                 | (ATTACHING PARTS)   |                         |             |
| -5                    | NAS517-3-2      | . SCREW . . . . .   | 32                      |             |
| -6                    | AN381-2-8       | . PIN, Cotter . . . . .   | 8                       |             |
| -7                    | AN320C4         | . NUT . . . . .   | 8                       |             |
| -8                    | AN960C416       | . WASHER. . . . .   | 16                      |             |
| -9                    | BAC-B30BH-4-12  | . BOLT. . . . .   | 8                       |             |
|                       | 65-10526        | . LINK ASSY, Support. . . . .   | 4                       |             |
| -10                   | 66-10244        | . BUSHING . . . . .   | 2                       |             |
| -11                   | 65-10526-1      | . LINK. . . . .   | 1                       |             |
| -12                   | NAS679C3W       | . NUT . . . . .   | 8                       |             |
| -13                   | AN960C10        | . WASHER. . . . .   | 8                       |             |
| -14                   | NAS517-3-13     | . SCREW . . . . .   | 2                       |             |
| -15                   | NAS517-3-15     | . SCREW . . . . .   | 2                       |             |
| -16                   | BAC-B30BG-3-13A | . BOLT. . . . .   | 2                       |             |
| -17                   | BAC-B30BG-3-15A | . BOLT. . . . .   | 2                       |             |
| -18                   | 65-10527-1      | . FITTING, Left lower, right upper. . . . .   | 2                       |             |
| -19                   | 65-10527-2      | . FITTING, Right lower, left upper. . . . .   | 2                       |             |
| -20                   | 66-10240-2      | . FILLER, Lower fitting . . . . .   | 2                       |             |
| -21                   | 65-10505-403    | . SLEEVE ASSY (Preferred replacement for 65-10505-400 and 65-10505-270)   | 1                       | E           |
| -21                   | 65-10505-400    | . SLEEVE ASSY (Optional 65-10505-403 and 65-10505-270; 65-10505-403 preferred for replacement)  | 1                       | C           |
| -21                   | 65-10505-270    | . SLEEVE ASSY (Optional 65-10505-400 and 65-10505-403, 65-10505-403 preferred for replacement)  | 1                       | D           |
| -21A                  | MS2C500-428     | . NUT . . . . .   | 2                       |             |
| -22                   | MS20500-1032    | . NUT . . . . .   | 2                       |             |
| -23                   | 66-10240        | . FILLER, Radius. . . . .   | 2                       |             |
| -24                   | 66-10240-1      | . FILLER, Radius. . . . .   | 1                       |             |
| -25                   | BAC-B30BF-3-C7  | . BOLT. . . . .   | 2                       |             |
| -26                   | NAS560HK4-10    | . BOLT. . . . .   | 2                       |             |
| -27                   | BAC-S40SD-13-17 | . SHIM, Laminated (make from BAC1524-62SS). . . . .   | 2                       |             |
| -27A                  | NAS679A3W       | . NUT . . . . .   | 8                       |             |
| -27B                  | AN960C10L       | . WASHER. . . . .   | 8                       |             |
| -27C                  | AN3C4A          | . BOLT. . . . .   | 4                       |             |
| -27D                  | BACB30LH3U3     | . BOLT (Optional BACB30BF3C3 or BACB30BF3-3). . . . .   | 4                       |             |
|                       | 69-12671        | . FITTING ASSY, Hinge trailing edge fairing . . . . .   | 1                       |             |
|                       | 69-12671-1      | . . . FITTING, Hinge. . . . .   | 1                       |             |
| -27E                  | NAS77A5-13P     | . . . BUSHING, Flanged. . . . .   | 2                       |             |
|                       | 65-15604        | . . . FITTING ASSY, Hinge, aft thrust reverser. . . . .   | 1                       |             |
|                       | 65-15604-1      | . . . FITTING, Hinge. . . . .   | 1                       |             |
| -27F                  | NAS77A5-13P     | . . . BUSHING, Flanged. . . . .   | 2                       |             |
| -28                   | 66-10242        | . FITTING, Lower serrated . . . . .   | 1                       |             |
| -29                   | AN381-3-14      | . PIN, Cotter . . . . .   | 1                       |             |
| -30                   | AN320C6         | . NUT . . . . .   | 1                       |             |
| -31                   | AN960C816       | . WASHER. . . . .   | 1                       |             |
| -32                   | BAC-B30BH-6-22  | . BOLT. . . . .   | 1                       |             |
| -33                   | 65-1057T6-028   | . SPACER. . . . .   | 2                       |             |
| -34                   | 66-103063       | . BEARING, Needle (60380) (BAC-B10B-317). . . . .   | 1                       |             |
| -35                   | 69-10330-6      | . STOP (Optional 69-10330-4). . . . .   | 1                       |             |
|                       |                 | (ATTACHING PARTS)   |                         |             |
| -36                   | NAS679A3W       | . NUT . . . . .   | 5                       |             |
| -37                   | AN960C10L       | . WASHER. . . . .   | 5                       |             |
| -38                   | NAS501-3-6A     | . BOLT. . . . .   | 5                       |             |

| FIGURE &<br>INDEX NO | PART NUMBER    | DESCRIPTION   | 1 2 3 4 5 6 7 |  |  |  |  |  |  | QTY<br>PER<br>ASSY | MATERIAL<br>CODE |
|----------------------|----------------|---|---------------|--|--|--|--|--|--|--------------------|------------------|
|                      |                |   |               |  |  |  |  |  |  |                    |                  |
| 4-19(Cont)           |                |   |               |  |  |  |  |  |  |                    |                  |
| -39                  | NAAS679C3W     | . NUT . . . . .   |               |  |  |  |  |  |  | 1                  |                  |
| -40                  | AN960C10       | . WASHER. . . . .   |               |  |  |  |  |  |  | 1                  |                  |
| -41                  | AN3C5A         | . BOLT. . . . .   |               |  |  |  |  |  |  | 1                  |                  |
| -42                  | NAAS679A3W     | . NUT . . . . .   |               |  |  |  |  |  |  | 2                  |                  |
| -43                  | AN960C10L      | . WASHER. . . . .   |               |  |  |  |  |  |  | 2                  |                  |
| -44                  | BAC-B30BF-3-6A | . BOLT. . . . .   |               |  |  |  |  |  |  | 2                  |                  |
| -45                  | AN4C6A         | . BOLT. . . . .   |               |  |  |  |  |  |  | 1                  |                  |
| -46                  | AN4C5A         | . BOLT. . . . .   |               |  |  |  |  |  |  | 1                  |                  |
| -47                  | AN960C416      | . WASHER. . . . .   |               |  |  |  |  |  |  | 2                  |                  |
| -48                  | 65-10505-824   | . FILLER, Radius (Take from AISI301 sheet per MIL-S-5059,<br>comp 30, ser. cond. 2D 1/2 hard, 0.20 x 3.3 x 3.4<br>inches) |               |  |  |  |  |  |  | 1                  |                  |
| -49                  | 65-10505-209   | . SHIM, Laminated . . . . .   |               |  |  |  |  |  |  | 1                  |                  |
| -50                  | MS16996-10     | . SCREW (Optional BACS12AG8F and MS16996-10B) . . . . .   |               |  |  |  |  |  |  | 2                  | A                |
| -51                  | AN960-10L      | . WASHER. . . . .   |               |  |  |  |  |  |  | 2                  | A                |
| -52                  | NAS42HT10-28   | . SPACER. . . . .   |               |  |  |  |  |  |  | 1                  | A                |
| -53                  | NAS42HT10-14   | . SPACER. . . . .   |               |  |  |  |  |  |  | 1                  | A                |
| -54                  | AN960-516      | . WASHER. . . . .   |               |  |  |  |  |  |  | 3                  | A                |
| -54A                 | AN960-516L     | . WASHER. . . . .   |               |  |  |  |  |  |  | 1                  | A                |
| -55                  | MS15795-811    | . WASHER (Optional BACW10F115S) . . . . .   |               |  |  |  |  |  |  | 2                  | A                |
| -56                  | 66-11683       | . PIN . . . . .   |               |  |  |  |  |  |  | 1                  | A                |
| -57                  | 69-12687-2     | . SUPPORTING FITTING. . . . .   |               |  |  |  |  |  |  | 1                  | A                |
|                      | 69-12689       | . FITTING ASSY, Anchor, fairing . . . . .   |               |  |  |  |  |  |  | 1                  | A                |
| -57A                 | 69-12687-1     | . . FITTING, Anchor . . . . .   |               |  |  |  |  |  |  | 1                  | A                |
| -58                  | BSSR-5000-G    | . . BEARING (81376) (BACB10A203GD) (optional KWB-5SSG<br>(J7613)) . . . . .   |               |  |  |  |  |  |  | 1                  | A                |
| -58A                 | NAS509-3       | . NUT . . . . .   |               |  |  |  |  |  |  | 1                  | B                |
| -58B                 | 66-20473-1     | . BUSHING, Flanged. . . . .   |               |  |  |  |  |  |  | 2                  | B                |
| -58C                 | 66-21131-1     | . SHIM, Laminated . . . . .   |               |  |  |  |  |  |  | 1                  | B                |
| -58D                 | AN960-516      | . WASHER. . . . .   |               |  |  |  |  |  |  | 1                  | B                |
| -58E                 | AN960-516L     | . WASHER. . . . .   |               |  |  |  |  |  |  | 4                  | B                |
| -58F                 | NAS42HT10-10   | . SPACER. . . . .   |               |  |  |  |  |  |  | 1                  | B                |
| -58G                 | NAS42HT10-22   | . SPACER (Make from NAS42HT10-28) . . . . .   |               |  |  |  |  |  |  | 1                  | B                |
| -58H                 | BACB30G45-25   | . BOLT. . . . .   |               |  |  |  |  |  |  | 1                  | B                |
| -58J                 | 69-30242-1     | . FITTING, Anchor (optional 69-12689-2) . . . . .   |               |  |  |  |  |  |  | 1                  | B                |
| -58K                 | 69-27531-1     | . SUPPORT FITTING . . . . .   |               |  |  |  |  |  |  | 1                  | B                |
| -59                  | AN380-3-3      | . PIN, Cotter . . . . .   |               |  |  |  |  |  |  | 2                  |                  |
| -60                  | MS20392-4C21   | . PIN, Flathead (optional MS20392-4-21) . . . . .   |               |  |  |  |  |  |  | 2                  |                  |
| -61                  | 65-10505-271   | . FAIRING ASSY, Aft . . . . .   |               |  |  |  |  |  |  | 1                  | A                |
| -61A                 | 65-10505-354   | . FAIRING ASSY, Aft . . . . .   |               |  |  |  |  |  |  | 1                  | B                |
| -62                  | 69-12695-1     | . . SEAL ASSY, Fairing. . . . .   |               |  |  |  |  |  |  | 1                  |                  |
|                      | 69-12695-2     | . . SEAL ASSY (Opposite 69-12695-1) . . . . .   |               |  |  |  |  |  |  | 1                  |                  |
| -63                  | NAS517-3-2     | . . (ATTACHING PARTS)<br>. . SCREW (Optional BACB30LU3-2). . . . .  |               |  |  |  |  |  |  | 14                 |                  |
|                      | 65-15593       | . . FITTING ASSY, Hinge, aft fairing. . . . .   |               |  |  |  |  |  |  | 1                  |                  |
|                      | 65-15593-1     | . . . . FITTING, Hinge. . . . .   |               |  |  |  |  |  |  | 1                  |                  |
| -63A                 | NAS76A5-004P   | . . . . BUSHING, Plain. . . . .   |               |  |  |  |  |  |  | 1                  |                  |
|                      | 69-12679       | . . FITTING ASSY, Hinge, aft fairing. . . . .   |               |  |  |  |  |  |  | 1                  |                  |
|                      | 69-12679-1     | . . . . FITTING, Hinge. . . . .   |               |  |  |  |  |  |  | 1                  |                  |
| -63B                 | NAS76A5-004P   | . . . . BUSHING, Plain. . . . .   |               |  |  |  |  |  |  | 1                  |                  |
| -64                  | 65-16771-1     | . FITTING, Support. . . . .   |               |  |  |  |  |  |  | 1                  |                  |
| -65                  | BACS4QSC22-27  | . SHIM (Make from BAC1524-14SS) . . . . .   |               |  |  |  |  |  |  | AR                 |                  |
| -66                  | NAS1221-4-15   | . BOLT. . . . .   |               |  |  |  |  |  |  | 4                  |                  |
| -67                  | MS20500-428    | . NUT . . . . .   |               |  |  |  |  |  |  | 4                  |                  |
| -68                  | 69-10333-1     | . CHANNEL ASSY. . . . .   |               |  |  |  |  |  |  | 1                  |                  |
| -69                  | 69-10333-2     | . CHANNEL ASSY. . . . .   |               |  |  |  |  |  |  | 1                  |                  |
|                      | *65-98055-2    | KIT ASSY, Aft fairing attach fitting replacement. . . . .   |               |  |  |  |  |  |  | 1                  |                  |
|                      | 65-99332-2     | KIT ASSY, Sleeve structure modification . . . . .   |               |  |  |  |  |  |  | 1                  |                  |
|                      |                | A Used On 65-10505-269  |               |  |  |  |  |  |  |                    |                  |
|                      |                | B Used On 65-10505-353, -401 and -402   |               |  |  |  |  |  |  |                    |                  |
|                      |                | C Used On 65-10505-401  |               |  |  |  |  |  |  |                    |                  |
|                      |                | D Used On 65-10505-269 and -353   |               |  |  |  |  |  |  |                    |                  |
|                      |                | E Used On 65-10505-402  |               |  |  |  |  |  |  |                    |                  |
|                      |                | *See detailed illustration B.   |               |  |  |  |  |  |  |                    |                  |
|                      |                | Kit consists of items 58A thru 58K.   |               |  |  |  |  |  |  |                    |                  |

# FLOW PROCESS CHART

SUBJECT SLEEVE ASSEMBLY

DATE 4/5/89

PCN: 15236A WCD: 15236A WCD DATE: 88054

CHART BEGINS operation 010

CHART ENDS operation 350

PREPARED BY: MICHAEL

| SYMBOLS | DESCRIPTION   | SYMBOLS | DESCRIPTION                               |
|---------|---|---------|---|
| 010     | RECEIVE & UNPACK 2122 MAPCA                         |         | Delay                                     |
|         | DELAY   |         | Move to 3001 3001 MATPZW                  |
|         | MOVE  |         | Delay                                     |
|         | DELAY   | 115     | Weld Hat 1/2 Section                      |
| 020     | WASH INT. & EXT. 2122 MAPCA                         |         | Delay                                     |
|         |   |         | Move to 95 95 MAPAB                       |
|         |   |         | Delay                                     |
|         | STRIP INT. & EXT.                                   | 150     | Replace unserviceable or damaged parts    |
|         | Delay   | 155     | Disassemble box                           |
|         | Move to 816, 95 95 MAPAB                            |         | Delay                                     |
|         |   |         | Perform penetrant inspection check        |
| 040     | Remove panels                                       |         | Delay                                     |
| 050     | Remove Faring assembly                              |         | Reassemble box after inspection           |
| 060     | Remove support link                                 | 180     | Replace Link Brackets                     |
|         | Delay   | 190     | Replace aft tub strip                     |
|         | Move to 2122 2122 MAPCA                             | 200     | Repair or replace skin - 407              |
|         | Delay   | 210     | Repair or replace skin - 408              |
| 070     | Abrasive blast sleeve                               | 220     | Repair or replace skin - 405              |
|         | Delay   | 230     | Repair or replace skin - 404              |
|         | Move to 95 95 MAPAB                                 | 240     | Replace damaged nut plates & screws       |
|         | Delay   | 250     | Repair or replace fire seals              |
| 080     | Visual Inspection                                   | 260     | Repair or replace heat shields            |
| 090     | Treat Corrosion                                     | 270     | replace aluminum parts w/ stainless steel |
| 100     | Remove lack wire & cutter pins & replace w/ new mat | 280     | replace damaged nutplates & screws        |
| 110     | Replace Fasteners, nuts, nut plates & screws        | 290     | Install Faring gssy                       |
| 120     | Remove minor scratches, nicks & corrosion           | 300     | Install support link and bush 25          |
| 130     | Repair defects in Threaded areas                    | 310     | Reinstall all parts removed for repairs   |
| 140     | Correct minor separation defects                    | 320     | attach access panels & hardware           |
|         |   |         | Delay                                     |

095 - PIN 65-10526-1 is removed and sent to Bldg 3001 for magnetic particle inspection and then returned, tagged good or bad. This part is interchangeable. The sl assembly repair process continues independent of this inspection.

## FLOW PROCESS CHART

SUBJECT Sleeve Assembly

DATE 4/5/89

PCN: 15236A WCD: 15236A WCDDATE: 88054

CHART BEGINS Operation 010

PAGE OF

CHART ENDS Operation 350

PREPARED BY: Tim Hall

[illegible]



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*****
1 15236A * WORK CONTROL DOCUMENT * MISTR L.DATE 98054 PAGE 1 OF 1 PAGE 1
*****
12.Orig/PROD NR 13.QUANTITY 14.PROD SECTION/RCC 15.DATE SCHLD 16.DATE COMP
| | | MBPAB | 89073 |
|-----|-----|-----|
17.PART NUMBER 19.ITEM SERIAL NR 10/12.TECH DATA/OPTIONAL
| 65-10505-269 | | 1. WORK SPEC. UC 1560FL/
| | | 78-1-45, 77 AND 78.
10.MDCL/DESIGN/SERIES 11.STOCK NR 2. 1C-135B 10. 1C-135(B)
| RC-135 | 15600080/5321FL | C10,
|-----|-----|-----|
13.11.00.14.ROUND/END 11A ROUND
| SLEEVE ASSEMBLY
14.11.00.15.11A. NO LINAX TABLES/65266
11.01.15.11A.
STATION NO. 17.WORK TO BE ACCOMPLISHED 18.MLCH: "11.00"
|-----|-----|-----|
2122 010 RECEIVE & UNCRATE
| MBPAB |
|-----|-----|-----|
2122 020 WASH INTERIOR AND EXTERIOR IAW
| MBPCA | SOW UC1560FL/78-1-45 AND T.O.
| | 1C-135(K)A-3 4 SEC 11 & T.O.
| | 1C-135B-10 SEC 6-64.
|-----|-----|-----|
2122 030 STRIP INTERIOR AND EXTERIOR IAW
| MBPCA | 1C-135B-10 SEC 7 & 11 AND
| | T.O. 1-2.
|-----|-----|-----|
95 040 REMOVE PANELS (-360), (-361) AND
| MBPAB | 1175.
| | REQD_____ NOT REQD_____
|-----|-----|-----|
95 050 REMOVE FAIRING ASSEMBLY P/N
+> | MBPAB | 65-10505-271.
| | REQD_____ NOT REQD_____
|-----|-----|-----|
95 060 REMOVE SUPPORT LINK.
| MBPAB | REQD_____ NOT REQD_____
| | MOVE SLEEVE, LINKS AND ASSOCIATED
| | PARTS TO MBPCA FOR ABRASIVE BLAST
|-----|-----|-----|
2122 070 ABRASIVE BLAST SLEEVE AND
| MBPCA | ASSOCIATED PARTS AND HARDWARE IAW
| | 1C-135(K)A-3-4 SEC 9 AND T.O.
| | 1-2.REQD---NOT REQD---MOVE TO
| | MBPAB
|-----|-----|-----|
95 080 ACCOMPLISH VISUAL INSPECTION IAW
| MBPAB | SOW UC1560FL/78-1-45.
| | REQD_____ NOT REQD_____
|-----|-----|-----|
3001 085 IAW SOW UC1560FL/78 1 45 AND T.O.
| MIPHA | 1C-135B-10 SECTION SIX PERFORM
| | MAGNETIC PARTICLE INSPECTION ON
| | P/N 65-10526-1. REQD---NOT REQD---
| | POST 0-69, MIPHA BLDG 3001
|-----|-----|-----|
95 090 REMOVE CORROSION AND APPLY CORROSION
| MBPAB | PROTECTIVE FINISH TO ALL REWORKED
| | SURFACES IAW T.O. 1C-135(K)A-3 4 &
| | T.O. 1-1-2.
|-----|-----|-----|

```

STATION/OP NO. 117.WORK TO BE ACCOMPLISHED 118.MECH 119"PR" 120"Q"

|      |              |  |   |   |
|------|--------------|--|---|---|
| 95   | 100<br>MBPAB | REMOVE ALL LOCKWIRE AND COTTER PINS<br>REPLACE WITH NEW MATERIAL UPON<br>REASSEMBLY.<br>REQ'D _____ NOT REQ'D _____  | / | / |
| 95   | 110<br>MBPAB | REPLACE CORRODED, LOOSE OR DAMAGED<br>FASTENERS NUTS NOT PLATES AND<br>SCREWS IAW SOW OC1560FL/78-1 45.<br>REQ'D _____ NOT REQ'D _____   | E | / |
| 95   | 120<br>MBPAB | REMOVE BURR SCRATCHES, RIFES<br>AND IMPRESSION BY POLISHING<br>WHEELS OR SAND PAPER TO GLOTH 220<br>GRIT OR FINE.<br>REQ'D _____ NOT REQ'D _____   | / | / |
| 95   | 130<br>MBPAB | REMOVE BURR SCRATCHES, RIFES<br>AND IMPRESSION BY POLISHING<br>WHEELS OR SAND PAPER TO GLOTH 220<br>GRIT OR FINE.<br>REQ'D _____ NOT REQ'D _____   | / | / |
| 95   | 140<br>MBPAB | USE STANDARD ORIGINAL TYPE RIVETS<br>AND/OR ACCEPTED WELDING PROCEDURES<br>TO CORRECT MINOR DEFERATION DEFECTS.<br>REQ'D _____ NOT REQ'D _____   | / | / |
| 3001 | 145<br>MTFIW | WELD HAT RING SECTION AS NECESSARY.<br>REQUIRED --- NOT REQ'D ---<br>WELDING ACCOMPLISHED AT POST K-73   | / | / |
| 95   | 150<br>MBPAB | REPLACE ALL PARTS FOUND<br>UNSERVICABLE OR DAMAGED BEYOND<br>PRESCRIBED OR SAMPLE REPAIR IAW<br>SOW OC1560FL/78-1 45.  | / | / |
| 95   | 155<br>MBPAB | DISASSEMBLE BOX AND PREPARE PARTS<br>FOR INSPECTION.   | / | / |
| 95   | 160<br>MOCIA | PERFORM PENETRANT INSPECTION/CHECK<br>IAW SOW OC1560FL/78-1 45 AND T.O.<br>135B-10 SEC SIX ON THE FOLLOWING<br>PARTS: 65-10527-1 REQ'D --- NOT REQ'D ---<br>65-10527-2 REQ'D --- NOT REQ'D ---<br>69-10330-6 REQ'D --- NOT REQ'D ---<br>65-15604-1 REQ'D --- NOT REQ'D ---<br>69-12671-1 REQ'D --- NOT REQ'D --- | / | / |
| 95   | 165<br>MBPAB | REASSEMBLE BOX AFTER INSPECTION.   | / | / |
| 95   | 180<br>MBPAB | REPLACE LINK BRACKETS 69-10331-5 & 6<br>IAW T.O.1C-135B-10 FIG 8-39 AS REQ'D.<br>REQ'D _____ NOT REQ'D _____   | / | / |
| 95   | 190<br>MBPAB | REPLACE AFT RUB STRIP 66-10259(8EA)<br>BRACKET.<br>REQ'D _____ NOT REQ'D _____   | / | / |

| *****   |              |   |         |       |       |
|---|--------------|---|---------|-------|-------|
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| 15.DISP-16.PDN/   |              |   |         |       |       |
| STATION   | OP NO.       | 17.WORK TO BE ACCOMPLISHED  | 18.MECH | 19"P" | 20"Q" |
| 95  | 200<br>MBPAB | SKIN,P/N 65-10505-407<br>REPAIR____REPLACE____NOT REQD____  |         | /     | /     |
| 95  | 210<br>MBPAB | SKIN, 65-10505-406<br>REPAIR____REPLACE____NOT REQD____   |         | L     | /     |
| 95  | 220<br>MBPAB | SKIN, 65 0505 405<br>REPAIR____REPLACE____NOT REQD____  |         | /     | /     |
| 95  | 230<br>MBPAB | SKIN, 65 10505 404<br>REPAIR____REPLACE____NOT REQD____   |         | E     | /     |
| 95  | 240<br>MBPAB | REPLACE DAMAGED NUT PLATES & SCREWS   |         | /     | /     |
| 95  | 250<br>MBPAB | FIRE SEALS, 283, & 284<br>REPAIR____REPLACE____NOT REQD____   |         | /     | /     |
| 95  | 260<br>MBPAB | HEAT SHIELDS, -831 & -832<br>REPAIR____REPLACE____NOT REQD____  |         | /     | /     |
| 95  | 270<br>MBPAB | REPLACE ALL ALUMINUM PARTS WITH<br>STAINLESS STEEL PARTS 1AW SOW<br>UC560FL/78-11-45                  |         | /     | /     |
| 95  | 280<br>MBPAB | INSPECT & REPLACE DAMAGED NUTPLATES<br>AND SCREWS.<br>REQ'D____NOT REQ'D____                          |         | /     | /     |
| 95  | 290<br>MBPAB | INSTALL FAIRING ASSY (-271). NOTE:<br>PRIOR TO INSTALLATION CONDUCT<br>THOROUGH CLOSE OUT INSPECTION. |         | /     | /     |
| 95  | 300<br>MBPAB | INSTALL SUPPORT LINK AND BUSHINGS<br>REQD____NOT REQD____   |         | /     | /     |
| 95  | 310<br>MBPAB | REINSTALL ALL PARTS REMOVED FOR<br>REPAIRS AND INSPECTION.  |         | /     | /     |
| 95  | 320<br>MBPAB | ATTACH ACCESS PANELS AND HARDWARE<br>SLEEVE.<br>MOVE TO MBPCB   |         | /     | /     |
| 2122  | 330<br>MBPCB | FINAL WASH AND CORROSION TREAT  |         | /     | /     |
| 2122  | 340<br>MBPCB | REFINISH AND PAINT 1AW SOW UC1560FL/<br>78-1-45 AND T.O. 1C-135(K)A-3-4<br>SEC11. MOVE TO MBPAB       |         | /     | /     |
| 95  | 350<br>MBPAB | WORK COMPLETED. CONDITION TAG AND<br>IDENTIFY PER MAINT 65-1  | /       | E     | /     |
|   |              | MABEBS L. MURPHY 3-22-89  |         |       |       |
|   |              | MAQBF T. HAN 3-22-89  |         |       |       |
|   |              | MBPAB D. LEND 3-22-89   |         |       |       |
|   |              | MABSCS H. NGUYEN 3-22-89  |         |       |       |
| *****   |              |   |         |       |       |

15236A

15236B

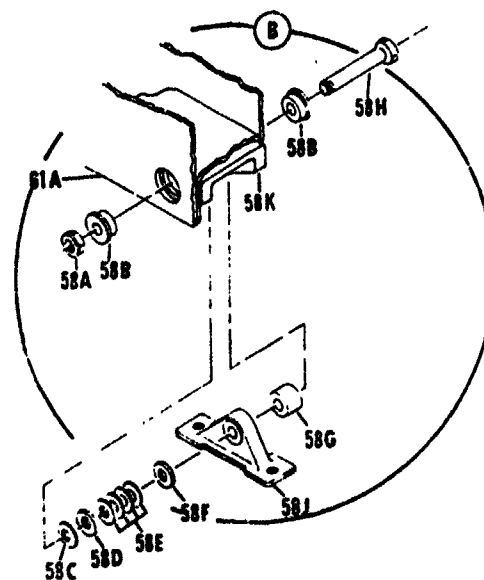
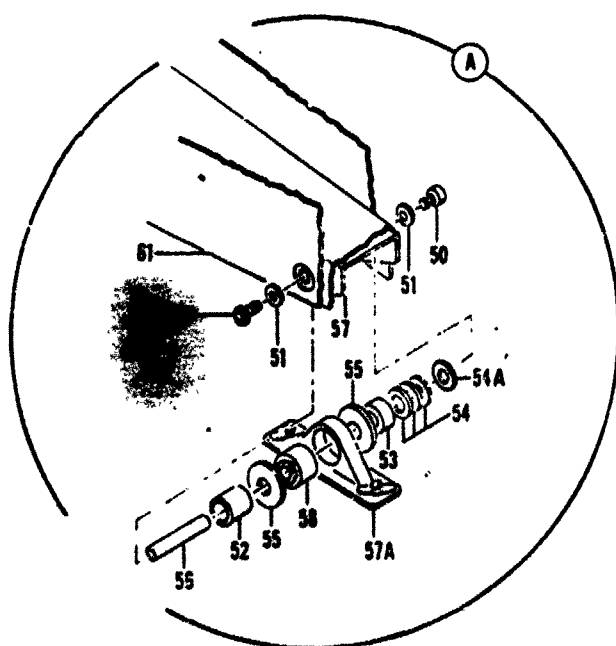
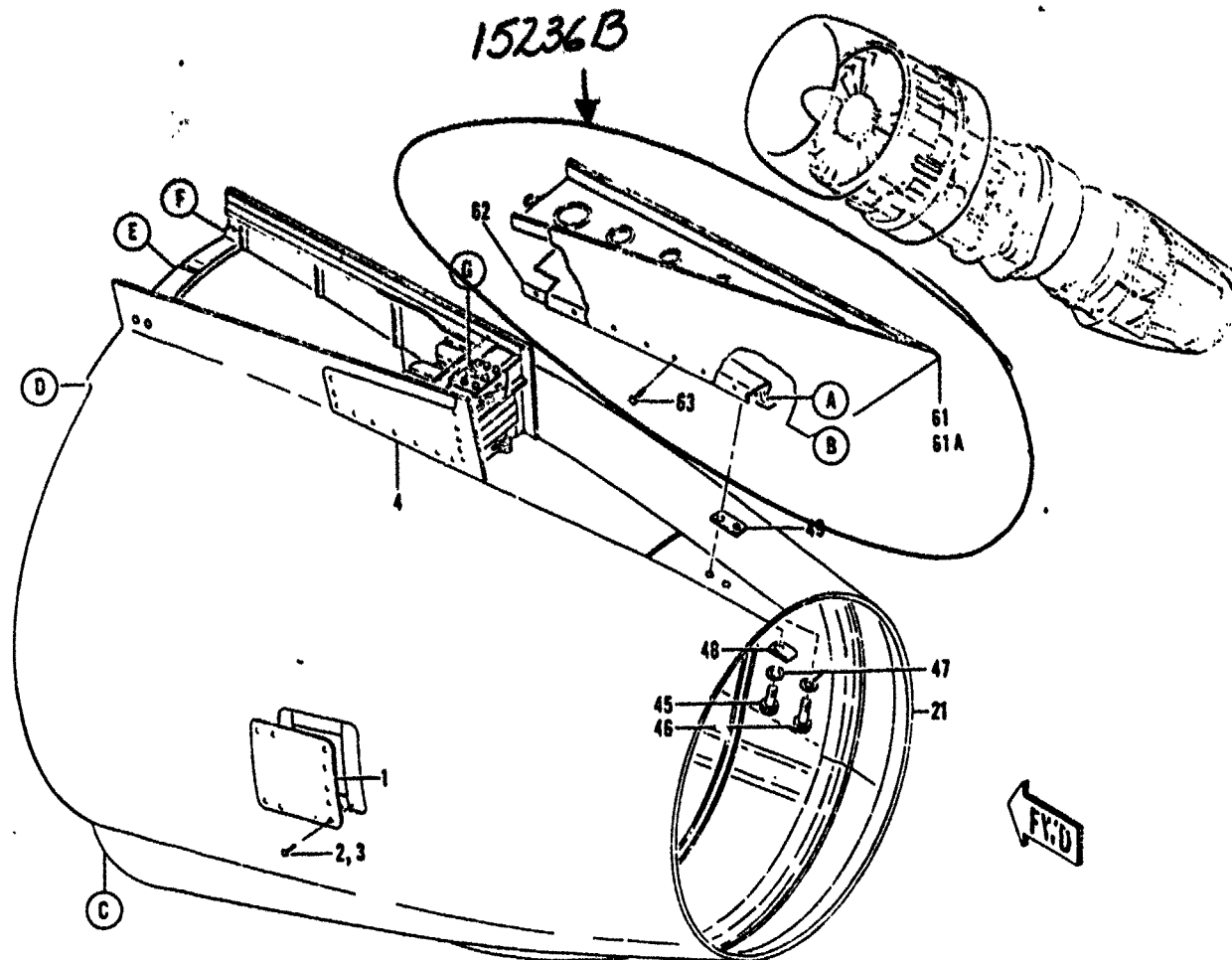


Figure 4-19. Aft Thrust Reverser and Sleeve Assembly (Sheet 1 of 3)

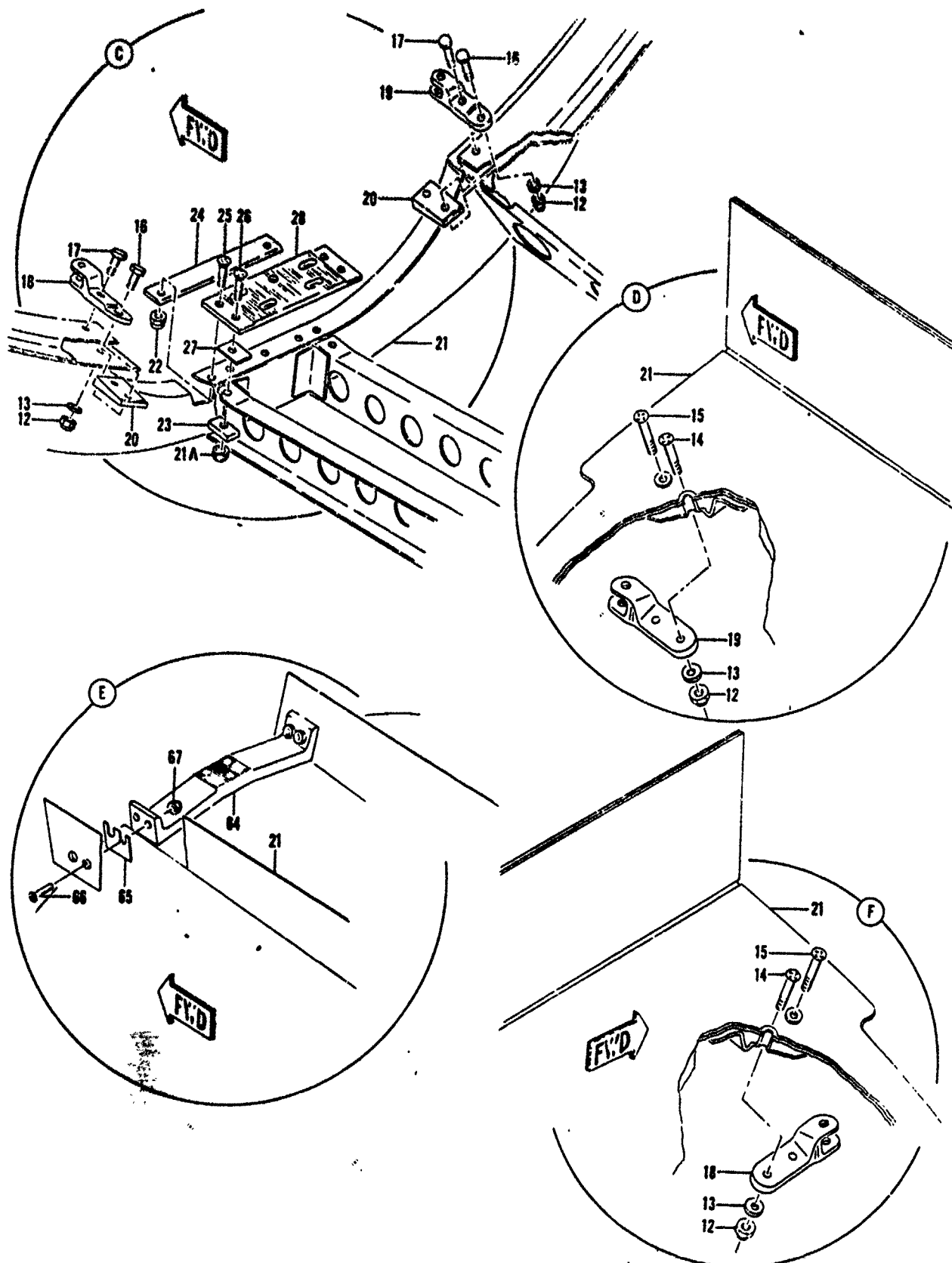


Figure 4-19. Aft Thrust Reverser and Sleeve Assembly (Sheet 2 of 3)

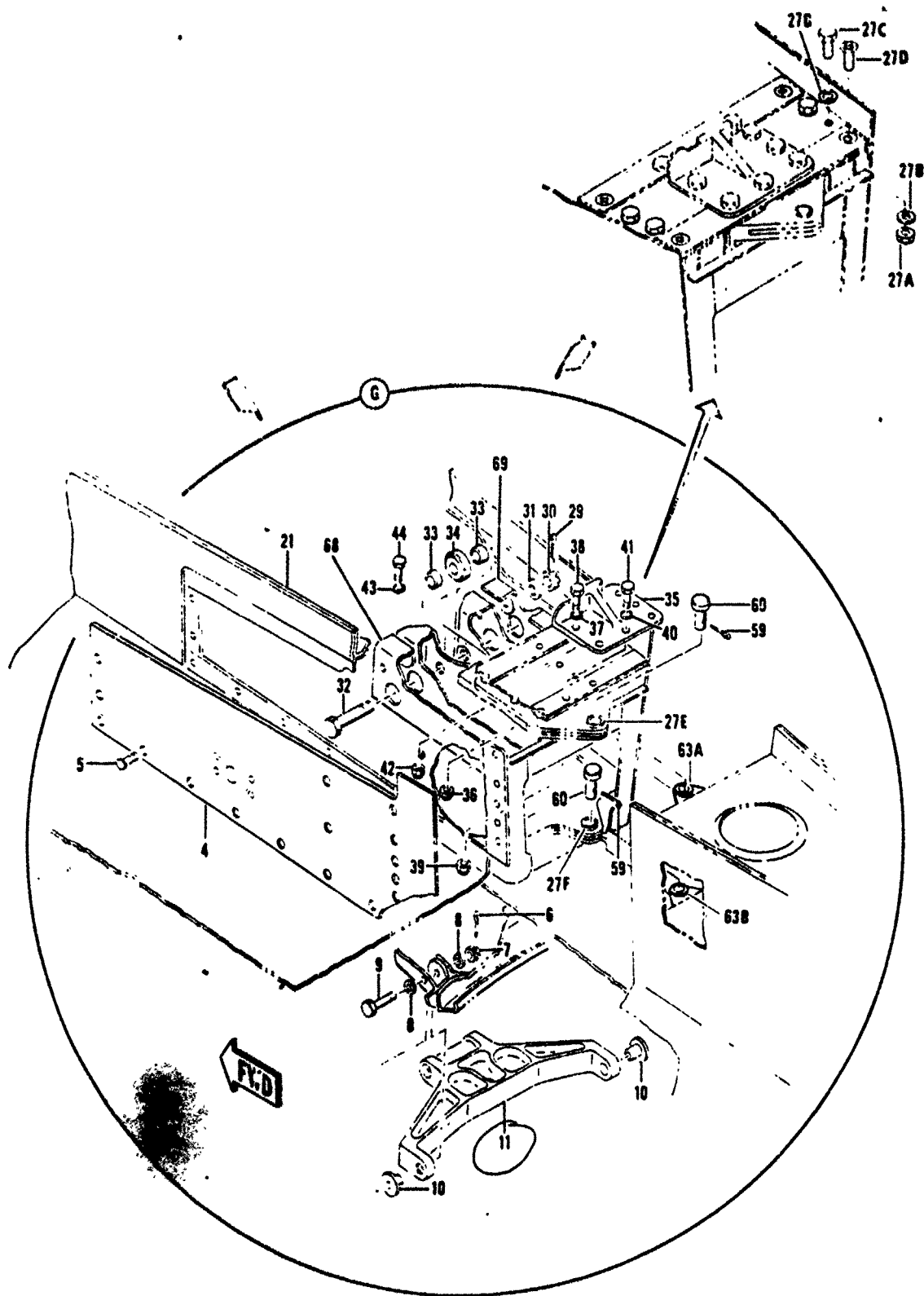


Figure 4-19. Aft Thrust Reverser and Sleeve Assembly (Sheet 3 of 3)

# FLOW PROCESS CHART

SUBJECT FAIRING AFT

DATE 4/10/89

PCN: 15237A WCD: 15238 WCD DATE: 88069

CHART BEGINS 10

CHART ENDS 230

PREPARED BY: R. BOLANOS

| SYMBOLS       | DESCRIPTION                          | SYMBOLS       | DESCRIPTION                     |
|---------------|--------------------------------------|---------------|---------------------------------|
| 10 ● ◊ ◊ ◊ ◊  | REC. & UNCRATE<br>2122 MABPCA        | 100 ○ ◊ ◊ ◊ ◊ | R/R SEAL ASSY #1                |
| ○ ◊ ◊ ◊ ◊     | DELAY                                | 110 ○ ◊ ◊ ◊ ◊ | R/R SEAL ASSY #2                |
| ○ ◊ ◊ ◊ ◊     | MOVE TO STRIP                        | ○ ◊ ◊ ◊ ◊     | DELAY                           |
| ○ ◊ ◊ ◊ ◊     | DELAY                                | ○ ◊ ◊ ◊ ◊     | MOVE TO WASH<br>2280 MABPCA     |
| 20 ● ◊ ◊ ◊ ◊  | STRIP PAINT                          | ○ ◊ ◊ ◊ ◊     | DELAY                           |
| 30 ● ◊ ◊ ◊ ◊  | WASH W/ SOLVENT                      | 210 ● ◊ ◊ ◊ ◊ | WASH                            |
| 40 ● ◊ ◊ ◊ ◊  | DRAIN & CLEAN                        | 210 ● ◊ ◊ ◊ ◊ | REFINISH SURFACE                |
| ○ ◊ ◊ ◊ ◊     | DELAY                                | ○ ◊ ◊ ◊ ◊     | DELAY                           |
| ○ ◊ ◊ ◊ ◊     | MOVE TO SHEETMETAL<br>95 MABPCA      | ○ ◊ ◊ ◊ ◊     | MOVE TO SHEETMETAL<br>95 MABPCA |
| ○ ◊ ◊ ◊ ◊     |                                      | ○ ◊ ◊ ◊ ◊     | DELAY                           |
| 50 ○ ◊ ◊ ◊ ◊  | SHAKEDOWN INSPECTION                 | ○ ◊ ◊ ◊ ◊     | MARK TO 30.                     |
| ○ ◊ ◊ ◊ ◊     |                                      | ○ ◊ ◊ ◊ ◊     | CONDITION & TIE                 |
| ○ ◊ ◊ ◊ ◊     | MOVE TO BLAST<br>2122 MABPCA         | ○ ◊ ◊ ◊ ◊     | DELAY                           |
| ○ ◊ ◊ ◊ ◊     |                                      | ○ ◊ ◊ ◊ ◊     | STORAGE                         |
| 60 ● ◊ ◊ ◊ ◊  | BLAST                                | ○ ◊ ◊ ◊ ◊     |                                 |
| ○ ◊ ◊ ◊ ◊     | DELAY                                | ○ ◊ ◊ ◊ ◊     |                                 |
| ○ ◊ ◊ ◊ ◊     | MOVE TO SHEETMETAL<br>95 MABPCA      | ○ ◊ ◊ ◊ ◊     |                                 |
| ○ ◊ ◊ ◊ ◊     |                                      | ○ ◊ ◊ ◊ ◊     |                                 |
| 70 ● ◊ ◊ ◊ ◊  | REMOVE CARBONAL                      | ○ ◊ ◊ ◊ ◊     |                                 |
| 80 ● ◊ ◊ ◊ ◊  | R/R LOWER BULKHEAD<br>STRUT          | ○ ◊ ◊ ◊ ◊     |                                 |
| 90 ● ◊ ◊ ◊ ◊  | REPLACE SUPPORT FITTING              | ○ ◊ ◊ ◊ ◊     |                                 |
| 100 ● ◊ ◊ ◊ ◊ | R/R FASTENERS                        | ○ ◊ ◊ ◊ ◊     |                                 |
| 110 ● ◊ ◊ ◊ ◊ | STRAIGHTEN ALL MINOR<br>DENTS & BEND | ○ ◊ ◊ ◊ ◊     |                                 |
| 120 ● ◊ ◊ ◊ ◊ | SMOOTH ALL SCRATCHES                 | ○ ◊ ◊ ◊ ◊     |                                 |
| 130 ● ◊ ◊ ◊ ◊ | R/R LEFT & RIGHT SKINS               | ○ ◊ ◊ ◊ ◊     |                                 |
| 140 ● ◊ ◊ ◊ ◊ | REPLACE UPPER BULKHEAD               | ○ ◊ ◊ ◊ ◊     |                                 |
| 150 ● ◊ ◊ ◊ ◊ | " RUB STRIPS                         | ○ ◊ ◊ ◊ ◊     |                                 |
| 160 ● ◊ ◊ ◊ ◊ | " FITTING ASSY                       | ○ ◊ ◊ ◊ ◊     |                                 |
| 170 ● ◊ ◊ ◊ ◊ | " BUSHINGS                           | ○ ◊ ◊ ◊ ◊     |                                 |

2. UNIT/PROD NR 13. QUANTITY 14. PRG SECTION, SEC 15. DATE SCHLD 16. DATE COME  
15237A 1 MBPAB 1 87100 1

7. PART NUMBER 19. ITEM SERIAL NR 18/12. TECH DATA/OPTIONAL  
65-10505-271 1 1C-135(K)A-3-4 C/N: 00-

10. MODEL/DESIGN/SERIES 11. STOCK NR 15691 L/78-1-62, 3 AUG 78  
KC 135 1 1560003174274 FET REQ'D. FILL IN ANY ADD'L WORK

13. RISS: 14. NOON/END ITEM NOON  
PAIRING: AFF  
MULLINAX / MASEP 5/8285

15. DION 16. CON/ SECTION OF NO. 17. WORK TO BE ACCOMPLISHED 11C. REQ'D BY WORK

|      |       |  |   |   |
|------|-------|--|---|---|
| 2121 | 010   | RECEIVE & INSPECT  | / | / |
|      | MBPAB |  |   |   |
| 2122 | 020   | STRIP ALL PAINT IAW 1C-135(K)A-3-4   | / | / |
|      | MBPAB |  |   |   |
| 2122 | 030   | WASH INTERIOR & EXTERIOR WITH SOLVENT P-0680   | / | / |
|      | MBPAB |  |   |   |
|      | 040   | DRAIN AND DRY WITH A LINT FREE CLOTH OR CLEAN DRY COMPRESSED AIR. MOVE TO 0.00       | / | / |
|      | MBPAB |  |   |   |
| 95   | 050   | ACCOMPLISH SHAKEDOWN INSPECTION IAW SDW. ANNOTATE DISCREPANCIES.                     | / | / |
|      | MBPAB |  |   |   |
| 2122 | 060   | ABRASIVE BLAST TO REMOVE EXHAUST DEPOSITS IAW T.O. 1C-135(K)A-3-4. REQ___ NOT REQ___ | / | / |
|      | MBPAB |  |   |   |
| 95   | 070   | REMOVE CORROSION & TREAT IAW T.O. 1C-135(K)A-3-4, SEC IV. REQ___ NOT REQ___          | / | / |
|      | MBPAB |  |   |   |
| 95   | 080   | REPAIR OR REPLACE LOWER BULKHEAD STRUT P/N 65-10505-279 REQ___ NOT REQ___            | / | / |
|      | MBPAB |  |   |   |
| 95   | 090   | REPLACE SUPPORT FITTING, P/N 62-12687-2. REQ___ NOT REQ___ (FITTINGS).               | / | / |
|      | MBPAB |  |   |   |
| 95   | 100   | REPAIR OR REPLACE ALL LOOSE, MISSING OR DEFECTIVE FASTENERS.                         | / | / |
|      | MBPAB |  |   |   |
| 95   | 110   | STRAIGHTEN ALL MINOR DENTS & BENDS. REQ___ NOT REQ___                                | / | / |
|      | MBPAB |  |   |   |
| 95   | 120   | SMOOTH ALL SCRATCHES, ABRASIONS AND NICKS. REQ___ NOT REQ___                         | / | / |
|      | MBPAB |  |   |   |
| 95   | 130   | REPAIR LEFT AND RIGHT SKINS AS REQ. REQ'D___ NO REQ'D___                             | / | / |
|      | MBPAB |  |   |   |



15. DISP 16. (DN)

STATION/UP NO. 17. WORK TO BE ACCOMPLISHED

18. MECH 19. P 20. Q

95 140 REPLACE UPPER BULKHEAD P/N 65-10503-  
 MBPAB 212. REQ NOT REQ

95 150 REPLACE RUB STRIPS 217 & 220  
 MBPAB REQ NOT REQ

95 160 REPLACE FITTING ASSEMBLY P/N  
 MBPAB 69-12689 REQ NOT REQ

95 170 REPLACE BUSHING  
 MBPAB REQ NOT REQ

95 180 REPAIR OR REPLACE SEAL ASSEMBLY P/N  
 MBPAB 69-12695-1. REQ NOT REQ

95 190 REPAIR OR REPLACE SEAL ASSY P/N  
 MBPAB 69-12695-2.  
 REQ NOT REQ

2200 200 FINAL WASH  
 MBPAB

2200 210 REFINISH ALL SURFACES EXCEPT OUTER  
 MBPAB SKIN IAW WORK STATEMENT T.O. 10-  
 135(K)A-3-4. MOVE TO BLDG 95.

95 220 MARK EA FAIRING WITH A PERMANENT  
 MBPAB MEANS OF IDENTIFICATION.

95 230 WORK COMPLETED, CONDITION TAGGED  
 MBPAB IAW AFM 67-L. (NEW TAG)  
 NOTE: PART WILL HAVE ORANGE PUMPS  
 586, 587 OR 588 ID LABELS APPLIED TO  
 COMPLETED ITEM IAW NAUI 66-4.  
 ACCEPTANCE DATE ON THE LABEL ALONG  
 WITH "M" STAP OF THE PERSON PLR  
 FORMING THE OVERHAUL.  
 CAUTION: SURFACES TO WHICH LABELS  
 ARE APPLIED MUST BE FREE OF CONTAM-  
 INATION.

NOTE: COMPLETE "REMARKS" COLUMN OF  
 MELC FORM 1574 AND (A/C) 10-16, THIS  
 PARA. NOT APPLICABLE TO NON-PRO-  
 GRAMMED A/C WORKLOAD.

COORDINATION

MABEBS L. MULLINAX 13 FEB 89

MABSFS D. TANNI 13 FEB 89

MABPAB DONNA LENOX 13 FEB 89

MAWBF TED HAYES 13 FEB 89

15237A

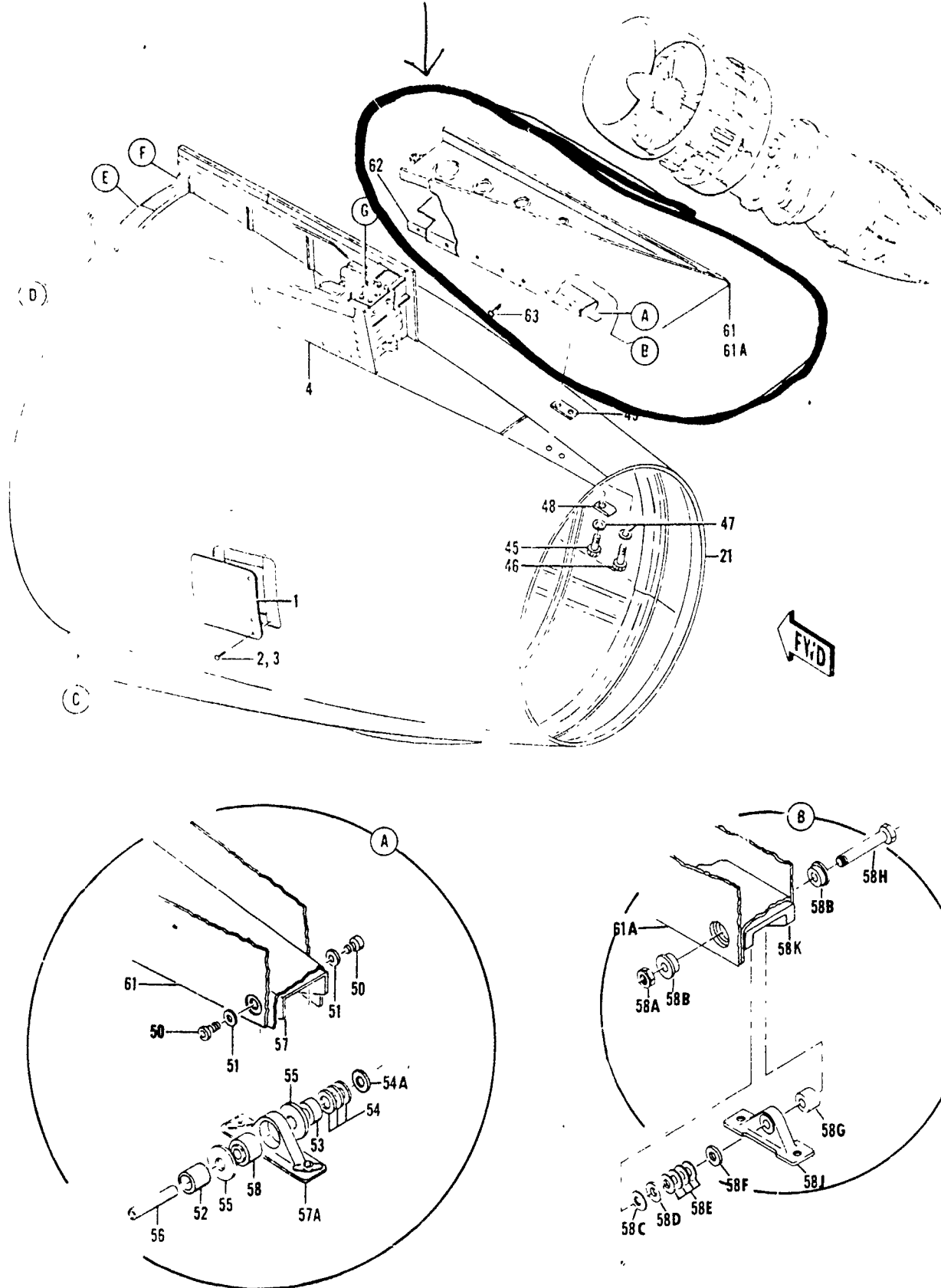


Figure 4-19 Aft Thrust Reverser and Sleeve Assembly (Sheet 1 of 3)

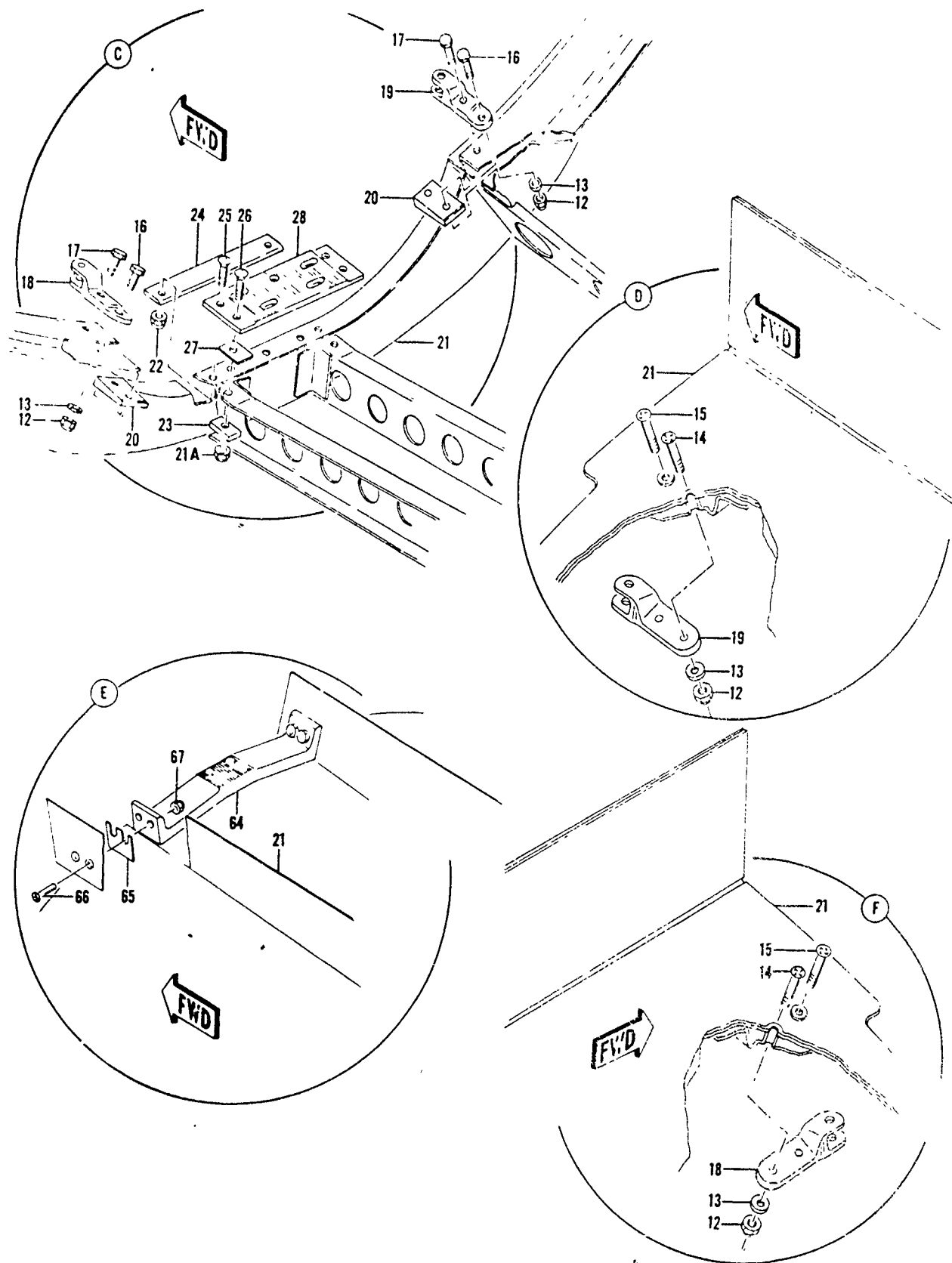


Figure 4-19 Aft Thrust Reverser and Sleeve Assembly (Sheet 2 of 3)

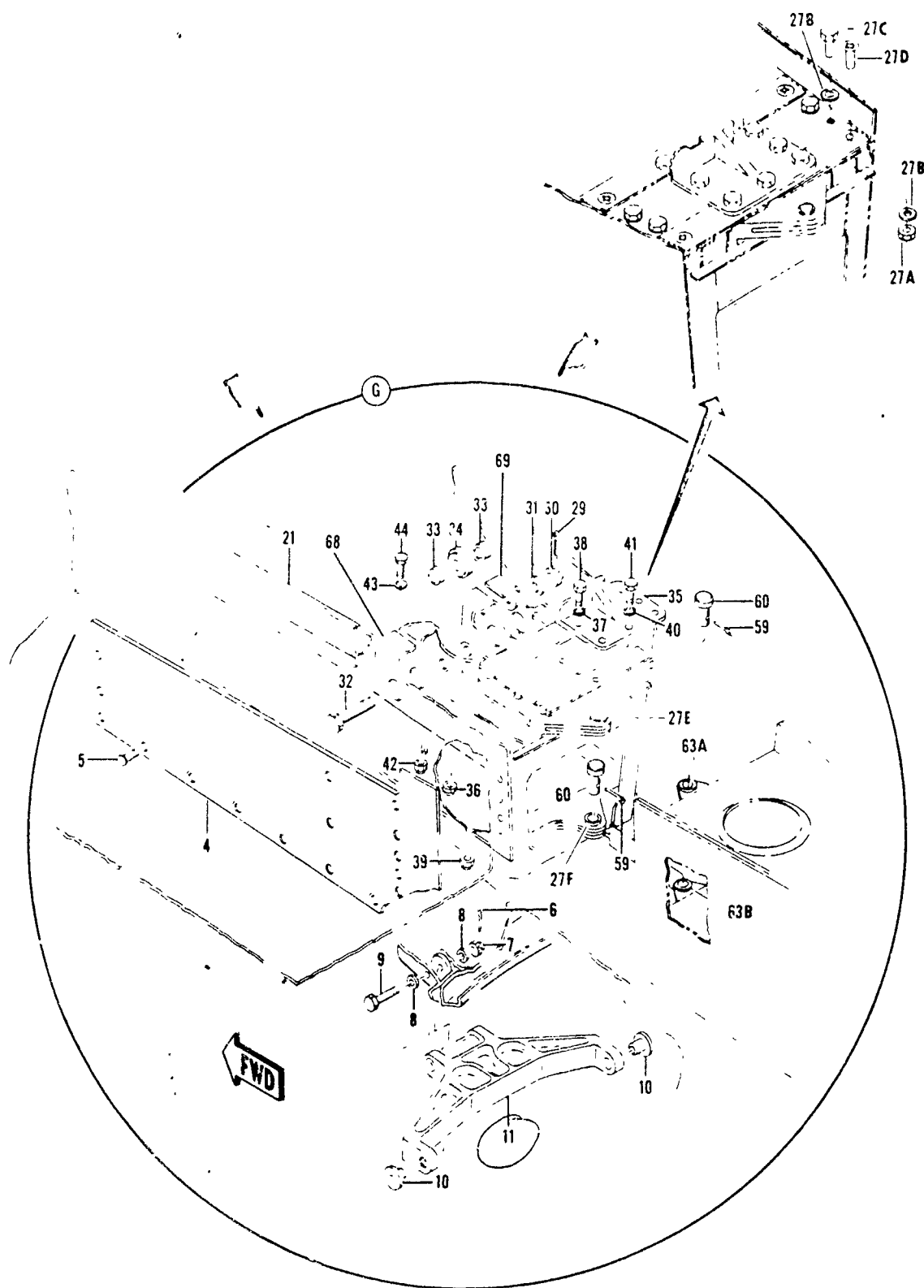


Figure 4-19. Aft Thrust Reverser and Sleeve Assembly (Sheet 3 of 3)

| FIGURE &<br>INDEX NO | PART NUMBER     | DESCRIPTION   | 1 2 3 4 5 6 7 |  |  |  |  |  |  | Ref | ASSY |
|----------------------|-----------------|---|---------------|--|--|--|--|--|--|-----|------|
|                      |                 |   |               |  |  |  |  |  |  |     |      |
| 4-19                 | 65-10505-402    | SLEEVE ASSY, Aft thrust reverser (optional 65-10505-401, 65-10505-353 and 65-10505-269; 65-10505-402 preferred for replacement) (see figure 4-18, index 43) |               |  |  |  |  |  |  | 319 |      |
| -1                   | 65-10505-11     | ACCESS PANEL ASSY, Bottom and sides (ATTACHING PARTS)   |               |  |  |  |  |  |  | 3   |      |
| -2                   | NAS517-3-3      | SCREW (Used on side access panels)  |               |  |  |  |  |  |  | 32  |      |
| -3                   | NAS517-3-2      | SCREW (Used on bottom access panels)  |               |  |  |  |  |  |  | 16  |      |
| -4                   | 65-10505-360    | PANEL ASSY, Access (optional 65-10505-268; 65-10505-360 preferred for replacement)  |               |  |  |  |  |  |  | 1   |      |
|                      | 65-10505-361    | PANEL ASSY, Access (opposite 65-10505-360) (optional 65-10505-254, 65-10505-361 preferred for replacement) (ATTACHING PARTS)                                |               |  |  |  |  |  |  | 1   |      |
| -5                   | NAS517-3-2      | SCREW   |               |  |  |  |  |  |  | 32  |      |
| -6                   | AN381-2-8       | PIN, Cotter   |               |  |  |  |  |  |  | 8   |      |
| -7                   | AN320C4         | NUT   |               |  |  |  |  |  |  | 8   |      |
| -8                   | AN960C416       | WASHER  |               |  |  |  |  |  |  | 16  |      |
| -9                   | BAC-B30BH-4-12  | BOLT  |               |  |  |  |  |  |  | 8   |      |
|                      | 66-10240        | LINK ASSY, Support  |               |  |  |  |  |  |  | 4   |      |
| -10                  | 66-10244        | BUSHING   |               |  |  |  |  |  |  | 2   |      |
| -11                  | 65-10526-1      | LINK  |               |  |  |  |  |  |  | 1   |      |
| -12                  | NAS679C3W       | NUT   |               |  |  |  |  |  |  | 8   |      |
| -13                  | AN960C10        | WASHER  |               |  |  |  |  |  |  | 8   |      |
| -14                  | NAS517-3-13     | SCREW   |               |  |  |  |  |  |  | 2   |      |
| -15                  | NAS517-3-15     | SCREW   |               |  |  |  |  |  |  | 2   |      |
| -16                  | BAC-B30BG-3-13A | BOLT  |               |  |  |  |  |  |  | 2   |      |
| -17                  | BAC-B30BG-3-15A | BOLT  |               |  |  |  |  |  |  | 2   |      |
| -18                  | 65-10527-1      | FITTING, Left lower, right upper  |               |  |  |  |  |  |  | 2   |      |
| -19                  | 65-10527-2      | FITTING, Right lower, left upper  |               |  |  |  |  |  |  | 2   |      |
| -20                  | 66-10240-2      | FILLER, Lower fitting   |               |  |  |  |  |  |  | 2   |      |
| -21                  | 65-10505-403    | SLEEVE ASSY (Preferred replacement for 65-10505-400 and 65-10505-270)   |               |  |  |  |  |  |  | 1   | E    |
| -21                  | 65-10505-400    | SLEEVE ASSY (Optional 65-10505-403 and 65-10505-270, 65-10505-403 preferred for replacement)  |               |  |  |  |  |  |  | 1   | C    |
| -21                  | 65-10505-270    | SLEEVE ASSY (Optional 65-10505-400 and 65-10505-403, 65-10505-403 preferred for replacement)  |               |  |  |  |  |  |  | 1   | D    |
| -21A                 | MS20500-428     | NUT   |               |  |  |  |  |  |  | 2   |      |
| -22                  | MS20500-1032    | NUT   |               |  |  |  |  |  |  | 2   |      |
| -23                  | 66-10240        | FILLER, Radius  |               |  |  |  |  |  |  | 2   |      |
| -24                  | 66-10240-1      | FILLER, Radius  |               |  |  |  |  |  |  | 1   |      |
| -25                  | BAC-B30BF-3-C7  | BOLT  |               |  |  |  |  |  |  | 2   |      |
| -26                  | NAS560HK4-10    | BOLT  |               |  |  |  |  |  |  | 2   |      |
| -27                  | BAC-S40SD-13-17 | SHIM, Laminated (make from BAC1524-62SS)  |               |  |  |  |  |  |  | 2   |      |
| -27A                 | NAS679A3W       | NUT   |               |  |  |  |  |  |  | 8   |      |
| -27B                 | AN960C10L       | WASHER  |               |  |  |  |  |  |  | 8   |      |
| -27C                 | AN3C4A          | BOLT  |               |  |  |  |  |  |  | 4   |      |
| -27D                 | BACB30LH3U3     | BOLT (Optional BACB30BF3C3 or BACB30BF3-3)  |               |  |  |  |  |  |  | 4   |      |
|                      | 69-12671        | FITTING ASSY, Hinge trailing edge fairing   |               |  |  |  |  |  |  | 1   |      |
|                      | 69-12671-1      | FITTING, Hinge  |               |  |  |  |  |  |  | 1   |      |
| -27E                 | NAS77A5-13P     | BUSHING, Flanged  |               |  |  |  |  |  |  | 2   |      |
|                      | 65-15604        | FITTING ASSY, Hinge, aft thrust reverser  |               |  |  |  |  |  |  | 1   |      |
|                      | 65-15604-1      | FITTING, Hinge  |               |  |  |  |  |  |  | 1   |      |
| -27F                 | NAS77A5-13P     | BUSHING, Flanged  |               |  |  |  |  |  |  | 2   |      |
| -28                  | 66-10242        | FITTING, Lower serrated   |               |  |  |  |  |  |  | 1   |      |
| -29                  | AN381-3-14      | PIN, Cotter   |               |  |  |  |  |  |  | 1   |      |
| -30                  | AN320C6         | NUT   |               |  |  |  |  |  |  | 1   |      |
| -31                  | AN960C616       | WASHER  |               |  |  |  |  |  |  | 1   |      |
| -32                  | BAC-B30BH-6-22  | BOLT  |               |  |  |  |  |  |  | 1   |      |
| -33                  | NAS1057T6-028   | SPACER  |               |  |  |  |  |  |  | 2   |      |
| -34                  | AC22063         | BEARING, Needle (60380) (BAC-B10B-317)  |               |  |  |  |  |  |  | 1   |      |
| -35                  | 69-10330-6      | STOP (Optional 69-10330-4) (ATTACHING PARTS)  |               |  |  |  |  |  |  | 1   |      |
| -36                  | NAS679A3W       | NUT   |               |  |  |  |  |  |  | 5   |      |
| -37                  | AN960C10L       | WASHER  |               |  |  |  |  |  |  | 5   |      |
| -38                  | NAS501-3-6A     | BOLT  |               |  |  |  |  |  |  | 5   |      |

| FIGURE INDEX NO | PART NUMBER    | DESCRIPTION   | 1 | 2 | 3 | 4 | 5 | 6 | 7 |    |
|-----------------|----------------|---|---|---|---|---|---|---|---|----|
| 4-19(Cont)      |                |   |   |   |   |   |   |   |   |    |
| -39             | NAS679C3W      | . NUT . . . . .   |   |   |   |   |   |   |   | 1  |
| -40             | AN960C10       | . WASHER . . . . .  |   |   |   |   |   |   |   | 1  |
| -41             | AN3C5A         | . BOLT . . . . .  |   |   |   |   |   |   |   | 1  |
| -12             | NAS679A3W      | . NUT . . . . .   |   |   |   |   |   |   |   | 2  |
| -13             | AN960C10L      | . WASHER . . . . .  |   |   |   |   |   |   |   | 2  |
| -14             | BAC-B30BF-3-6A | . BOLT . . . . .  |   |   |   |   |   |   |   | 2  |
| -15             | AN106A         | . BOLT . . . . .  |   |   |   |   |   |   |   | 1  |
| -16             | AN4C5A         | . BOLT . . . . .  |   |   |   |   |   |   |   | 1  |
| -17             | AN960C116      | . WASHER . . . . .  |   |   |   |   |   |   |   | 2  |
| -18             | 65-10505-824   | . FILLER, Radius (Make from AISI301 sheet per MIL-S-5059, comp 30, str. cond. 2D 1/2 hard, 0.20 x 3.3 x 3.4 inches) |   |   |   |   |   |   |   | 1  |
| -19             | 65-10505-209   | . SHIM, laminated   |   |   |   |   |   |   |   | 1  |
| -20             | VS16796-10     | . SCREW (Optional BACB10A203GD and 65-10505-10H)  |   |   |   |   |   |   |   | 2  |
| -1              | AN960-10L      | . WASHER . . . . .  |   |   |   |   |   |   |   | 2  |
| -2              | NAS42HT10-28   | . SPACER . . . . .  |   |   |   |   |   |   |   | 1  |
| -3              | NAS42HT10-11   | . SPACER . . . . .  |   |   |   |   |   |   |   | 1  |
| -31             | AN960-316      | . WASHER . . . . .  |   |   |   |   |   |   |   | 3  |
| -31A            | AN960-316L     | . WASHER . . . . .  |   |   |   |   |   |   |   | 1  |
| -35             | VS16796-811    | . WASHER (Optional BACB10A203GD)  |   |   |   |   |   |   |   | 2  |
| -36             | 65-11683       | . PIN . . . . .   |   |   |   |   |   |   |   | 1  |
| -37             | 65-12687-2     | . SUPPORT FITTING . . . . .   |   |   |   |   |   |   |   | 1  |
| -37A            | 65-12689-1     | . FITTING ASSY, Anchor, fairing   |   |   |   |   |   |   |   | 1  |
| -38             | 65-12689-1     | . FITTING, Anchor   |   |   |   |   |   |   |   | 1  |
| -38A            | 65-12689-1     | . BEARING (81376) (BACB10A203GD) (optional KWB-5SSG (37613))  |   |   |   |   |   |   |   | 1  |
| -38B            | NAS500-3       | . NUT . . . . .   |   |   |   |   |   |   |   | 1  |
| -38C            | 65-20173-1     | . BUSHING, Flanged . . . . .  |   |   |   |   |   |   |   | 2  |
| -38D            | 65-21131-1     | . SHIM, laminated . . . . .   |   |   |   |   |   |   |   | 1  |
| -38E            | AN960-316      | . WASHER . . . . .  |   |   |   |   |   |   |   | 1  |
| -38F            | AN960-316L     | . WASHER . . . . .  |   |   |   |   |   |   |   | 4  |
| -38G            | NAS42HT10-10   | . SPACER . . . . .  |   |   |   |   |   |   |   | 1  |
| -38H            | NAS42HT10-22   | . SPACER (Make from NAS42HT10-28)   |   |   |   |   |   |   |   | 1  |
| -38I            | BACB30GN5-1    | . BOLT . . . . .  |   |   |   |   |   |   |   | 1  |
| -38J            | 65-30242-1     | . FITTING, Anchor (optional 69-12689-2)   |   |   |   |   |   |   |   | 1  |
| -38K            | 65-20131-1     | . SUPPORT FITTING . . . . .   |   |   |   |   |   |   |   | 1  |
| -38L            | AN960-3-3      | . PIN, Cotter . . . . .   |   |   |   |   |   |   |   | 2  |
| -38M            | VS20392-4C21   | . PIN, Flathead (optional VS20392-4-21)   |   |   |   |   |   |   |   | 2  |
| -38N            | 65-10505-271   | . FAIRING ASSY, Aft . . . . .   |   |   |   |   |   |   |   | 1  |
| -38O            | 65-10505-354   | . FAIRING ASSY, Aft . . . . .   |   |   |   |   |   |   |   | 1  |
| -38P            | 69-12695-1     | . SEAL ASSY, Fairing . . . . .  |   |   |   |   |   |   |   | 1  |
| -38Q            | 69-12695-2     | . SEAL ASSY (Opposite 69-12695-1) . . . . .   |   |   |   |   |   |   |   | 1  |
| -63             | NAS517-3-2     | . SCREW (Optional BACB30LU3-2) . . . . .  |   |   |   |   |   |   |   | 14 |
| -63A            | 65-15593       | . FITTING ASSY, Hinge, aft fairing . . . . .  |   |   |   |   |   |   |   | 1  |
| -63B            | 65-15593-1     | . FITTING, Hinge . . . . .  |   |   |   |   |   |   |   | 1  |
| -63C            | NAS76A5-004P   | . BUSHING, Plain . . . . .  |   |   |   |   |   |   |   | 1  |
| -63D            | 69-12679       | . FITTING ASSY, Hinge, aft fairing . . . . .  |   |   |   |   |   |   |   | 1  |
| -63E            | 69-12679-1     | . FITTING, Hinge . . . . .  |   |   |   |   |   |   |   | 1  |
| -63F            | NAS76A5-004P   | . BUSHING, Plain . . . . .  |   |   |   |   |   |   |   | 1  |
| -63G            | 65-16771-1     | . FITTING, Support . . . . .  |   |   |   |   |   |   |   | 1  |
| -63H            | BACB44SC22-27  | . SHIM (Make from BAC1524-14SS)   |   |   |   |   |   |   |   | AR |
| -63I            | NAS1221-4-15   | . BOLT . . . . .  |   |   |   |   |   |   |   | 4  |
| -63J            | VS20500-428    | . NUT . . . . .   |   |   |   |   |   |   |   | 4  |
| -63K            | 69-10333-1     | . CHANNEL ASSY . . . . .  |   |   |   |   |   |   |   | 1  |
| -63L            | 69-10333-2     | . CHANNEL ASSY . . . . .  |   |   |   |   |   |   |   | 1  |
| -63M            | *65-98055-2    | . KIT ASSY, Aft fairing attach fitting replacement . . . . .  |   |   |   |   |   |   |   | 1  |
| -63N            | 65-99332-2     | . KIT ASSY, Sleeve structure modification . . . . .   |   |   |   |   |   |   |   | 1  |
|                 |                | A Used On 65-10505-269  |   |   |   |   |   |   |   |    |
|                 |                | B Used On 65-10505-353, -401 and -402   |   |   |   |   |   |   |   |    |
|                 |                | C Used On 65-10505-401  |   |   |   |   |   |   |   |    |
|                 |                | D Used On 65-10505-269 and -353   |   |   |   |   |   |   |   |    |
|                 |                | E Used On 65-10505-402  |   |   |   |   |   |   |   |    |
|                 |                | *See detailed illustration B.   |   |   |   |   |   |   |   |    |
|                 |                | Kit consists of items 58A thru 58K.   |   |   |   |   |   |   |   |    |

FLOW PROCESS CHART

SUBJECT AFT FAIRING
DATE 4/4

PCN: 15237A
WCD: 15237A
WCD DATE: 89073

CHART BEGINS \_\_\_\_\_
CHART ENDS \_\_\_\_\_

PREPARED BY: MICHAEL

| SYMBOLS | DESCRIPTION       | SYMBOLS | DESCRIPTION       |
|---------|-------------------|---------|-------------------|
|         | REF-205 FASTENERS |         | DELAY             |
|         | REF-205 FASTENERS |         | REF-205 FASTENERS |
|         | REF-205 FASTENERS |         | REF-205 FASTENERS |
|         | REF-205 FASTENERS |         | REF-205 FASTENERS |
|         | STAIN PRIMER/WASH |         | REF-205 FASTENERS |
|         | DELAY             |         | IDENTIFY ITEM     |
|         | PAINT             |         | WORK COMPLETION   |
|         | DELAY             |         | DELAY             |
|         | FASTENERS PLAST   |         | PAINT             |
|         | DELAY             |         |                   |
|         | PAINT - 15        |         |                   |
|         | DELAY             |         |                   |
|         | ACCOMPLISH CH     |         |                   |
|         | DELAY             |         |                   |
|         | PAINT CONTROL     |         |                   |
|         | DELAY             |         |                   |
|         | REF-205 FASTENERS |         |                   |
|         | REF-205 FASTENERS |         |                   |
|         | REF-205 FASTENERS |         |                   |
|         | REF-205 FASTENERS |         |                   |
|         | REF-205 FASTENERS |         |                   |
|         | REF-205 FASTENERS |         |                   |
|         | REF-205 FASTENERS |         |                   |
|         | REF-205 FASTENERS |         |                   |
|         | DELAY             |         |                   |
|         | REF-205 FASTENERS |         |                   |
|         | DELAY             |         |                   |
|         | REF-205 FASTENERS |         |                   |
|         | REF-205 FASTENERS |         |                   |
|         | REF-205 FASTENERS |         |                   |
|         | REF-205 FASTENERS |         |                   |
|         | REF-205 FASTENERS |         |                   |

**SUBJECT**

AF 7 FAIRING

DATE \_\_\_\_\_

4/4

PCN: 15237A

WCD: 152372

W CODE: 89073

CHART BEGINS

CHART ENDS

PREPARED BY: MICHAEL

[illegible]

\*\*\*\*\*  
 15237A \* WORK CONTROL DOCUMENT \* MISTR 1.DATE 89073 PAGE 1 OF 2 PAGES  
 \*\*\*\*\*  
 12. ORIG/PROD NR 13. QUANTITY 14. PROD SECTION/RCC 15. DATE SCHED 16. DATE COMP  
 15237A | | MBPAB | 09093 |  
 17. PART NUMBER 19. ITEM SERIAL NR 18/12. TECH DATA/OPTIONAL  
 65 10505-271 | | 1C-135(K)A-3-4 C/N: DC-  
 1560FL/78-1-62, 3AUG78  
 10. MODEL/DESIGN/SERIES 11. STOCK NR 12. FILL IN ANY ADD'L WORK  
 KC-135 | 1560008174274FL | REQ'D.  
 13. DISC 14. NOUN/END ITEM NOUN  
 | PAIRING, AFT  
 PHYLLIS HEALD/MBPAB/65265  
 15. DISP 16. PDN/  
 17. WORK TO BE ACCOMPLISHED 18. MECH 19. P 20. W  
 2122 010 RECLIVE & UNCRATE /  
 MBPCA  
 2122 020 STRIP ALL PAINT IAW 1C-135(K)A-3-4 / /  
 MBPCA  
 2122 030 WASH INTERIOR & EXTERIOR WITH / /  
 MBPCA SOLVENT P-D680  
 2122 040 ABRASIVE BLAST TO REMOVE EXHAUST / /  
 MBPCA DEPOSITS IAW 1C-135(K)A-3-4  
 REQ'D \_\_\_\_\_ NOT REQ'D \_\_\_\_\_  
 2122 050 DRAIN & DRY WITH LINT FREE CLOTH OR / /  
 MBPCA CLEAN DRY COMPRESSED AIR  
 2122 060 TREAT FOR CORROSION 1C-135(K)A-3-4 / /  
 MBPCA SEC IV. MOVE TO MBPAB, BLDG 95.  
 95 070 ACC SHAKEDOWN INSP. IAW WORK STATE /  
 MBPAB MENT. ANNOTATE DISCREPANCIES.  
 95 080 REMOVE CORROSION & TREAT IAW 1C-135 / /  
 MBPAB A-3-4 SEC IV.  
 REQ'D \_\_\_\_\_ NOT REQ'D \_\_\_\_\_  
 95 090 REPLACE BUSHINGS P/N NAS76A5-004P / /  
 MBPAB (2 PLACES ON UPPER / LOWER HINGE  
 FITTINGS).  
 95 100 REPLACE SUPPORT FITTING 69-27531 1 / /  
 MBPAB REQ'D \_\_\_\_\_ NOT REQ'D \_\_\_\_\_  
 95 110 REPAIR OR REPLACE ALL LOOSE, MISSING / E /  
 MBPAB OR DEFECTIVE FASTENERS.  
 95 120 STRAIGHTEN ALL MINOR DENTS & BENDS / /  
 MBPAB REQ'D \_\_\_\_\_ NOT REQ'D \_\_\_\_\_  
 95 130 SMOOTH ALL SCRATCHES, ABRASIONS, & / E /  
 MBPAB NICKS  
 REQ'D \_\_\_\_\_ NOT REQ'D \_\_\_\_\_  
 95 140 REPAIR LEFT & RIGHT SKIN AS REQ'D. / E /  
 MBPAB REQ'D \_\_\_\_\_ NOT REQ'D \_\_\_\_\_



\*\*\*\*\*  
 15237A \* WORK CONTROL DOCUMENT \* MISTR 1.DATE 37073 PAGE 2 OF 2 PAULS

15.DISP-16.PDN/

STATION/UP NO. 117.WORK TO BE ACCOMPLISHED

18.MECH 19"P" 20"Q"

|      |              |   |   |   |   |
|------|--------------|---|---|---|---|
| 75   | 145<br>MBPAB | REPLACE RUB STRIPS, -217 & -220.<br>REQ'D _____ NOT REQ'D _____   |   | / | / |
|      | 150          | MOVE TO BLDG 2200, MBPAB. <i>N/A</i>  |   |   |   |
| 2280 | 160<br>MBPAB | FINAL WASH.   |   | / | / |
| 2280 | 170<br>MBPAB | REFINISH ALL SURFACES EXCEPT OUTER<br>SKIN IAW WORK STATEMENT T.O. 1C<br>135(K)A 3 4. PARA. 11 30, MOVE TO<br>BLDG 95, MBPAB.   |   | / |   |
| 95   | 100<br>MBPAB | MARK LA FAIRING WITH A PERMANENT<br>MEANS OF IDENTIFICATION.  |   | / | / |
| 95   | 190<br>MBPAB | WORK COMPLETED, CONDITION TAGGED<br>IAW AFM 87 1, MOVE TO CRATING<br>NOTE: PART WILL HAVE OC ALC FORMS<br>506,507 OR 508 ID LABELS APPLIED TO<br>COMPLETED ITEM IAW. NO 66 4.<br>ACCEPTANCE DATE ON THE LABEL ALONG<br>WITH "M" STAMP OF THE PERSON PER-<br>FORMING THE OVERHAUL.<br>CAUTION: SURFACES TO WHICH LABELS<br>ARE APPLIED MUST BE FREE OF CONTAM-<br>INATION.<br>NOTE: COMPLETE "REMARKS" COLUMN OF<br>AFLC FORM 1574 IAW MAOI 66-36, THIS<br>PARA. NOT APPLICABLE TO NON PRO-<br>GRAMMED A/C WORKLOAD. | / | E | / |
|      |              | COORDINATION  |   |   |   |
|      |              | MABEBS  |   |   |   |
|      |              | MABSCS  |   |   |   |
|      |              | MBPAB   |   |   |   |
|      |              | MBQBF   |   |   |   |

?15237A  
RECORD NOT FOUND 152

ENTER DATA AS NEEDED  
PROD ...ELSE 'END'

<----->

?15237A

| RCC   | FAC | PROD   | NO    | OPER             | DESCRIPTION   | SK      | OCC  | T/S | HOURS | TECH |
|-------|-----|--------|-------|------------------|---------------|---------|------|-----|-------|------|
| MBPAB | F   | 15237A | 00B10 | REPAIR           | FAIRING AFT   | 004N FS | 1.00 | N   | 28.00 | E    |
| MBPCA | B   | 15237A | 00C10 | WASH&STRIP       | FAIRING AFT   | 004N WL | 1.00 | N   | 1.00  | E    |
| MBPCB | D   | 15237A | 00C20 | FINAL WASH&PAINT | FRNG AFT      | 004N B3 | 1.00 | N   | 2.00  | E    |
| MBPCD | B   | 15237A | 00C30 | UNCRATE          | FAIRING AFT   | 004N CQ | 1.00 | N   | .40   | E    |
| MBPAB | F   | 15237A | 00D10 | SHAKEDOWN        | INSP FRNG AFT | 004N FS | 1.00 | N   | .60   | E    |
| MBPAB | F   | 15237A | 00J10 | FAIRING          | ASSY. AFT MFG | K235 FS | 1.00 | N   | 2.00  | E    |

ENTER DATA AS NEEDED  
PROD ...ELSE 'END'

<----->

| FIGURE &<br>INDEX NO. | PART NUMBER       | DESCRIPTION   | UNITS<br>PER<br>ASSY | USE<br>ON<br>CODE |
|-----------------------|-------------------|---|----------------------|-------------------|
|                       |                   | 1 2 3 4 5 6 7   |                      |                   |
| 25 -                  | 5-88190-105       | AILERON AND TAB ASSY, OUTBOARD WING (LH) (FOR NHA SEE . . FIG. 24)  | REF                  |                   |
|                       | 5-88190-106       | AILERON AND TAB ASSY, OUTBOARD WING (RH) (FOR NHA SEE . . FIG. 24)  | REF                  |                   |
|                       | 5-88190-103       | AILERON ASSY, OUTBOARD WING (LH ONLY) . . . . .   | 1                    |                   |
|                       | 5-88190-117       | AILERON ASSY, OUTBOARD WING (FOR SPARES ONLY) . . . . .   | REF                  |                   |
|                       |                   | (CONSISTS OF PARTS DENOTED BY (S)) (LH ONLY)  |                      |                   |
|                       | 5-88190-104       | AILERON ASSY, OUTBOARD WING (RH ONLY) . . . . .   | 1                    |                   |
|                       | 5-88190-118       | AILERON ASSY, OUTBOARD WING (FOR SPARES ONLY) . . . . .   | REF                  |                   |
|                       |                   | (CONSISTS OF PARTS DENOTED BY (S)) (RH ONLY)  |                      |                   |
| 1                     | (S)740D10-12.     | JUMPER ASSY, COP BOND 38 AMP (91812) (ALTERNATE . . . 4E3E (79550)) (BACJ40D10-12) (ATTACHING PARTS)                              | 4                    |                   |
|                       | (S)AN3-11A        | BOLT (FOR REPLACEMENT ORDER BACB3ONE3-12) . . . . .   | 4                    |                   |
|                       | (S)NASS17-3-1     | SCREW (FOR REPLACEMENT ORDER BACB3OLU3-2) . . . . .   | 2                    |                   |
|                       | (S)NASS14P1032-10 | SCREW . . . . .   | 2                    |                   |
|                       | (S)BACN10P44AL    | WASHER, PLAIN . . . . .   | 4                    |                   |
|                       | (S)BACN10P63AL    | WASHER, PLAIN . . . . .   | 6                    |                   |
|                       | (S)AN341-10       | NUT (FOR REPLACEMENT ORDER MS20341-10A) . . . . .   | 2                    |                   |
|                       | (S)BAC840A13-29   | SHIM, LAM, 0.30 IN. THK . . . . .   | AR                   |                   |
|                       | (S)5-88190-23     | FILLER, AILERON, OUTBOARD WING. . . . .   | 4                    |                   |
|                       | (S)NAB679A3V      | NUT (FOR REPLACEMENT ORDER 96-02 (56878) (80539). . . H10-3EAC (15653) T6S1032J (71087) RMLH9075-3W (72962) (BACN10JC3))          | 8                    |                   |
| 2                     | 65-8435-3         | PANEL ASSY, HONEYCOMB, OUTBOARD AILERON, HALF, . . . INBOARD, UPPER (FOR REPLACEMENT ORDER 65-8435-9) (LH ONLY)                   | 1                    |                   |
| 2                     | 65-8435-13        | PANEL ASSY, HONEYCOMB, OUTBOARD AILERON, HALF, . . . INBOARD, UPPER (FOR REPLACEMENT ORDER 65-8435-9) (LH ONLY)                   | 1                    |                   |
|                       | 65-8435-4         | PANEL ASSY, HONEYCOMB, OUTBOARD AILERON, HALF, . . . INBOARD, UPPER (FOR REPLACEMENT ORDER 65-8435-9) (RH ONLY)                   | 1                    |                   |
|                       | 65-8435-14        | PANEL ASSY, HONEYCOMB, OUTBOARD AILERON, HALF, . . . INBOARD, UPPER (FOR REPLACEMENT ORDER 65-8435-9) (FOR SPARES ONLY) (RH ONLY) | 1                    |                   |
| 3                     | 65-8435-1         | PANEL ASSY, HONEYCOMB, OUTBOARD AILERON, HALF, . . . INBOARD, LOWER (FOR REPLACEMENT ORDER 65-8435-9) (LH ONLY)                   | 1                    |                   |
| 3                     | 65-8435-11        | PANEL ASSY, HONEYCOMB, OUTBOARD AILERON, HALF, . . . INBOARD, LOWER (FOR REPLACEMENT ORDER 65-8435-9) (FOR SPARES ONLY) (LH ONLY) | 1                    |                   |
|                       | 65-8435-2         | PANEL ASSY, HONEYCOMB, OUTBOARD AILERON, HALF, . . . INBOARD, LOWER (FOR REPLACEMENT ORDER 65-8435-9) (RH ONLY)                   | 1                    |                   |
|                       | 65-8435-12        | PANEL ASSY, HONEYCOMB, OUTBOARD AILERON, HALF, . . . INBOARD, LOWER (FOR REPLACEMENT ORDER 65-8435-9) (FOR SPARES ONLY) (RH ONLY) | 1                    |                   |
| 4                     | 5-97697-1         | PANEL ASSY, HONEYCOMB, OUTBOARD AILERON, HALF, . . . OUTBOARD, UPPER (FOR REPLACEMENT ORDER 5-97697-16)                           | 1                    |                   |
| 4                     | 5-97697-17        | PANEL ASSY, HONEYCOMB SKIN, OUTBOARD AILERON, HALF, . . . OUTBOARD, UPPER (FOR REPLACEMENT ORDER 5-97697-16)                      | 1                    |                   |
| 5                     | 5-97697-18        | PANEL ASSY, HONEYCOMB, OUTBOARD AILERON, HALF, . . . OUTBOARD, LOWER (FOR REPLACEMENT ORDER 5-97697-16)                           | 1                    |                   |
| 5                     | 5-97697-18        | PANEL ASSY, HONEYCOMB SKIN, OUTBOARD AILERON, HALF, . . . OUTBOARD, LOWER (FOR REPLACEMENT ORDER 5-97697-16)                      | 1                    |                   |
|                       | 9-64577-131       | TRAILING EDGE INSTL, OUTBOARD AILERON (LH ONLY) . . .   | 1                    |                   |
|                       | (S)9-64577-131    | TRAILING EDGE INSTL, OUTBOARD AILERON (FOR SPARES . . ONLY) (CONSISTS OF PARTS DENOTED BY (S)) (LH ONLY)                          | 1                    |                   |
|                       | 9-64577-132       | TRAILING EDGE INSTL, OUTBOARD AILERON (RH ONLY) . . .   | 1                    |                   |
|                       | (S)9-64577-132    | TRAILING EDGE INSTL, OUTBOARD AILERON (FOR SPARES . . ONLY) (CONSISTS OF PARTS DENOTED BY (S)) (RH ONLY)                          | 1                    |                   |
|                       | (S)9-64577-133    | TRAILING EDGE ASSY, INBOARD, OUTBOARD AILERON . . . (LH ONLY)   | 1                    |                   |

# Wing Control Surfaces

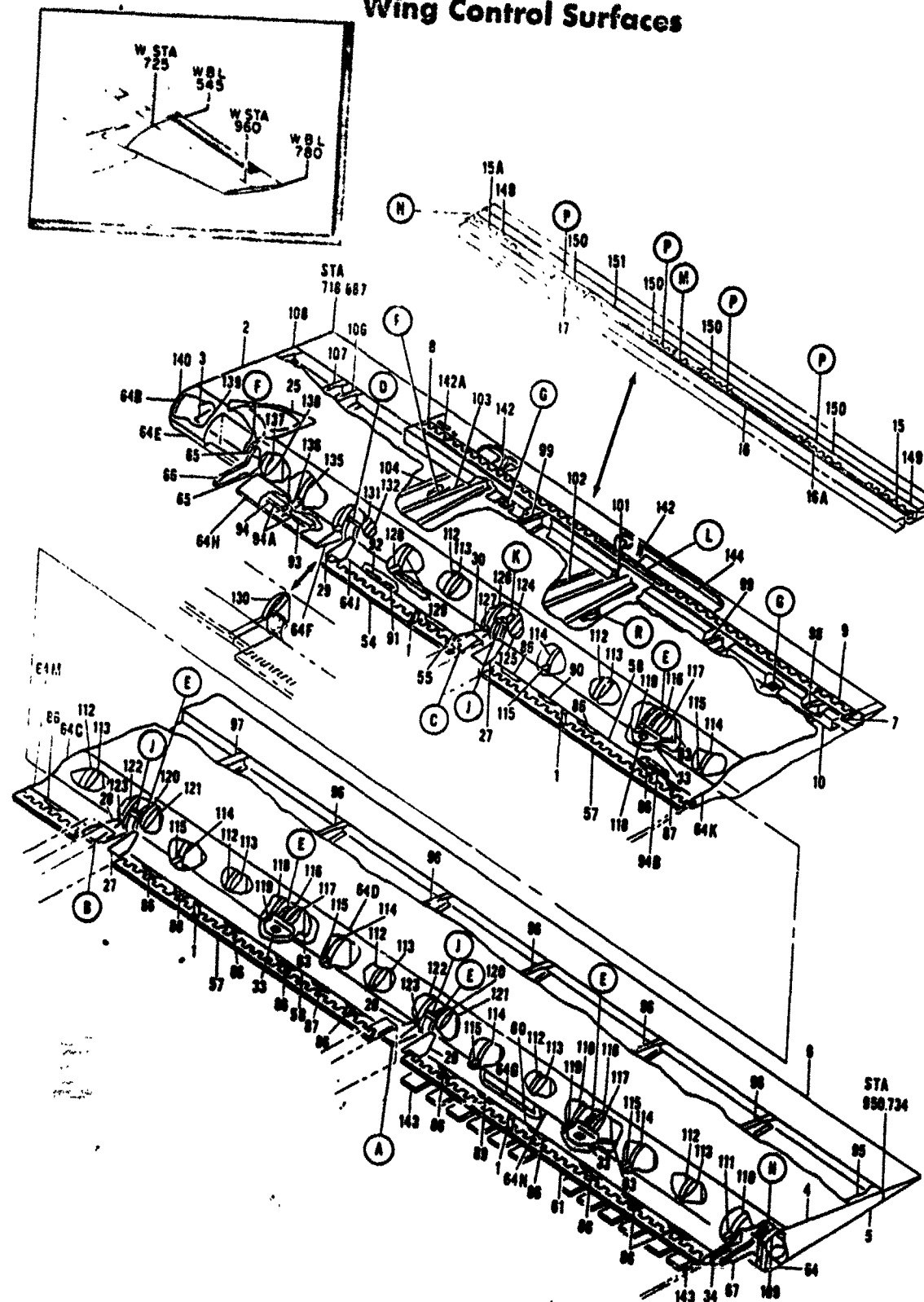
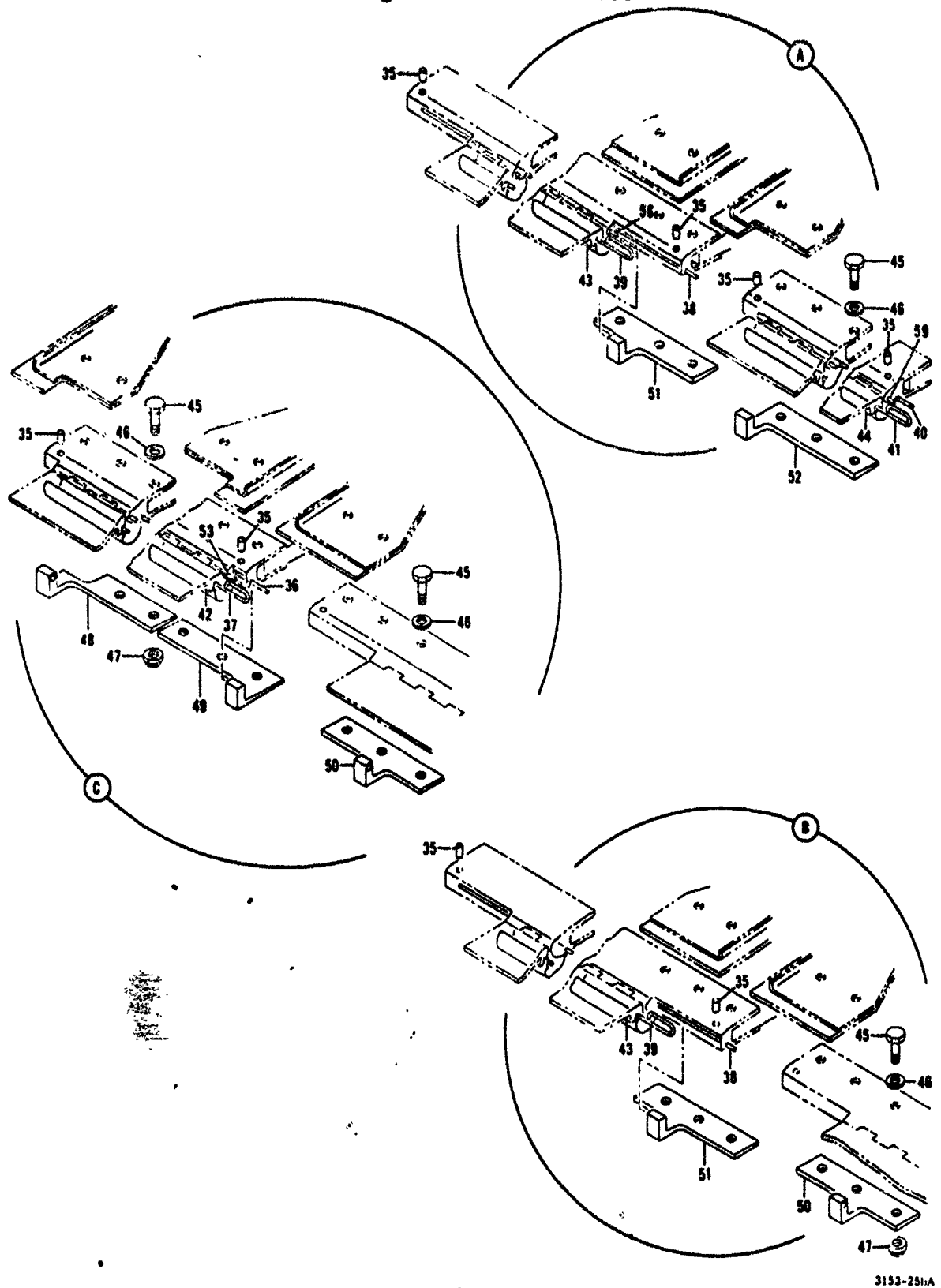


Figure 25. Outboard Wing Aileron and Tab Assemblies (Sheet 1 of 5)

3153-25a1

## Wing Control Surfaces



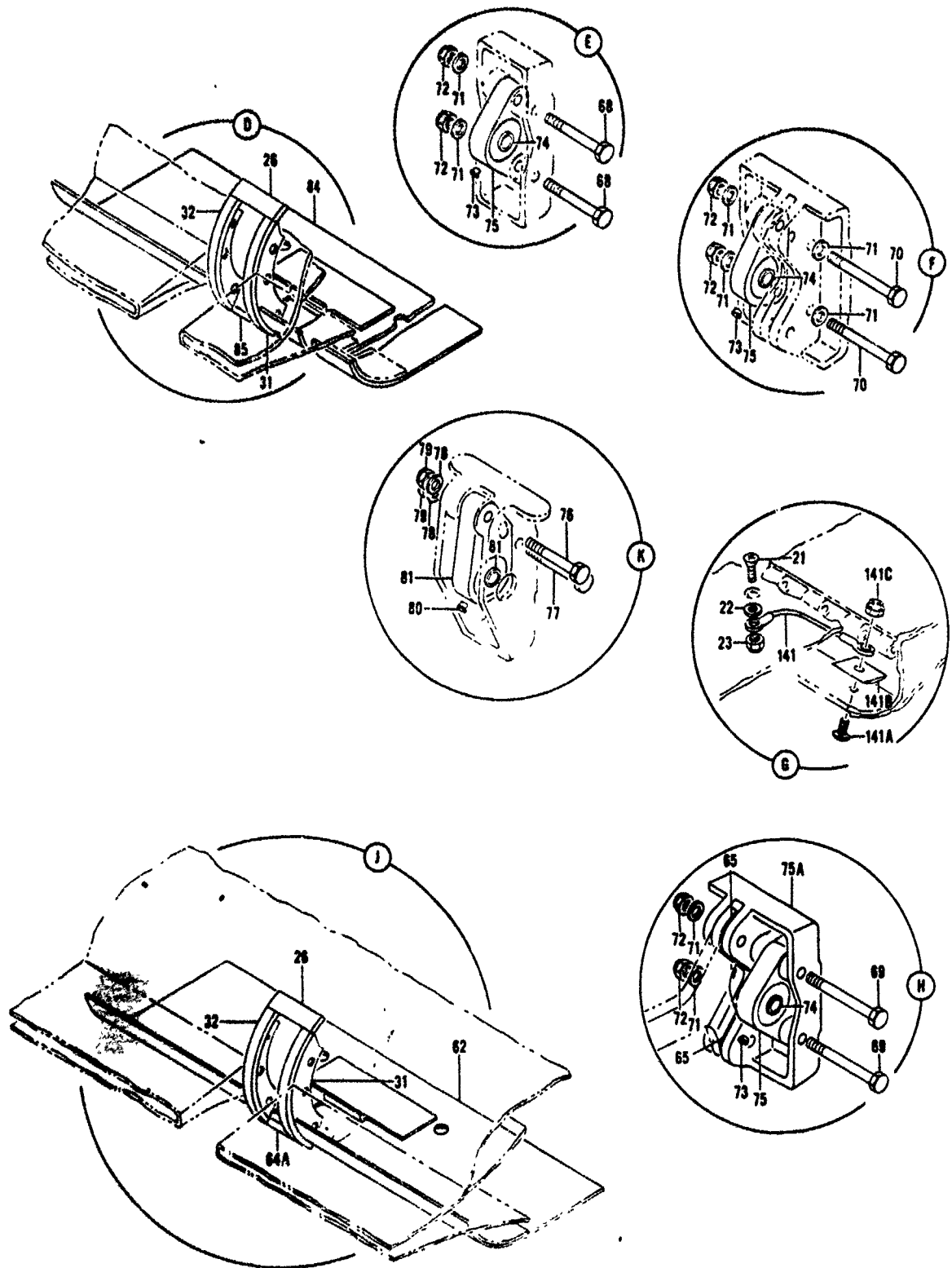
3153-251A

Figure 25. Outboard Wing Aileron and Tab Assemblies (Sheet 2 of 5)

CHANGED 28 JUN 1965

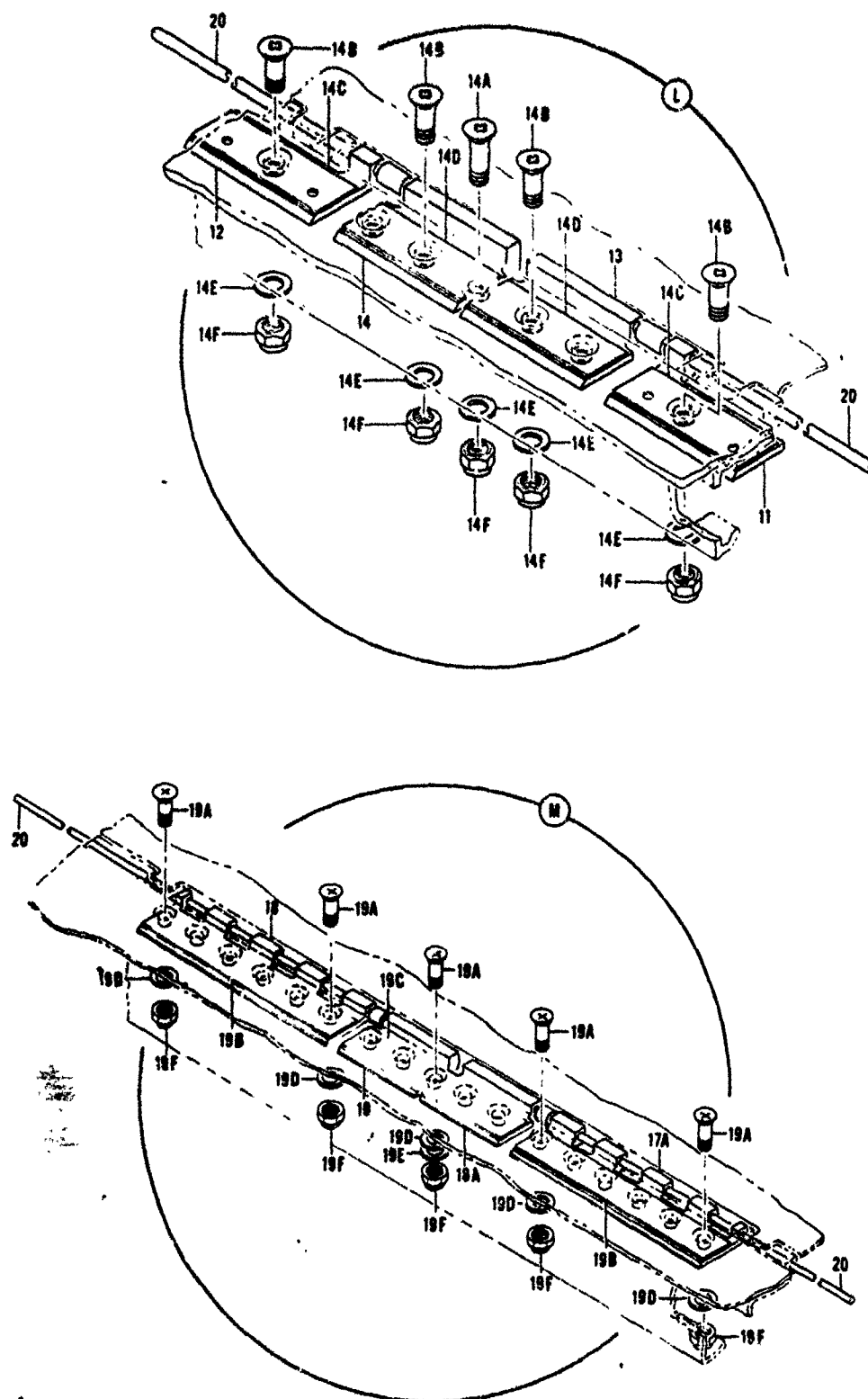
2-61

# Wing Control Surfaces



3153-25cA

Figure 25. Outboard Wing Aileron and Tab Assemblies (Sheet 3 of 5)

**Wing Control Surfaces**

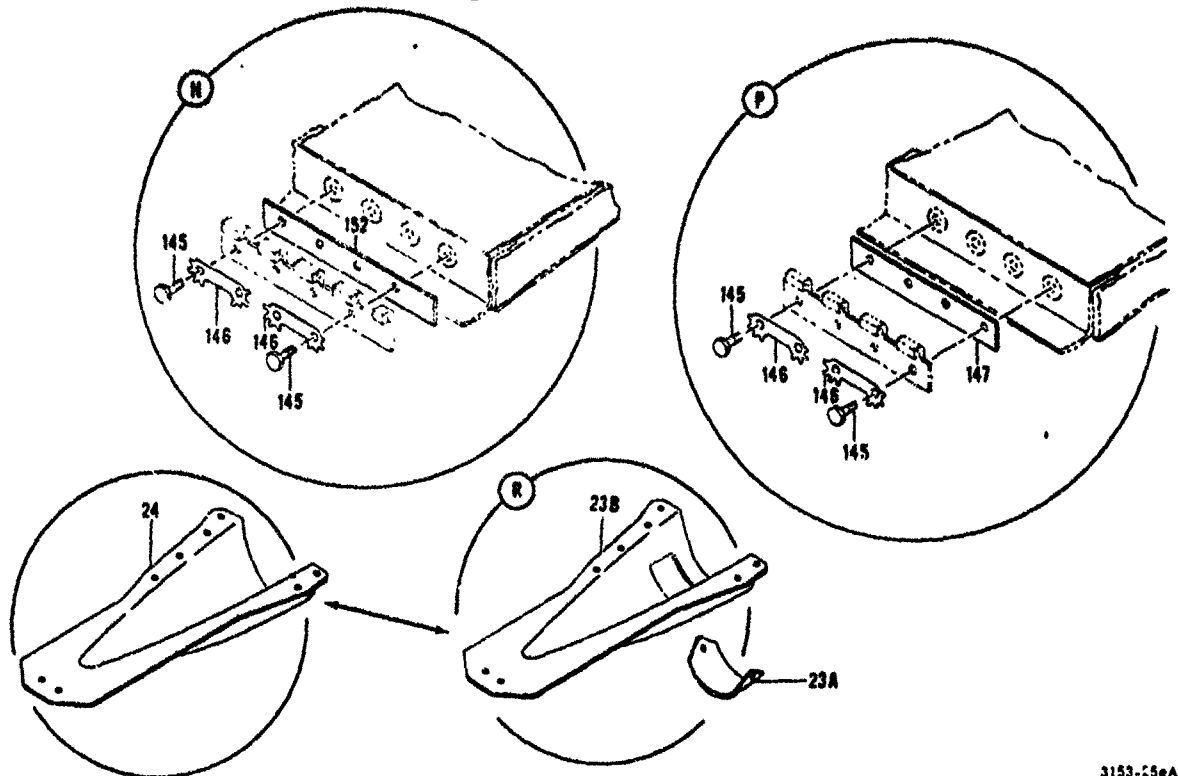
3153-25dA

**Figure 25. Outboard Wing Aileron and Tab Assemblies (Sheet 4 of 5)**

CHANGED 28 JUNE 1965

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# Wing Control Surfaces



3153-156A

Figure 25. Outboard Wing Aileron and Tab Assemblies (Sheet 5 of 5)

| FIGURE &<br>INDEX NO. | PART NUMBER    | DESCRIPTION |  |          |        |           |                   |             | UNITS<br>PER<br>ASSY | USE<br>ON<br>CODE |
|-----------------------|----------------|-------------|--|----------|--------|-----------|-------------------|-------------|----------------------|-------------------|
|                       |                | 1           | 2  | 3        | 4      | 5         | 6                 | 7           |                      |                   |
| 25 -                  | (S)9-64577-134 | . . .       | TRAILING                                   | EDGE     | ASSY,  | INBOARD,  | OUTBOARD          | AILERON . . | 1                    |                   |
|                       |                |             | (RH ONLY)                                  |          |        |           |                   |             |                      |                   |
| 6                     | (S)9-64577-85  | . . .       | TRAILING                                   | EDGE     | ASSY,  | OUTBOARD, | OUTBOARD          | AILERON . . | 1                    |                   |
|                       |                |             | (LH ONLY)                                  |          |        |           |                   |             |                      |                   |
|                       | (S)9-64577-86  | . . .       | TRAILING                                   | EDGE     | ASSY,  | OUTBOARD, | OUTBOARD          | AILERON . . | 1                    |                   |
|                       |                |             | (RH ONLY)                                  |          |        |           |                   |             |                      |                   |
| 7                     | 66-14038-1     | . . .       | RETAINER,                                  | PIN,     | HINGE, | OUTBOARD  | AILERON . . . . . |             | 1                    |                   |
|                       |                |             | (LH ONLY)                                  |          |        |           |                   |             |                      |                   |
|                       | 66-14038-2     | . . .       | RETAINER,                                  | PIN,     | HINGE, | OUTBOARD  | AILERON . . . . . |             | 1                    |                   |
|                       |                |             | (RH ONLY)                                  |          |        |           |                   |             |                      |                   |
| 8                     | 69-6177-1      | . . .       | HINGE-HALF,                                | TRAILING | EDGE   | BEAM,     | OUTBOARD          | AILERON     | 1                    |                   |
|                       |                |             | (LH ONLY)                                  |          |        |           |                   |             |                      |                   |
|                       | 69-6177-2      | . . .       | HINGE-HALF,                                | TRAILING | EDGE   | BEAM,     | OUTBOARD          | AILERON     | 1                    |                   |
|                       |                |             | (RH ONLY)                                  |          |        |           |                   |             |                      |                   |
| 9                     | 69-6177-3      | . . .       | HINGE-HALF,                                | TRAILING | EDGE   | BEAM,     | OUTBOARD          | AILERON     | 1                    |                   |
|                       |                |             | (LH ONLY)                                  |          |        |           |                   |             |                      |                   |
|                       | 69-6177-1      | . . .       | HINGE-HALF,                                | TRAILING | EDGE   | BEAM,     | OUTBOARD          | AILERON     | 1                    |                   |
|                       |                |             | (RH ONLY)                                  |          |        |           |                   |             |                      |                   |
| 10                    | 9-64577-135    | . . .       | HINGE-HALF,                                | TRAILING | EDGE,  | OUTBOARD  | AILERON . . .     |             | 1                    |                   |
|                       |                |             | (LH ONLY) (WHEN EXHAUSTED USE 9-64577-169) |          |        |           |                   |             |                      |                   |
|                       | 9-64577-136    | . . .       | HINGE-HALF,                                | TRAILING | EDGE,  | OUTBOARD  | AILERON . . .     |             | 1                    |                   |
|                       |                |             | (RH ONLY) (WHEN EXHAUSTED USE 9-64577-170) |          |        |           |                   |             |                      |                   |
| 11                    | 69-6177-3      | . . .       | HINGE-HALF,                                | TRAILING | EDGE   | BEAM,     | OUTBOARD          | AILERON     | 1                    |                   |
|                       |                |             | (LH ONLY)                                  |          |        |           |                   |             |                      |                   |
|                       | 69-6177-4      | . . .       | HINGE-HALF,                                | TRAILING | EDGE   | BEAM,     | OUTBOARD          | AILERON     | 1                    |                   |
|                       |                |             | (RH ONLY)                                  |          |        |           |                   |             |                      |                   |
| 12                    | 69-6177-4      | . . .       | HINGE-HALF,                                | TRAILING | EDGE   | BEAM,     | OUTBOARD          | AILERON     | 1                    |                   |
|                       |                |             | (LH ONLY)                                  |          |        |           |                   |             |                      |                   |
|                       | 69-6177-3      | . . .       | HINGE-HALF,                                | TRAILING | EDGE   | BEAM,     | OUTBOARD          | AILERON     | 1                    |                   |
|                       |                |             | (RH ONLY)                                  |          |        |           |                   |             |                      |                   |



| FIGURE &<br>INDEX NO. | PART NUMBER    | DESCRIPTION   | UNITS<br>PER<br>ASSY | US<br>ON<br>COL |
|-----------------------|----------------|---|----------------------|-----------------|
| 25 -                  |                | 1 2 3 4 5 6 7   |                      |                 |
| 13                    | 69-6177-5      | ... RETAINER, HINGE-HALF, TRAILING EDGE BEAM, ...<br>OUTBOARD AILERON (LH ONLY)   | 1                    |                 |
|                       | 69-6177-6      | ... RETAINER, HINGE-HALF, TRAILING EDGE BEAM, ...<br>OUTBOARD AILERON (RH ONLY)   | 1                    |                 |
| 14                    | 69-6177-6      | ... RETAINER, HINGE-HALF, TRAILING EDGE BEAM, ...<br>OUTBOARD AILERON (LH ONLY)   | 1                    |                 |
|                       | 69-6177-5      | ... RETAINER, HINGE-HALF, TRAILING EDGE BEAM, ...<br>OUTBOARD AILERON (RH ONLY)   | 1                    |                 |
| 14A                   | NAS1503-3      | (ATTACHING PARTS)   |                      |                 |
| 14B                   | NAS1503-3      | ... BOLT, 1000 CSK HD   | 1                    |                 |
| 14C                   | BACS40810-29   | ... BOLT, 1000 CSK HD   | 6                    |                 |
| 14D                   | BACS40810-57   | ... SHIM, LAM, 0.062 THK  | 2                    |                 |
| 14E                   | AN960PD10L     | ... SHIM, LAM, 0.062 THK  | 2                    |                 |
| 14F                   | NAS679A3W      | ... WASHER  | 7                    |                 |
|                       |                | ... NUT (FOR REPLACEMENT ORDER 96-02 (56878) (80539)<br>H10-38AC (15653) T651032J (71087) RMLH9075-3W<br>(72962) (BACN10JC31))                      | 7                    |                 |
| 15                    | 69-33850-7     | ... HINGE-HALF, TRAILING EDGE BEAM, OUTBOARD AILERON<br>(FOR SPARES ONLY) (LH ONLY)   | 1                    |                 |
|                       | 69-33850-8     | ... HINGE-HALF, TRAILING EDGE BEAM, OUTBOARD AILERON<br>(FOR SPARES ONLY) (RH ONLY)   | 1                    |                 |
| 15A                   | 69-33850-8     | ... HINGE-HALF, TRAILING EDGE BEAM, OUTBOARD AILERON<br>(FOR SPARES ONLY) (LH ONLY)   | 1                    |                 |
|                       | 69-33850-7     | ... HINGE-HALF, TRAILING EDGE BEAM, OUTBOARD AILERON<br>(FOR SPARES ONLY) (RH ONLY)   | 1                    |                 |
| 16                    | 9-64577-169    | ... HINGE-HALF, TRAILING EDGE BEAM, OUTBOARD AILERON<br>(FOR SPARES ONLY) (LH ONLY) (USE 9-64577-135<br>UNTIL EXHAUSTED)                            | 1                    |                 |
|                       | 9-64577-170    | ... HINGE-HALF, TRAILING EDGE BEAM, OUTBOARD AILERON<br>(FOR SPARES ONLY) (RH ONLY) (USE 9-64577-136<br>UNTIL EXHAUSTED)                            | 1                    |                 |
| 16A                   | 69-33850-12    | ... HINGE-HALF, TRAILING EDGE BEAM, OUTBOARD AILERON<br>(FOR SPARES ONLY) (LH ONLY)   | 1                    |                 |
|                       | 69-33850-11    | ... HINGE-HALF, TRAILING EDGE BEAM, OUTBOARD AILERON<br>(FOR SPARES ONLY) (RH ONLY)   | 1                    |                 |
| 17                    | 69-33850-11    | ... HINGE-HALF, TRAILING EDGE BEAM, OUTBOARD AILERON<br>(FOR SPARES ONLY) (LH ONLY)   | 1                    |                 |
|                       | 69-33850-12    | ... HINGE-HALF, TRAILING EDGE BEAM, OUTBOARD AILERON<br>(FOR SPARES ONLY) (RH ONLY)   | 1                    |                 |
| 17A                   | 69-33850-10    | ... HINGE-HALF, TRAILING EDGE BEAM, OUTBOARD AILERON<br>(FOR SPARES ONLY) (LH ONLY)   | 1                    |                 |
|                       | 69-33850-9     | ... HINGE-HALF, TRAILING EDGE BEAM, OUTBOARD AILERON<br>(FOR SPARES ONLY) (RH ONLY)   | 1                    |                 |
| 18                    | 69-33850-9     | ... HINGE-HALF, TRAILING EDGE BEAM, OUTBOARD AILERON<br>(FOR SPARES ONLY) (LH ONLY)   | 1                    |                 |
|                       | 69-33850-10    | ... HINGE-HALF, TRAILING EDGE BEAM, OUTBOARD AILERON<br>(FOR SPARES ONLY) (RH ONLY)   | 1                    |                 |
| 18A                   | 69-6177-5      | ... RETAINER, HINGE-HALF, TRAILING EDGE BEAM, ...<br>OUTBOARD AILERON (FOR SPARES ONLY) (LH ONLY)   | 1                    |                 |
|                       | 69-6177-6      | ... RETAINER, HINGE-HALF, TRAILING EDGE BEAM, ...<br>OUTBOARD AILERON (FOR SPARES ONLY) (RH ONLY)   | 1                    |                 |
| 19                    | 69-6177-6      | ... RETAINER, HINGE-HALF, TRAILING EDGE BEAM, ...<br>OUTBOARD AILERON (FOR SPARES ONLY) (LH ONLY)   | 1                    |                 |
|                       | 69-6177-5      | ... RETAINER, HINGE-HALF, TRAILING EDGE BEAM, ...<br>OUTBOARD AILERON (FOR SPARES ONLY) (RH ONLY)   | 1                    |                 |
| 19A                   | NAS1503-3      | (ATTACHING PARTS)   |                      |                 |
| 19B                   | NAS1503-3      | ... BOLT, 1000 CSK HD   | 17                   |                 |
| 19C                   | BACS40810-57   | ... SHIM, LAM, 0.062 THK (FOR SPARES ONLY) (MAKE<br>FROM 9535 BACS408 9/16 X 4 1/2 INCH)  | 2                    |                 |
| 19D                   | AN960PD10L     | ... SHIM, LAM, 0.062 THK (FOR SPARES ONLY)  | 1                    |                 |
| 19E                   | BACN10P43AL    | ... WASHER (FOR SPARES ONLY)  | 17                   |                 |
| 19F                   | NAS679A3W      | ... WASHER, PLAIN (FOR SPARES ONLY)   | 1                    |                 |
|                       |                | ... NUT (FOR SPARES ONLY) (FOR REPLACEMENT ORDER<br>96-02 (56878) (80539) H10-38AC (15653)<br>T651032J (71087) RMLH9075-3W (72962)<br>(BACN10JC31)) | 17                   |                 |
| 20                    | 15166-10402    | ... PIN ASSY, TAB HINGE, OUTBOARD AILERON   | 2                    |                 |
| 21                    | 151NAS517-3-2  | ... SCREW (FOR REPLACEMENT ORDER BACB30LU3-2)   | 2                    |                 |
| 22                    | 151BACN10P41AL | ... WASHER, PLAIN   | 2                    |                 |
| 23                    | 151NAS679A3W   | ... NUT (FOR REPLACEMENT ORDER 96-02 (56878) (80539)<br>H10-38AC (15653) T651032J (71087) RMLH9075-3W<br>(72962) (BACN10JC31))                      | 2                    |                 |

Section II  
Group Assembly Parts List

T.O. 1C-135A-4

| FIGURE &<br>INDEX NO. | PART NUMBER    | DESCRIPTION   | UNITS<br>PER<br>ASSY | USE<br>ON<br>CODE |
|-----------------------|----------------|---|----------------------|-------------------|
| 25 -                  |                | 1 2 3 4 5 6 7   |                      |                   |
|                       | (S)69-8929-1   | .. FAIRING INSTL, TAB MAST, OUTBOARD AILERON (LH ONLY)  | 2                    |                   |
|                       | (S)69-8929-2   | .. FAIRING INSTL, TAB MAST, OUTBOARD AILERON (RH ONLY)  | 2                    |                   |
|                       | 69-8929-5      | .. FAIRING ASSY, TAB MAST, OUTBOARD AILERON (LH ONLY)   | 1                    | C                 |
|                       | 69-8929-6      | .. FAIRING ASSY, TAB MAST, OUTBOARD AILERON (RH ONLY)   | 1                    | C                 |
| 23A                   | 69-8929-9      | .. COVER, ACCESS, TAB MAST FAIRING, OUTBOARD AILERON (ATTACHING PARTS)  | 1                    | C                 |
|                       | NAS603-8P      | .. SCREW  | 2                    | C                 |
| 23B                   | 69-8929-7      | .. FAIRING, TAB MAST, OUTBOARD AILERON (LH ONLY)  | 1                    | C                 |
|                       | 69-8929-8      | .. FAIRING, TAB MAST, OUTBOARD AILERON (RH ONLY)  | 1                    | C                 |
| 24                    | 69-8929-3      | .. FAIRING, TAB MAST, OUTBOARD AILERON (LH ONLY)  | 1                    | D                 |
|                       | 69-8929-4      | .. FAIRING, TAB MAST, OUTBOARD AILERON (RH ONLY)  | 1                    | D                 |
|                       | (S)5-97849-1   | .. FAIRING INSTL, TAB MAST, OUTBOARD AILERON (LH ONLY)  | 1                    |                   |
|                       | (S)5-97849-2   | .. FAIRING INSTL, TAB MAST, OUTBOARD AILERON (RH ONLY)  | 1                    |                   |
| 25                    | 5-97849-3      | .. FAIRING, CONTROL MAST, OUTBOARD AILERON (LH ONLY)  | 1                    |                   |
|                       | 5-97849-4      | .. FAIRING, CONTROL MAST, OUTBOARD AILERON (RH ONLY)  | 1                    |                   |
|                       | NAS514P1032-12 | .. SCREW  | 5                    |                   |
| 26                    | (S)5-84190-107 | .. SEAL, MOHAIR, AILERON, OUTBOARD WING (MAKE FROM 5680 BAC1523-17N X 2.1)  | 4                    |                   |
| 27                    | (S)66-14032-1  | .. SEAL ASSY, OUTBOARD AILERON (LH ONLY)  | 2                    |                   |
|                       | (S)66-14032-2  | .. SEAL ASSY, OUTBOARD AILERON (RH ONLY)  | 2                    |                   |
| 28                    | (S)66-14032-2  | .. SEAL ASSY, OUTBOARD AILERON (LH ONLY)  | 2                    |                   |
|                       | (S)66-14032-1  | .. SEAL ASSY, OUTBOARD AILERON (RH ONLY)  | 2                    |                   |
| 29                    | (S)60-2078-1   | .. SEAL ASSY, OUTBOARD AILERON (LH ONLY)  | 2                    |                   |
|                       | (S)60-2078-2   | .. SEAL ASSY, OUTBOARD AILERON (RH ONLY)  | 2                    |                   |
| 30                    | (S)60-2078-2   | .. SEAL ASSY, OUTBOARD AILERON (LH ONLY)  | 1                    |                   |
|                       | (S)60-2078-1   | .. SEAL ASSY, OUTBOARD AILERON (RH ONLY)  | 1                    |                   |
|                       | (S)AN3-5A      | .. BOLT (FOR REPLACEMENT ORDER BACB3ONE3-4)   | 10                   |                   |
|                       | (S)AN3-11A     | .. BOLT (FOR REPLACEMENT ORDER BACB3ONE3-12)  | 11                   |                   |
|                       | (S)BACH10P43AL | .. WASHER, PLAIN  | 10                   |                   |
|                       | (S)NAS620-10   | .. WASHER   | 3                    |                   |
|                       | (S)NAS679A3W   | .. NUT (FOR REPLACEMENT ORDER 96-02 (56878) (80539) M10-38AC (15653) T6S1032J (71087) RMLH9075-3W (72962) (BACN10JC3))                      | 5                    |                   |
|                       | 66-14032-7     | .. SEAL, OUTBOARD AILERON (USED ON 66-14032-1, -2)  | 1                    |                   |
|                       | 60-2078-5      | .. SEAL, OUTBOARD AILERON (MAKE FROM 8305 0.125 X 2.7 X 5.4 FELT TYPE 3 SPEC MIL-F-5656 COLOR OPT 100% NEUTRALIZED) (USED ON 60-2078-1, -2) | 1                    |                   |
| 31                    | 60-2077-7      | .. SEAL ASSY, HINGE, TYPICAL, OUTBOARD AILERON (FOR I/W INFO SEE 60-2077-11) (LH ONLY)  | 4                    | A                 |
| 31                    | (S)60-2077-11  | .. SEAL ASSY, HINGE, TYPICAL, OUTBOARD AILERON (I/W 60-2077-7) (USE 60-2077-7 UNTIL EXHAUSTED) (LH ONLY)                                    | 4                    | B                 |
|                       | 60-2077-8      | .. SEAL ASSY, HINGE, TYPICAL, OUTBOARD AILERON (FOR I/W INFO SEE 60-2077-12) (RH ONLY)  | 4                    | A                 |
|                       | (S)60-2077-12  | .. SEAL ASSY, HINGE, TYPICAL, OUTBOARD AILERON (I/W 60-2077-8) (USE 60-2077-8 UNTIL EXHAUSTED) (RH ONLY)                                    | 4                    | B                 |
| 32                    | 60-2077-8      | .. SEAL ASSY, HINGE, TYPICAL, OUTBOARD AILERON (FOR I/W INFO SEE 60-2077-12) (LH ONLY)  | 4                    | A                 |
| 32                    | (S)60-2077-12  | .. SEAL ASSY, HINGE, TYPICAL, OUTBOARD AILERON (I/W 60-2077-8) (USE 60-2077-8 UNTIL EXHAUSTED) (LH ONLY)                                    | 4                    | B                 |
|                       | 60-2077-7      | .. SEAL ASSY, HINGE, TYPICAL, OUTBOARD AILERON (FOR I/W INFO SEE 60-2077-11) (RH ONLY)  | 4                    | A                 |
|                       | (S)60-2077-11  | .. SEAL ASSY, HINGE, TYPICAL, OUTBOARD AILERON (I/W 60-2077-7) (USE 60-2077-7 UNTIL EXHAUSTED) (RH ONLY)                                    | 4                    | B                 |
|                       | (S)AN3-4A      | .. BOLT (FOR REPLACEMENT ORDER BACB3ONE3-2)   | 24                   |                   |
|                       | AN960D10       | .. WASHER (USED WITH 60-2077-7)   | 12                   | A                 |
|                       | BACH10P43AL    | .. WASHER, PLAIN (USED WITH 60-2077-8)  | 12                   | A                 |
|                       | (S)NAS679A3W   | .. NUT (FOR REPLACEMENT ORDER 96-02 (56878) (80539) M10-38AC (15653) T6S1032J (71087) RMLH9075-3W (72962) (BACN10JC3))                      | 24                   |                   |

| FIGURE &<br>INDEX NO. | PART NUMBER                     | DESCRIPTION  | UNITS<br>PER<br>ASSY | USE<br>ON<br>CODE |
|-----------------------|---------------------------------|--|----------------------|-------------------|
| 25                    | 60-2077-3                       | ... SEAL, HINGE, TYPICAL, OUTBOARD AILERON (MAKE FROM 5680 BAC1523-13 X 5.2) (FOR I/W INFO SEE 60-2077-13)   | 1                    | A                 |
|                       | 60-2077-13                      | ... SEAL, HINGE, TYPICAL, OUTBOARD AILERON (MAKE FROM 5680 BAC1523-13N X 5.2) (I/W 60-2077-3) (USE 60-2077-5 UNTIL EXHAUSTED)                          | 1                    | B                 |
| 33                    | (S)60-1593-3000<br>60-1593-2002 | ... SEAL ASSY, OUTBOARD AILERON . . . . .<br>... SEAL, OUTBOARD AILERON (MAKE FROM 8305 O.125 X 3.7 X 3.8 FELT TYPE 3 PER MIL-F-5636 100% NEUTRALIZED) | 3<br>1               |                   |
| 34                    | 60-1469-1                       | ... SEAL ASSY, OUTBOARD AILERON (FOR I/W INFO SEE 60-1469-7) (LH ONLY)   | 1                    | A                 |
| 34                    | (S)60-1469-7                    | ... SEAL ASSY, OUTBOARD AILERON (I/W 60-1469-1) (USE 60-1469-1 UNTIL EXHAUSTED) (LH ONLY)  | 1                    | B                 |
|                       | 60-1469-2                       | ... SEAL ASSY, OUTBOARD AILERON (FOR I/W INFO SEE 60-1469-8) (RH ONLY)   | 1                    | A                 |
|                       | (S)60-1469-8                    | ... SEAL ASSY, OUTBOARD AILERON (I/W 60-1469-2) (USE 60-1469-2 UNTIL EXHAUSTED) (RH ONLY)  | 1                    | B                 |
|                       | (S)AN3-4A<br>(S)AN960010        | (ATTACHING PARTS)<br>... BOLT (FOR REPLACEMENT ORDER BACB3ONE3-2) . . . . .<br>... WASHER . . . . .  | 2<br>2               |                   |
|                       | 60-1469-5                       | ... SEAL, OUTBOARD AILERON (MAKE FROM 5680 BAC1523-17 X 4.6) (FOR I/W INFO SEE 60-1469-6)  | 1                    | A                 |
|                       | 60-1469-6                       | ... SEAL, OUTBOARD AILERON (MAKE FROM 5680 BAC1523-17N X 4.6) (I/W 60-1469-5) (USE 60-1469-5 UNTIL EXHAUSTED)  | 1                    | B                 |
| 35                    | (S)NAS561P4-7                   | ... PIN, (FOR REPLACEMENT ORDER MS16562-32) . . . . .  | 8                    |                   |
| 36                    | (S)BACP18G2-2517                | ... PIN, SEAL RET, (MAKE FROM .090 CORROSION RESISTANT STEEL WIRE) (09505)   | 1                    |                   |
| 37                    | (S)BACP18G2-2525                | ... PIN, SEAL RET, (MAKE FROM .090 CORROSION RESISTANT STEEL WIRE) (09505)   | 2                    |                   |
| 38                    | (S)BACP18G2-5210                | ... PIN, SEAL RET . . . . .  | 2                    |                   |
| 39                    | (S)BACP18G2-4823                | ... PIN, SEAL RET, (MAKE FROM .090 CORROSION RESISTANT STEEL WIRE) (09505)   | 1                    |                   |
| 40                    | (S)BACP18G2-5460                | ... PIN, SEAL RET, (MAKE FROM .090 CORROSION RESISTANT STEEL WIRE) (09505)   | 1                    |                   |
| 41                    | (S)BACP18G2-5453                | ... PIN, SEAL RET, (MAKE FROM .090 CORROSION RESISTANT STEEL WIRE) (09505)   | 1                    |                   |
| 42                    | (S)60-2099                      | ... SEAL, FABRIC, OUTBOARD AILERON (MAKE FROM BMS1-17A TYPE 2 GRADE B, 8305-24.50 LG X 2.50 WIDE)  | 1                    |                   |
| 43                    | (S)60-2099-1                    | ... SEAL, FABRIC, OUTBOARD AILERON (MAKE FROM BMS1-17A TYPE 2 GRADE B, 8305-48.48 LG X 2.50 WIDE)  | 2                    |                   |
| 44                    | (S)60-2099-2                    | ... SEAL, FABRIC, OUTBOARD AILERON (MAKE FROM BMS1-17A TYPE 2 GRADE B, 8305-54.72 LG X 2.50 WIDE)  | 1                    |                   |
| 45                    | (S)AN3-11A                      | ... BOLT (FOR REPLACEMENT ORDER BACB3ONE3-12) . . . . .  | 4                    |                   |
| 46                    | (S)BACW10P43AL                  | ... WASHER, PLAIN . . . . .  | 4                    |                   |
| 47                    | (S)NAS679A3W                    | ... NUT (FOR REPLACEMENT ORDER 96-02 (56878) (80539) H10-38AC (15653) T6S1032J (71087) RMLH9075-3W (72962) (BACN10JC3))                                | 2                    |                   |
| 48                    | (S)66-3656-4                    | ... RETAINER, PIN, HINGE, OUTBOARD AILERON (LH ONLY)   | 1                    |                   |
|                       | (S)66-3656-3                    | ... RETAINER, PIN, HINGE, OUTBOARD AILERON (RH ONLY)   | 1                    |                   |
| 49                    | (S)66-3656-2                    | ... RETAINER, PIN, HINGE, OUTBOARD AILERON (LH ONLY)   | 1                    |                   |
|                       | (S)66-3656-1                    | ... RETAINER, PIN, HINGE, OUTBOARD AILERON (RH ONLY)   | 1                    |                   |
| 50                    | (S)66-3655-1                    | ... RETAINER, PIN, HINGE, OUTBOARD AILERON (LH ONLY)   | 2                    |                   |
|                       | (S)66-3655-2                    | ... RETAINER, PIN, HINGE, OUTBOARD AILERON (RH ONLY)   | 2                    |                   |
| 51                    | (S)66-3655-2                    | ... RETAINER, PIN, HINGE, OUTBOARD AILERON (LH ONLY)   | 2                    |                   |
|                       | (S)66-3655-1                    | ... RETAINER, PIN, HINGE, OUTBOARD AILERON (RH ONLY)   | 2                    |                   |
| 52                    | (S)66-3656-1                    | ... RETAINER, PIN, HINGE, OUTBOARD AILERON (LH ONLY)   | 1                    |                   |
|                       | (S)66-3656-2                    | ... RETAINER, PIN, HINGE, OUTBOARD AILERON (RH ONLY)   | 1                    |                   |
|                       | (S)65-27063-14                  | ... HINGE ASSY, OUTBOARD AILERON . . . . .   | 1                    |                   |
|                       | (S)65-27063-17                  | ... HINGE ASSY, OUTBOARD AILERON (LH ONLY) . . . . .   | 2                    |                   |
|                       | (S)65-27063-18                  | ... HINGE ASSY, OUTBOARD AILERON (RH ONLY) . . . . .   | 2                    |                   |
|                       | (S)65-27063-15                  | ... HINGE ASSY, OUTBOARD AILERON (LH ONLY) . . . . .   | 1                    |                   |
|                       | (S)65-27063-16                  | ... HINGE ASSY, OUTBOARD AILERON (RH ONLY) . . . . .   | 1                    |                   |
|                       | 69-1893-6                       | ... HINGE ASSY, NOSE, OUTBOARD AILERON (USED ON 65-27063-14)   | 1                    |                   |
|                       | 5-96763-23                      | ... HINGE ASSY, NOSE, OUTBOARD AILERON (USED ON 65-27063-17, -18)  | 2                    |                   |
|                       | 5-96763-19                      | ... HINGE ASSY, NOSE, OUTBOARD AILERON (USED ON 65-27063-15)   | 1                    |                   |
|                       | 5-96763-20                      | ... HINGE ASSY, NOSE, OUTBOARD AILERON (USED ON 65-27063-16)   | 1                    |                   |
| 53                    | 69-1893-5                       | ... PIN, HINGE, NOSE, OUTBOARD AILERON (USED ON 69-1893-6)   | 1                    |                   |

Section II  
Group Assembly Parts List

TO 1C-135A-4

| FIGURE &<br>INDEX NO. | PART NUMBER    | DESCRIPTION   | UNITS<br>PER<br>ASSY | USE<br>ON<br>CODE |
|-----------------------|----------------|---|----------------------|-------------------|
|                       |                | 1 2 3 4 5 6 7   |                      |                   |
| 25 -                  |                |   |                      |                   |
| 54                    | 69-1893-2      | HINGE-HALF, NOSE, OUTBOARD AILERON (USED ON 69-1893-6)  | 1                    |                   |
| 55                    | 69-1893-7      | HINGE-HALF, NOSE, OUTBOARD AILERON (USED ON 69-1893-6)  | 1                    |                   |
| 56                    | MS20257-2-4882 | PIN (USED ON 5-96763-23)  | 1                    |                   |
| 57                    | 5-96763-10     | HINGE-HALF, NOSE, OUTBOARD AILERON (USED ON 5-96763-23)   | 1                    |                   |
| 58                    | 5-96763-9      | HINGE-HALF, NOSE, OUTBOARD AILERON (USED ON 5-96763-23)   | 1                    |                   |
| 59                    | MS20257-2-5449 | PIN (USED ON 5-96763-19, 20)  | 1                    |                   |
| 60                    | 5-96763-11     | HINGE-HALF, NOSE, OUTBOARD AILERON (USED ON 5-96763-19)   | 1                    |                   |
|                       | 5-96763-12     | HINGE-HALF, NOSE, OUTBOARD AILERON (USED ON 5-96763-20)   | 1                    |                   |
| 61                    | 5-96763-17     | HINGE-HALF, NOSE, OUTBOARD AILERON (USED ON 5-96763-19)   | 1                    |                   |
|                       | 5-96763-18     | HINGE-HALF, NOSE, OUTBOARD AILERON (USED ON 5-96763-20)   | 1                    |                   |
| 62                    | 90-1417-10     | DOOR ASSY, ACCESS, OUTBOARD AILERON (FOR I/W INFO SEE 90-1417-13)   | 3                    | A                 |
| 62                    | 90-1417-13     | DOOR ASSY, ACCESS, OUTBOARD AILERON (I/W 90-1417-10) (USE 90-1417-10 UNTIL EXHAUSTED)   | 3                    | B                 |
| 62                    | 90-1417-16     | DOOR ASSY, ACCESS, OUTBOARD AILERON (FOR SPARES ONLY)   | 3                    |                   |
| 63                    | 90-2866-3      | DOOR ASSY, ACCESS, OUTBOARD AILERON   | 3                    |                   |
| 63                    | 90-2866-5      | DOOR ASSY, ACCESS, OUTBOARD AILERON (FOR SPARES ONLY)   | 3                    |                   |
| 64                    | 90-1417-1      | DOOR ASSY, ACCESS, OUTBOARD AILERON (LH ONLY)   | 1                    |                   |
| 64                    | 90-1417-14     | DOOR ASSY, ACCESS, OUTBOARD AILERON (FOR SPARES ONLY) (LH ONLY)   | 1                    |                   |
|                       | 90-1417-2      | DOOR ASSY, ACCESS, OUTBOARD AILERON (RH ONLY)   | 1                    |                   |
| 64                    | 90-1417-15     | DOOR ASSY, ACCESS, OUTBOARD AILERON (FOR SPARES ONLY) (RH ONLY)   | 1                    |                   |
|                       | NAS517-3-2     | SCREW (FOR REPLACEMENT ORDER BACB30LU3-2)   | 106                  |                   |
| 64A                   | 90-1417-9      | SEAL, DOOR, ACCESS, OUTBOARD AILERON (MAKE FROM 5680 BAC1523-17 X 2.1) (FOR I/W INFO SEE 90-1417-12) (USED ON 90-1417-10)                         | 1                    | A                 |
| 64A                   | 90-1417-12     | SEAL, DOOR, ACCESS, OUTBOARD AILERON (MAKE FROM 5680 BAC1523-17N X 2.1) (I/W 90-1417-9) (USE 90-1417-9 UNTIL EXHAUSTED) (USED ON 90-1417-13, -16) | 1                    | B                 |
| 64B                   | 5-88190-73     | SKIN, AILERON, OUTBOARD WING, UPPER (MAKE FROM ALUM 2024-T6)  | 1                    |                   |
| 64B                   | 5-88190-3095   | SKIN, AILERON, OUTBOARD WING, UPPER (FOR SPARES ONLY)   | 1                    |                   |
| 64C                   | 5-88190-55     | SKIN, AILERON, OUTBOARD WING, UPPER (ALTERED FROM 5-88190-62) (MAKE FROM ALUM 2024-T6) (FOR REPLACEMENT ORDER 65-17640-105) (LH ONLY)             | 1                    |                   |
| 64C                   | 5-88190-3077   | SKIN, AILERON, OUTBOARD WING, UPPER (FOR SPARES ONLY) (LH ONLY)   | 1                    |                   |
|                       | 5-88190-56     | SKIN, AILERON, OUTBOARD WING, UPPER (ALTERED FROM 5-88190-62) (MAKE FROM ALUM 2024-T6) (RH ONLY)  | 1                    |                   |
|                       | 5-88190-3078   | SKIN, AILERON, OUTBOARD WING, UPPER (FOR SPARES ONLY) (RH ONLY)   | 1                    |                   |
| 64D                   | 5-88190-61     | SKIN, AILERON, OUTBOARD WING, UPPER (ALTERED FROM 5-88190-62) (MAKE FROM ALUM 2024-T6) (FOR REPLACEMENT ORDER 65-17640-107) (LH ONLY)             | 1                    |                   |
| 64D                   | 5-88190-3079   | SKIN, AILERON, OUTBOARD WING, UPPER (FOR SPARES ONLY) (LH ONLY)   | 1                    |                   |
|                       | 5-88190-62     | SKIN, AILERON, OUTBOARD WING, UPPER (MAKE FROM ALUM 2024-T6) (RH ONLY)  | 1                    |                   |
|                       | 5-88190-3080   | SKIN, AILERON, OUTBOARD WING, UPPER (FOR SPARES ONLY) (RH ONLY)   | 1                    |                   |
| 64E                   | 5-88190-71     | SKIN, AILERON, OUTBOARD WING, LOWER (ALTERED FROM 5-88190-72) (LH ONLY)   | 1                    |                   |
| 64E                   | 5-88190-3093   | SKIN, AILERON, OUTBOARD WING, LOWER (FOR SPARES ONLY) (LH ONLY)   | 1                    |                   |
|                       | 5-88190-72     | SKIN, AILERON, OUTBOARD WING, LOWER (RH ONLY)   | 1                    |                   |
|                       | 5-88190-3094   | SKIN, AILERON, OUTBOARD WING, LOWER (FOR SPARES ONLY) (RH ONLY)   | 1                    |                   |
| 64F                   | 5-88190-69     | SKIN, AILERON, OUTBOARD WING, LOWER (ALTERED FROM 5-88190-72) (MAKE FROM ALUM 2024-T6) (LH ONLY)  | 1                    |                   |
| 64F                   | 5-88190-3091   | SKIN, AILERON, OUTBOARD WING, LOWER (FOR SPARES ONLY) (LH ONLY)   | 1                    |                   |
|                       | 5-88190-70     | SKIN, AILERON, OUTBOARD WING, LOWER (ALTERED FROM 5-88190-72) (MAKE FROM ALUM 2024-T6) (RH ONLY)  | 1                    |                   |

| FIGURE &<br>INDEX NO. | PART NUMBER     | DESCRIPTION   | UNI<br>PEI<br>ASS |
|-----------------------|-----------------|---|-------------------|
| 23 -                  | 5-88190-3092    | • • SKIN, AILERON, OUTBOARD WING, LOWER (FOR . . . . .<br>SPARES ONLY) (RH ONLY)  |                   |
| 64C                   | 5-88190-67      | • • SKIN, AILERON, OUTBOARD WING, LOWER . . . . .   |                   |
| 64C                   | 5-88190-3085    | • • SKIN, AILERON, OUTBOARD WING, LOWER (FOR . . . . .<br>SPARES ONLY)  |                   |
| 64H                   | 5-88190-57      | • • SKIN, NOSE, INBOARD AILERON, OUTBOARD WING (ALTERED<br>FROM 5-88190-54) (MAKE FROM ALUM 2024-T6)<br>(LH ONLY)               | 1                 |
| 64H                   | 5-88190-3087    | • • SKIN, NOSE, INBOARD AILERON, OUTBOARD WING (FOR . .<br>SPARES ONLY) (LH ONLY)   | 1                 |
|                       | 5-88190-58      | • • SKIN, NOSE, INBOARD AILERON, OUTBOARD WING (ALTERED<br>FROM 5-88190-54) (MAKE FROM ALUM 2024-T6)<br>(RH ONLY)               | 1                 |
|                       | 5-88190-3088    | • • SKIN, NOSE, INBOARD AILERON, OUTBOARD WING (FOR . .<br>SPARES ONLY) (RH ONLY)   | 1                 |
| 64J                   | 5-88190-59      | • • SKIN, NOSE, AILERON, OUTBOARD WING (ALTERED FROM .<br>5-88190-54) (MAKE FROM ALUM 2024-6L) (LH ONLY)                        | 1                 |
| 64J                   | 5-88190-3099    | • • SKIN, NOSE, AILERON, OUTBOARD WING (FOR . . . . .<br>SPARES ONLY) (LH ONLY)   | 1                 |
|                       | 5-88190-60      | • • SKIN, NOSE, AILERON, OUTBOARD WING (ALTERED FROM .<br>5-88190-54) (MAKE FROM ALUM 2024-T6) (RH ONLY)                        | 1                 |
|                       | 5-88190-3090    | • • SKIN, NOSE, AILERON, OUTBOARD WING (FOR . . . . .<br>SPARES ONLY) (RH ONLY)   | 1                 |
| 64K                   | 5-88190-49      | • • SKIN, NOSE, AILERON, OUTBOARD WING (ALTERED FROM .<br>5-88190-54) (MAKE FROM ALUM 2024-T6) (LH ONLY)                        | 1                 |
| 64K                   | 5-88190-3071    | • • SKIN, NOSE, AILERON, OUTBOARD WING (FOR . . . . .<br>SPARES ONLY) (LH ONLY)   | 1                 |
|                       | 5-88190-50      | • • SKIN, NOSE, AILERON, OUTBOARD WING (ALTERED FROM .<br>5-88190-54) (MAKE FROM ALUM 2024-T6) (RH ONLY)                        | 1                 |
|                       | 5-88190-3072    | • • SKIN, NOSE, AILERON, OUTBOARD WING (FOR . . . . .<br>SPARES ONLY) (RH ONLY)   | 1                 |
| 64L                   | DELETED         |   |                   |
| 64M                   | 5-88190-51      | • • SKIN, NOSE AILERON, OUTBOARD WING (ALTERED FROM . .<br>5-88190-54) (MAKE FROM ALUM 2024-T6) (LH ONLY)                       | 1                 |
| 64M                   | 5-88190-3073    | • • SKIN, NOSE, AILERON, OUTBOARD WING (FOR . . . . .<br>SPARES ONLY) (LH ONLY)   | 1                 |
|                       | 5-88190-52      | • • SKIN, NOSE, AILERON, OUTBOARD WING (ALTERED FROM .<br>5-88190-54) (MAKE FROM ALUM 2024-T6) (RH ONLY)                        | 1                 |
|                       | 5-88190-3074    | • • SKIN, NOSE, AILERON, OUTBOARD WING (FOR . . . . .<br>SPARES ONLY) (RH ONLY)   | 1                 |
| 64N                   | 5-88190-53      | • • SKIN, NOSE, AILERON, OUTBOARD WING (ALTERED FROM .<br>5-88190-54) (MAKE FROM ALUM 2024-T6) (LH ONLY)                        | 1                 |
| 64N                   | 5-88190-3075    | • • SKIN, NOSE, AILERON, OUTBOARD WING (FOR . . . . .<br>SPARES ONLY) (LH ONLY)   | 1                 |
|                       | 5-88190-54      | • • SKIN, NOSE, AILERON, OUTBOARD WING (MAKE FROM . . .<br>ALUM 2024-T6) (RH ONLY)  | 1                 |
|                       | 5-88190-3076    | • • SKIN, NOSE, AILERON, OUTBOARD WING (FOR . . . . .<br>SPARES ONLY) (RH ONLY)   | 1                 |
| 65                    | (S)5-88190-1651 | • • SHIM, AILERON, OUTBOARD WING . . . . .  | 4                 |
| 66                    | (S)6-84526      | • • STOP, OUTBOARD AILERON . . . . .  | 1                 |
| 67                    | (S)6-84526-2    | • • STOP ASSY, OUTBOARD AILERON . . . . .<br>(ATTACHING PARTS)  | 1                 |
|                       | (S)NAS464P5A15  | • • BOLT (FOR REPLACEMENT ORDER NAS1105-15) . . . . .   | 2                 |
|                       | (S)NAS464P5A16  | • • BOLT (FOR REPLACEMENT ORDER NAS1105-16) . . . . .   | 2                 |
|                       | (S)AN960D516    | • • WASHER . . . . .  | 4                 |
|                       | (S)NAS679A5W    | • • NUT (FOR REPLACEMENT ORDER 96-054 (56878) (80539) .<br>M10-5BAC (15653) T65524J (71087) RMLH9075-5W<br>(72962) (BACN10JC5)) | 4                 |
|                       | 6-83219-2       | • • SUPPORT ASSY, BEARING, HINGE, OUTBOARD AILERON . .<br>(ATTACHING PARTS)   | 7                 |
| 68                    | (S)NAS1104-35W  | • • BOLT (FOR REPLACEMENT ORDER NAS1104-35) . . . . .   | 10                |
| 69                    | (S)NAS1104-41W  | • • BOLT (FOR REPLACEMENT ORDER NAS1104-41) . . . . .   | 2                 |
| 70                    | (S)NAS1104-61W  | • • BOLT (FOR REPLACEMENT ORDER NAS1104-61) . . . . .   | 2                 |
| 71                    | (S)AN960D416    | • • WASHER . . . . .  | 16                |
| 72                    | (S)NAS679A4W    | • • NUT (FOR REPLACEMENT ORDER 96-048 (56878) (80539) .<br>M10-4BAC (15653) T65428J (71087) RMLH9075-4W<br>(72962) (BACN10JC4)) | 14                |
| 73                    | NAS516-1        | • • FITTING . . . . .   | 1                 |
| 74                    | BR5             | • • BEARING, CONCAVE, ROLLER, SELF-ALIGNING (77896) .<br>(BACB10C135)   | 1                 |
| 75                    | 6-83219-3       | • • SUPPORT, BEARING, HINGE, OUTBOARD AILERON . . . . .   | 1                 |
|                       | (S)9-64578-41   | • • SPAR INSTL, OUTBOARD AILERON (LH ONLY) . . . . .  | 1                 |
|                       | (S)9-64578-42   | • • SPAR INSTL, OUTBOARD AILERON (RH ONLY) . . . . .  | 1                 |

Section II  
Group Assembly Parts List

TO IC-135A-4

| FIGURE &<br>INDEX NO. | PART NUMBER    | DESCRIPTION   | UNITS<br>PER<br>ASSY | USE<br>ON<br>CODE |
|-----------------------|----------------|---|----------------------|-------------------|
| 25 -                  |                |   |                      |                   |
| 75A                   | 5-96181        | . . . SUPPORT, HINGE, OUTBOARD AILERON, WING STATION 949.174  | 1                    |                   |
|                       | (S)6-83592-4   | . . . SUPPORT ASSY, BEARING, OUTBOARD AILERON, WING STATION 779.96 (ATTACHING PARTS)                                      | 1                    |                   |
| 76                    | (S)NAS1104-33W | . . . BOLT (FOR REPLACEMENT ORDER NAS1104-33)   | 1                    |                   |
| 77                    | (S)NAS1104-35W | . . . BOLT (FOR REPLACEMENT ORDER NAS1104-35)   | 1                    |                   |
| 78                    | (S)AN960D416   | . . . WASHER  | 2                    |                   |
| 79                    | (S)NAS679A4W   | . . . NUT (FOR REPLACEMENT ORDER 96-048 (56878) (80539) M10-48AC (15653) T65428J (71087) RMLH9075-4W (72962) (BACN10JC4)) | 2                    |                   |
| 80                    | NAS516-1       | . . . FITTING   | 1                    |                   |
| 81                    | BR5            | . . . BEARING, CONCAVE, ROLLER, SELF-ALIGNING (77896) (PAC110C15)   | 1                    |                   |
| 82                    | 6-83592-3      | . . . SUPPORT, BEARING, OUTBOARD AILERON, WING STATION 779.96   | 1                    |                   |
| 83                    | DELETED        |   |                      |                   |
| 84                    | 69-1898-1      | . . . DOOR ASSY, ACCESS, OUTBOARD AILERON (FOR I/W INFO SEE 69-1898-11) (LM ONLY)   | 1                    |                   |
| 84                    | 69-1898-11     | . . . DOOR ASSY, ACCESS, OUTBOARD AILERON (I/W 69-1898-1) (USE 69-1898-1 UNTIL EXHAUSTED) (LM ONLY)                       | 1                    |                   |
| 84                    | 69-1898-14     | . . . DOOR ASSY, ACCESS, OUTBOARD AILERON (FOR SPARES ONLY) (LM ONLY)   | 1                    |                   |
|                       | 69-1898-2      | . . . DOOR ASSY, ACCESS, OUTBOARD AILERON (FOR I/W INFO SEE 69-1898-12) (RM ONLY)   | 1                    |                   |
|                       | 69-1898-12     | . . . DOOR ASSY, ACCESS, OUTBOARD AILERON (I/W 69-1898-2) (USE 69-1898-2 UNTIL EXHAUSTED) (RM ONLY)                       | 1                    |                   |
|                       | 69-1898-15     | . . . DOOR ASSY, ACCESS, OUTBOARD AILERON (FOR SPARES ONLY) (RM ONLY)   | 1                    |                   |
|                       | (S)NAS517-3-2  | . . . SCREW (FOR REPLACEMENT ORDER BACB30LU3-2) (ATTACHING PARTS)   | 16                   |                   |
| 85                    | 69-1898-6      | . . . SEAL, DOOR, ACCESS, OUTBOARD AILERON (MAKE FROM 5680 BAC1523-17 X 2.1)  | 1                    |                   |
| 85                    | (S)69-1898-13  | . . . SEAL, MOHAIK, ACCESS DOOR, OUTBOARD AILERON (MAKE FROM 5680 BAC1523-174 X 2.1)                                      | 1                    |                   |
| 86                    | (S)50-2477-17  | . . . WEIGHT, BALANCE, NOSE, OUTBOARD AILERON (MAKE FROM ANTIMONY LEAD L16.44 X 1.06 X 8.57)                              | 14                   |                   |
| 87                    | (S)50-2477-18  | . . . WEIGHT, BALANCE, NOSE, OUTBOARD AILERON (MAKE FROM ANTIMONY LEAD L16.44 X 1.06 X 7.02)                              | 2                    |                   |
| 88                    | (S)50-2477-19  | . . . WEIGHT, BALANCE, NOSE, OUTBOARD AILERON (MAKE FROM ANTIMONY LEAD L16.44 X 1.06 X 8.04)                              | 1                    |                   |
| 89                    | (S)50-2477-20  | . . . WEIGHT, BALANCE, NOSE, OUTBOARD AILERON (MAKE FROM ANTIMONY LEAD L16.44 X 1.06 X 8.81)                              | 1                    |                   |
| 90                    | (S)50-2477-21  | . . . WEIGHT, BALANCE, NOSE, OUTBOARD AILERON (MAKE FROM ANTIMONY LEAD L16.44 X 1.06 X 8.21)                              | 1                    |                   |
| 91                    | (S)65-2312-5   | . . . WEIGHT, BALANCE, NOSE, OUTBOARD AILERON (MAKE FROM ANTIMONY LEAD L16.47 X 1.49 X 7.94)                              | 1                    |                   |
| 92                    | (S)65-2312-6   | . . . WEIGHT, BALANCE, NOSE, OUTBOARD AILERON (MAKE FROM ANTIMONY LEAD L16.46 X 1.46 X 8.06)                              | 1                    |                   |
| 93                    | (S)65-2312-7   | . . . WEIGHT, BALANCE, NOSE, OUTBOARD AILERON (MAKE FROM ANTIMONY LEAD L16.48 X 1.21 X 7.50)                              | 1                    |                   |
| 94                    | (S)65-2312-8   | . . . WEIGHT, BALANCE, NOSE, OUTBOARD AILERON (MAKE FROM ANTIMONY LEAD L16.48 X 1.23 X 7.42)                              | 1                    |                   |
| 94A                   | (S)66-9900-1   | . . . WEIGHT, BALANCE, NOSE, OUTBOARD AILERON (MAKE FROM ANTIMONY LEAD L16.048 X 1.2 X 5.60)                              | AR                   |                   |
| 94B                   | (S)66-9900     | . . . WEIGHT, BALANCE, NOSE, OUTBOARD AILERON (MAKE FROM ANTIMONY LEAD L16.048 X 1.2 X 6.60)                              | AR                   |                   |
| 95                    | (S)65-8405-1   | . . . RIB INSTL, OUTBOARD AILERON, WING STATION 930.734 (LM ONLY) (FOR BREAKDOWN SEE FIG. 30)                             | 1                    |                   |
|                       | (S)65-8405-2   | . . . RIB INSTL, OUTBOARD AILERON, WING STATION 930.734 (RM ONLY) (FOR BREAKDOWN SEE FIG. 30)                             | 1                    |                   |
| 96                    | (S)69-5650-3   | . . . RIB INSTL, OUTBOARD AILERON (STATION 930.24, 910.22, 890.21, 871.72, 853.23) (LM ONLY) (FOR BREAKDOWN SEE FIG. 31)  | 5                    |                   |
|                       | (S)69-5650-4   | . . . RIB INSTL, OUTBOARD AILERON (STATION 930.24, 910.22, 890.21, 871.72, 853.23) (RM ONLY) (FOR BREAKDOWN SEE FIG. 31)  | 5                    |                   |
| 97                    | (S)9-64574-9   | . . . RIB INSTL, OUTBOARD AILERON, WING STATION 835.10 (LM ONLY) (FOR BREAKDOWN SEE FIG. 32)                              | 1                    |                   |
|                       | (S)9-64574-10  | . . . RIB INSTL, OUTBOARD AILERON, WING STATION 835.10 (RM ONLY) (FOR BREAKDOWN SEE FIG. 32)                              | 1                    |                   |

| FIGURE &<br>INDEX NO. | PART NUMBER     | DESCRIPTION   | 1 2 3 4 5 6 7 |  |  |  |  |  |  | UNITS<br>PER<br>ASSY | USE<br>ON<br>COD |
|-----------------------|-----------------|---|---------------|--|--|--|--|--|--|----------------------|------------------|
|                       |                 |   |               |  |  |  |  |  |  |                      |                  |
| 25 -                  |                 |   |               |  |  |  |  |  |  |                      |                  |
| 98                    | (S)69-5650-21   | . . RIB INSTL, OUTBOARD AILERON (STATION 816.68) . . .  |               |  |  |  |  |  |  | 1                    |                  |
|                       | (S)69-5650-22   | (LM ONLY) (FOR BREAKDOWN SEE FIG. 31)                   |               |  |  |  |  |  |  |                      |                  |
|                       |                 | . . RIB INSTL, OUTBOARD AILERON (STATION 816.68) . . .  |               |  |  |  |  |  |  | 1                    |                  |
|                       |                 | (RM ONLY) (FOR BREAKDOWN SEE FIG. 31)                   |               |  |  |  |  |  |  |                      |                  |
| 99                    | (S)69-5652-1    | . . RIB INSTL, OUTBOARD AILERON (STATION 799.00, . . .  |               |  |  |  |  |  |  | 2                    |                  |
|                       | (S)69-5652-2    | 766.18) (LM ONLY) (FOR BREAKDOWN SEE FIG. 31)           |               |  |  |  |  |  |  |                      |                  |
|                       |                 | . . RIB INSTL, OUTBOARD AILERON (STATION 799.00, . . .  |               |  |  |  |  |  |  | 2                    |                  |
|                       |                 | 766.18) (RM ONLY) (FOR BREAKDOWN SEE FIG. 31)           |               |  |  |  |  |  |  |                      |                  |
| 100                   | DELETED         |   |               |  |  |  |  |  |  |                      |                  |
| 101                   | (S)69-5652-1    | . . RIB INSTL, OUTBOARD AILERON (STATION 780.96) . . .  |               |  |  |  |  |  |  | 1                    |                  |
|                       |                 | (LM ONLY) (FOR BREAKDOWN SEE FIG. 31)                   |               |  |  |  |  |  |  |                      |                  |
|                       | (S)69-5652-2    | . . RIB INSTL, OUTBOARD AILERON (STATION 780.96) . . .  |               |  |  |  |  |  |  | 1                    |                  |
|                       |                 | (RM ONLY) (FOR BREAKDOWN SEE FIG. 31)                   |               |  |  |  |  |  |  |                      |                  |
| 102                   | (S)69-5652-2    | . . RIB INSTL, OUTBOARD AILERON (STATION 778.96) . . .  |               |  |  |  |  |  |  | 1                    |                  |
|                       |                 | (LM ONLY) (FOR BREAKDOWN SEE FIG. 31)                   |               |  |  |  |  |  |  |                      |                  |
|                       | (S)69-5652-1    | . . RIB INSTL, OUTBOARD AILERON (STATION 778.96) . . .  |               |  |  |  |  |  |  | 1                    |                  |
|                       |                 | (RM ONLY) (FOR BREAKDOWN SEE FIG. 31)                   |               |  |  |  |  |  |  |                      |                  |
| 103                   | (S)69-5650-3    | . . RIB INSTL, OUTBOARD AILERON (STATION 753.40) . . .  |               |  |  |  |  |  |  | 1                    |                  |
|                       | (S)69-5650-4    | (LM ONLY) (FOR BREAKDOWN SEE FIG. 31)                   |               |  |  |  |  |  |  |                      |                  |
|                       |                 | . . RIB INSTL, OUTBOARD AILERON (STATION 753.40) . . .  |               |  |  |  |  |  |  | 1                    |                  |
|                       |                 | (RM ONLY) (FOR BREAKDOWN SEE FIG. 31)                   |               |  |  |  |  |  |  |                      |                  |
| 104                   | (S)69-5650-4    | . . RIB INSTL, OUTBOARD AILERON (STATION 751.40) . . .  |               |  |  |  |  |  |  | 1                    |                  |
|                       |                 | (LM ONLY) (FOR BREAKDOWN SEE FIG. 31)                   |               |  |  |  |  |  |  |                      |                  |
|                       | (S)69-5650-3    | . . RIB INSTL, OUTBOARD AILERON (STATION 751.40) . . .  |               |  |  |  |  |  |  | 1                    |                  |
|                       |                 | (RM ONLY) (FOR BREAKDOWN SEE FIG. 31)                   |               |  |  |  |  |  |  |                      |                  |
| 105                   | DELETED         |   |               |  |  |  |  |  |  |                      |                  |
| 106                   | (S)9-64571-5    | . . RIB INSTL, OUTBOARD AILERON, WING STATION 732.60 .  |               |  |  |  |  |  |  | 1                    |                  |
|                       |                 | (LM ONLY) (FOR BREAKDOWN SEE FIG. 33)                   |               |  |  |  |  |  |  |                      |                  |
|                       | (S)9-64571-6    | . . RIB INSTL, OUTBOARD AILERON, WING STATION 732.60 .  |               |  |  |  |  |  |  | 1                    |                  |
|                       |                 | (RM ONLY) (FOR BREAKDOWN SEE FIG. 33)                   |               |  |  |  |  |  |  |                      |                  |
| 107                   | (S)9-64570-11   | . . RIB INSTL, OUTBOARD AILERON, WING STATION 729.00 .  |               |  |  |  |  |  |  | 1                    |                  |
|                       |                 | (LM ONLY) (FOR BREAKDOWN SEE FIG. 34)                   |               |  |  |  |  |  |  |                      |                  |
|                       | (S)9-64570-12   | . . RIB INSTL, OUTBOARD AILERON, WING STATION 729.00 .  |               |  |  |  |  |  |  | 1                    |                  |
|                       |                 | (RM ONLY) (FOR BREAKDOWN SEE FIG. 34)                   |               |  |  |  |  |  |  |                      |                  |
| 108                   | (S)69-5650-1    | . . RIB INSTL, OUTBOARD AILERON, WING STATION 713.887 . |               |  |  |  |  |  |  | 1                    |                  |
|                       |                 | (LM ONLY) (FOR BREAKDOWN SEE FIG. 31)                   |               |  |  |  |  |  |  |                      |                  |
|                       | (S)69-5650-2    | . . RIB INSTL, OUTBOARD AILERON, WING STATION 718.887 . |               |  |  |  |  |  |  | 1                    |                  |
|                       |                 | (RM ONLY) (FOR BREAKDOWN SEE FIG. 31)                   |               |  |  |  |  |  |  |                      |                  |
| 109                   | (S)9-67025-17   | . . WEB, NOSE RIB, OUTBOARD AILERON (LM ONLY) . . . . . |               |  |  |  |  |  |  | 1                    |                  |
|                       | (S)9-67025-18   | . . WEB, NOSE RIB, OUTBOARD AILERON (RM ONLY) . . . . . |               |  |  |  |  |  |  | 1                    |                  |
| 110                   | (S)9-67025-1    | . . WEB, NOSE RIB, OUTBOARD AILERON (LM ONLY) . . . . . |               |  |  |  |  |  |  | 1                    |                  |
|                       | (S)9-67025-2    | . . WEB, NOSE RIB, OUTBOARD AILERON (RM ONLY) . . . . . |               |  |  |  |  |  |  | 1                    |                  |
| 111                   | (S)9-67066-1    | . . RIB, NOSE, OUTBOARD AILERON (LM ONLY) . . . . .     |               |  |  |  |  |  |  | 1                    |                  |
|                       | (S)9-67066-2    | . . RIB, NOSE, OUTBOARD AILERON (RM ONLY) . . . . .     |               |  |  |  |  |  |  | 1                    |                  |
| 112                   | (S)9-67025-1651 | . . WEB, NOSE RIB, OUTBOARD AILERON (LM ONLY) . . . . . |               |  |  |  |  |  |  | 7                    |                  |
|                       | (S)9-67025-1652 | . . WEB, NOSE RIB, OUTBOARD AILERON (RM ONLY) . . . . . |               |  |  |  |  |  |  | 7                    |                  |
| 113                   | (S)9-67066-3    | . . RIB, NOSE, OUTBOARD AILERON (LM ONLY) . . . . .     |               |  |  |  |  |  |  | 7                    |                  |
|                       | (S)9-67066-4    | . . RIB, NOSE, OUTBOARD AILERON (RM ONLY) . . . . .     |               |  |  |  |  |  |  | 7                    |                  |
| 114                   | (S)9-67025-1652 | . . WEB, NOSE RIB, OUTBOARD AILERON (LM ONLY) . . . . . |               |  |  |  |  |  |  | 6                    |                  |
|                       | (S)9-67025-1651 | . . WEB, NOSE RIB, OUTBOARD AILERON (RM ONLY) . . . . . |               |  |  |  |  |  |  | 6                    |                  |
| 115                   | (S)9-67066-4    | . . RIB, NOSE, OUTBOARD AILERON (LM ONLY) . . . . .     |               |  |  |  |  |  |  | 6                    |                  |
|                       | (S)9-67066-3    | . . RIB, NOSE, OUTBOARD AILERON (RM ONLY) . . . . .     |               |  |  |  |  |  |  | 6                    |                  |
| 116                   | (S)9-67025-7    | . . WEB, NOSE RIB, OUTBOARD AILERON (LM ONLY) . . . . . |               |  |  |  |  |  |  | 3                    |                  |
|                       | (S)9-67025-8    | . . WEB, NOSE RIB, OUTBOARD AILERON (RM ONLY) . . . . . |               |  |  |  |  |  |  | 3                    |                  |
| 117                   | (S)9-67066-13   | . . RIB, NOSE, OUTBOARD AILERON (LM ONLY) . . . . .     |               |  |  |  |  |  |  | 3                    |                  |
|                       | (S)9-67066-14   | . . RIB, NOSE, OUTBOARD AILERON (RM ONLY) . . . . .     |               |  |  |  |  |  |  | 3                    |                  |
| 118                   | (S)9-67025-8    | . . WEB, NOSE RIB, OUTBOARD AILERON (LM ONLY) . . . . . |               |  |  |  |  |  |  | 3                    |                  |
|                       | (S)9-67025-7    | . . WEB, NOSE RIB, OUTBOARD AILERON (RM ONLY) . . . . . |               |  |  |  |  |  |  | 3                    |                  |
| 119                   | (S)9-67066-14   | . . RIB, NOSE, OUTBOARD AILERON (LM ONLY) . . . . .     |               |  |  |  |  |  |  | 3                    |                  |
|                       | (S)9-67066-13   | . . RIB, NOSE, OUTBOARD AILERON (RM ONLY) . . . . .     |               |  |  |  |  |  |  | 3                    |                  |
| 120                   | (S)9-67025-5    | . . WEB, NOSE RIB, OUTBOARD AILERON (LM ONLY) . . . . . |               |  |  |  |  |  |  | 2                    |                  |
|                       | (S)9-67025-6    | . . WEB, NOSE RIB, OUTBOARD AILERON (RM ONLY) . . . . . |               |  |  |  |  |  |  | 2                    |                  |
| 121                   | (S)9-67066-5    | . . RIB, NOSE, OUTBOARD AILERON (LM ONLY) . . . . .     |               |  |  |  |  |  |  | 2                    |                  |
|                       | (S)9-67066-6    | . . RIB, NOSE, OUTBOARD AILERON (RM ONLY) . . . . .     |               |  |  |  |  |  |  | 2                    |                  |
| 122                   | (S)9-67025-6    | . . WEB, NOSE RIB, OUTBOARD AILERON (LM ONLY) . . . . . |               |  |  |  |  |  |  | 2                    |                  |
|                       | (S)9-67025-5    | . . WEB, NOSE RIB, OUTBOARD AILERON (RM ONLY) . . . . . |               |  |  |  |  |  |  | 2                    |                  |
| 123                   | (S)9-67066-6    | . . RIB, NOSE, OUTBOARD AILERON (LM ONLY) . . . . .     |               |  |  |  |  |  |  | 2                    |                  |
|                       | (S)9-67066-5    | . . RIB, NOSE, OUTBOARD AILERON (RM ONLY) . . . . .     |               |  |  |  |  |  |  | 2                    |                  |
| 124                   | (S)9-67025-21   | . . WEB, NOSE RIB, OUTBOARD AILERON (LM ONLY) . . . . . |               |  |  |  |  |  |  | 1                    |                  |
|                       | (S)9-67025-22   | . . WEB, NOSE RIB, OUTBOARD AILERON (RM ONLY) . . . . . |               |  |  |  |  |  |  | 1                    |                  |
| 125                   | (S)9-67066-21   | . . RIB, NOSE, OUTBOARD AILERON (LM ONLY) . . . . .     |               |  |  |  |  |  |  | 1                    |                  |
|                       | (S)9-67066-22   | . . RIB, NOSE, OUTBOARD AILERON (RM ONLY) . . . . .     |               |  |  |  |  |  |  | 1                    |                  |
| 126                   | (S)9-67025-22   | . . WEB, NOSE RIB, OUTBOARD AILERON (LM ONLY) . . . . . |               |  |  |  |  |  |  | 1                    |                  |

Section II  
Group Assembly Parts List

T.O. 1C-125A 4

| FIGURE &<br>INDEX NO. | PART NUMBER   | DESCRIPTION   | UNITS<br>PER<br>ASSY | USE<br>ON<br>CODE |
|-----------------------|---------------|---|----------------------|-------------------|
| 25 -                  |               | 1 2 3 4 5 6 7   |                      |                   |
| 127                   | (S)9-67025-21 | • • WEB, NOSE RIB, OUTBOARD AILERON (RH ONLY) . . . . .   | 1                    |                   |
|                       | (S)9-67066-22 | • • RIB, NOSE, OUTBOARD AILERON (LM ONLY) . . . . .   | 1                    |                   |
|                       | (S)9-67066-21 | • • RIB, NOSE, OUTBOARD AILERON (LM ONLY) . . . . .   | 1                    |                   |
| 128                   | (S)9-67025-19 | • • WEB, NOSE RIB, OUTBOARD AILERON (LM ONLY) . . . . .   | 1                    |                   |
|                       | (S)9-67025-20 | • • WEB, NOSE RIB, OUTBOARD AILERON (RH ONLY) . . . . .   | 1                    |                   |
| 129                   | (S)9-67066-3  | • • RIB, NOSE, OUTBOARD AILERON (LM ONLY) . . . . .   | 1                    |                   |
|                       | (S)9-67066-4  | • • RIB, NOSE, OUTBOARD AILERON (RH ONLY) . . . . .   | 1                    |                   |
| 130                   | (S)9-67025-19 | • • WEB, NOSE RIB, OUTBOARD AILERON (LM ONLY) . . . . .   | 1                    |                   |
|                       | (S)9-67025-20 | • • WEB, NOSE RIB, OUTBOARD AILERON (RH ONLY) . . . . .   | 1                    |                   |
| 131                   | DELETED       |   |                      |                   |
| 132                   | (S)9-67066-15 | • • RIB, NOSE, OUTBOARD AILERON (LM ONLY) . . . . .   | 1                    |                   |
|                       | (S)9-67066-16 | • • RIB, NOSE, OUTBOARD AILERON (RH ONLY) . . . . .   | 1                    |                   |
| 133                   | DELETED       |   |                      |                   |
| 134                   | DELETED       |   |                      |                   |
| 135                   | (S)9-67025-19 | • • WEB, NOSE RIB, OUTBOARD AILERON (LM ONLY) . . . . .   | 1                    |                   |
|                       | (S)9-67025-20 | • • WEB, NOSE RIB, OUTBOARD AILERON (RH ONLY) . . . . .   | 1                    |                   |
| 136                   | (S)9-67066-17 | • • RIB, NOSE, OUTBOARD AILERON (LM ONLY) . . . . .   | 1                    |                   |
|                       | (S)9-67066-18 | • • RIB, NOSE, OUTBOARD AILERON (RH ONLY) . . . . .   | 1                    |                   |
| 137                   | (S)9-67025-11 | • • WEB, NOSE RIB, OUTBOARD AILERON (LM ONLY) . . . . .   | 1                    |                   |
|                       | (S)9-67025-12 | • • WEB, NOSE RIB, OUTBOARD AILERON (RH ONLY) . . . . .   | 1                    |                   |
| 138                   | (S)9-67066-19 | • • RIB, NOSE, OUTBOARD AILERON (LM ONLY) . . . . .   | 1                    |                   |
|                       | (S)9-67066-20 | • • RIB, NOSE, OUTBOARD AILERON (RH ONLY) . . . . .   | 1                    |                   |
| 139                   | (S)9-67025-13 | • • WEB, NOSE RIB, OUTBOARD AILERON (LM ONLY) . . . . .   | 1                    |                   |
|                       | (S)9-67025-14 | • • WEB, NOSE RIB, OUTBOARD AILERON (RH ONLY) . . . . .   | 1                    |                   |
| 140                   | (S)66-5296-1  | • • WEB, NOSE RIB, OUTBOARD AILERON (LM ONLY) . . . . .   | 1                    |                   |
|                       | (S)66-5296-2  | • • WEB, NOSE RIB, OUTBOARD AILERON (RH ONLY) . . . . .   | 1                    |                   |
|                       | 9-64026-83    | • TAB ASSY, HONEYCOMB, OUTBOARD AILERON (LM ONLY) . . . . .   | 1                    |                   |
|                       | 9-64026-1001  | • TAB ASSY, HONEYCOMB, OUTBOARD AILERON (FOR SPARES . . . . .<br>ONLY) (CONSISTS OF PARTS DENOTED BY (S))                                       | REF                  |                   |
|                       | 9-64026-84    | • TAB ASSY, HONEYCOMB, OUTBOARD AILERON (RH ONLY) . . . . .   | 1                    |                   |
|                       | 9-64026-1002  | • TAB ASSY, HONEYCOMB, OUTBOARD AILERON (FOR SPARES . . . . .<br>ONLY) (CONSISTS OF PARTS DENOTED BY (S))                                       | REF                  |                   |
| 141                   | (S)740K5A5A6  | • • JUMPER, BOND., IRRADIATED, POLYOLEFIN, INSULATED . . . . .<br>(91812) (BACJ40K5A5A6)<br>(ATTACHING PARTS)                                   | 2                    |                   |
| 141A                  | (S)N45517-3-2 | • • SCREW (FOR REPLACEMENT ORDER BACB30LU3-2) . . . . .   | 2                    |                   |
| 141B                  | 9-64026-49    | • • FILLER, HONEYCOMB TAB, OUTBOARD AILERON (FOR . . . . .<br>SPARES ONLY)  | 2                    |                   |
| 141C                  | NAS679A3W     | • • NUT (FOR SPARES ONLY) (FOR REPLACEMENT ORDER 96-02<br>(56878) (80539) H10-3BAC (15653) T6S1032J<br>(71097) RMLH9075-3W (72962) (BACN10JC3)) | 2                    |                   |
| 142                   | (S)60-3722-1  | • • FAIRING, TAB MAST, OUTBOARD AILERON (LM ONLY) . . . . .   | 2                    |                   |
|                       | (S)60-3722-2  | • • FAIRING, TAB MAST, OUTBOARD AILERON (RH ONLY) . . . . .   | 2                    |                   |
| 142A                  | (S)AN7510F1   | • • PLATE, IDENTIFICATION (ALTERNATE BACN12M30-1CD) . . . . .   | 1                    |                   |
| 142A                  | BACN12M30-1CD | • • NAMEPLATE (ALTERNATE TO AN7510F1) (FOR SPARES ONLY) . . . . .   | 1                    |                   |
| 143                   | 66-8420-3001  | • • WEIGHT ASSY, BALANCE, TAB, OUTBOARD AILERON (FOR . . . . .<br>SPARES ONLY)  | AR                   |                   |
|                       | 9-64026-81    | • • CORE ASSY, HONEYCOMB, TAB, OUTBOARD AILERON . . . . .<br>(LM ONLY)  | 1                    |                   |
|                       | 9-64026-92    | • • CORE ASSY, HONEYCOMB, TAB, OUTBOARD AILERON . . . . .<br>(RH ONLY)  | 1                    |                   |
|                       | 9-64026-87    | • • SPAR ASSY, TAB CORE, HONEYCOMB, OUTBOARD AILERON . . . . .<br>(LM ONLY)   | 1                    |                   |
|                       | 9-64026-88    | • • SPAR ASSY, TAB CORE, HONEYCOMB, OUTBOARD AILERON . . . . .<br>(RH ONLY)   | 1                    |                   |
| 144                   | 9-64026-85    | • • HINGE-HALF, SPAR, TAB CORE, HONEYCOMB, OUTBOARD . . . . .<br>AILERON (LM ONLY)  | 1                    |                   |
|                       | 9-64026-86    | • • HINGE-HALF, SPAR, TAB CORE, HONEYCOMB, OUTBOARD . . . . .<br>AILERON (RH ONLY)  | 1                    |                   |
| 145                   | NAS1223-1L    | • • BOLT (FOR REPLACEMENT ORDER BACB30NE3LN1) . . . . .<br>(FOR SPARES ONLY)  | 24                   |                   |
| 146                   | 69-33855-1    | • • RETAINER, BOLT, TAB, OUTBOARD AILERON (FOR SPARES . . . . .<br>ONLY)  | 12                   |                   |
| 147                   | BACS40A10-64  | • • SHIM, LAM, 0.030 THK (FOR SPARES ONLY) (MAKE FROM . . . . .<br>BAC1534-62, 5/8" x 4")   | 4                    |                   |
| 147                   | BACS40A10-64  | • • SHIM, LAM, 0.030 THK (FOR SPARES ONLY) . . . . .  | 4                    |                   |
| 148                   | 69-33849-1    | • • HINGE-HALF, TAB, OUTBOARD AILERON (FOR SPARES ONLY) . . . . .<br>(LM ONLY)  | 1                    |                   |
|                       | 69-33849-2    | • • HINGE-HALF, TAB, OUTBOARD AILERON (FOR SPARES ONLY) . . . . .<br>(RH ONLY)  | 1                    |                   |
| 149                   | 69-33849-2    | • • HINGE-HALF, TAB, OUTBOARD AILERON (FOR SPARES ONLY) . . . . .<br>(LM ONLY)  | 1                    |                   |



| FIGURE &<br>INDEX NO. | PART NUMBER  | DESCRIPTION   | UNITS<br>PER<br>ASSY | USE<br>ON<br>CODE |
|-----------------------|--------------|---|----------------------|-------------------|
|                       |              | 1 2 3 4 5 6 7   |                      |                   |
| 25 -                  | 69-33849-1   | . . HINGE-HALF, TAB, OUTBOARD AILERON (FOR SPARES ONLY) (RM ONLY)                           | 1                    |                   |
| 150                   | 69-33849-3   | . . HINGE-HALF, TAB, OUTBOARD AILERON (FOR SPARES ONLY)                                     | 4                    |                   |
|                       | 9-64026-1009 | . . CORE ASSY, HONEYCOMB, TAB, OUTBOARD AILERON (FOR SPARES ONLY) (LM ONLY)                 | 1                    |                   |
|                       | 9-64026-1010 | . . CORE ASSY, HONEYCOMB, TAB, OUTBOARD AILERON (FOR SPARES ONLY) (RM ONLY)                 | 1                    |                   |
|                       | 9-64026-1005 | . . . SPAR ASSY, TAB CORE, HONEYCOMB, OUTBOARD AILERON (FOR SPARES ONLY) (LM ONLY)          | 1                    |                   |
|                       | 9-64026-1006 | . . . SPAR ASSY, TAB CORE, HONEYCOMB, OUTBOARD AILERON (FOR SPARES ONLY) (RM ONLY)          | 1                    |                   |
| 151                   | 9-64026-1003 | . . . . HINGE-HALF, SPAR, TAB CORE, HONEYCOMB, OUTBOARD AILERON (FOR SPARES ONLY) (LM ONLY) | 1                    |                   |
|                       | 9-64026-1004 | . . . . HINGE-HALF, SPAR, TAB CORE, HONEYCOMB, OUTBOARD AILERON (FOR SPARES ONLY) (RM ONLY) | 1                    |                   |
| 152                   | BAC540A10-72 | . . . . SHIM, LAM, 0.030 THK (FOR SPARES ONLY) (MAKE . . FROM BAC1534-62, 5/8" x 4 1/2")    | 2                    |                   |
|                       |              | A 3001 THRU 3001  |                      |                   |
|                       |              | B 2201 THRU 2299, 3002 THRU 3099  |                      |                   |
|                       |              | C 2201 THRU 2299  |                      |                   |
|                       |              | D 3001 THRU 3099  |                      |                   |

# FLOW PROCESS CHART

SUBJECT AILERON ASSY OUTBOARD KC-135

DATE 4/5/89

PCN: 15250A WCD: 15249A WCD DATE: 88055

CHART BEGINS

PAGE 1 OF 1

CHART ENDS

PREPARED BY: LARRY

| WCD<br>OF<br>B | SYMBOLS | DESCRIPTION                                | WCD<br>OF<br>B | SYMBOLS | DESCRIPTION                                      |
|----------------|---------|--|----------------|---------|--|
| 010            | ● ○ □ ▽ | REMOVE / UNCRATE<br>2122 MBPCA             | 270            | ● ○ □ ▽ | CORROSION WORK                                   |
|                | ● ○ □ ▽ | DELAY<br>PASTE TO PAINT<br>DELAY           | 275            | ● ○ □ ▽ | REMOVE SKIN PANELS                               |
| 020            | ● ○ □ ▽ | STRIP PAINT<br>2122 MBPCA                  | 280            | ● ○ □ ▽ | LAYOUT/FABRICATE NEW SKINS                       |
|                | ● ○ □ ▽ | DELAY                                      | 285            | ● ○ □ ▽ | REPLACE IN/OUT TRAILING<br>EDGES                 |
| 030            | ● ○ □ ▽ | TREAT FOR CORROSION<br>2122 MBPCA          | 290            | ● ○ □ ▽ | ALIGNMENT CHECK/INSTALL IN<br>FIXTURE            |
|                | ● ○ □ ▽ | DELAY                                      | 300            | ● ○ □ ▽ | REPLACE OUTBOARD HONEYCOMB<br>TRAILING EDGE      |
|                | ● ○ □ ▽ | MOVE TO 95                                 | 310            | ● ○ □ ▽ | INSTALL NEW SKIN PANELS/<br>PAIRINGS             |
|                | ● ○ □ ▽ | DELAY                                      | 320            | ● ○ □ ▽ | REPAIR TAB HINGE SPAR                            |
| 040            | ● ○ □ ▽ | REMOVE ACCESS PANELS<br>95 MBPCA           | 330            | ● ○ □ ▽ | INSPECT FOR / REMOVE FOD                         |
| 050            | ● ○ □ ▽ | REMOVE SKIN PANELS                         | 340            | ● ○ □ ▽ | INSTALL IN/OUT SKIN PANELS                       |
| 055            | ● ○ □ ▽ | ACCOMPLISH SHADOW<br>INSPECTION            | 350            | ● ○ □ ▽ | PERFORM ALIGNMENT CHECK/<br>REMOVE FROM JIG      |
|                | ● ○ □ ▽ | DELAY                                      | 360            | ● ○ □ ▽ | INSTALL SPAR HINGE HAWES                         |
| 060            | ● ○ □ ▽ | REPAIR CYCLE - REPLACE<br>WORN SAILS MBPCA | 370            | ● ○ □ ▽ | REPLACE DAMAGED ACCESSORY<br>DOOR                |
| 070            | ● ○ □ ▽ | REPLACE CRACKED RIBS                       | 380            | ● ○ □ ▽ | INSTALL ACCESS DOORS                             |
| 075            | ● ○ □ ▽ | REPAIR HINGE ASSY                          | 395            | ● ○ □ ▽ | REMOVE DENTS, SCRATCHES<br>ETC IN OUTER SURFACES |
| 076            | ● ○ □ ▽ | INSTALL SKIN PANELS                        | 400            | ● ○ □ ▽ | APPLY AERO SEALANT                               |
| 077            | ● ○ □ ▽ | REPLACE CRACKED BEARING<br>CASTINGS        |                | ○ ○ □ ▽ | DELAY  |
| 080            | ● ○ □ ▽ | CLEAN/TREAT CORROSION                      |                | ○ ○ □ ▽ | MOVE TO 2280                                     |
| 085            | ● ○ □ ▽ | REPLACE BALANCE PANEL/DOOR                 |                | ○ ○ □ ▽ | DELAY  |
| 090            | ● ○ □ ▽ | REPLACE CAPS                               | 410            | ● ○ □ ▽ | FINAL WASH / CORROSION TREAT<br>2280 MBPCA       |
| 100            | ● ○ □ ▽ | REP/REP NOSE SKINS                         | 420            | ● ○ □ ▽ | PAINT AILERON<br>2280 MBPCA                      |
| 110            | ● ○ □ ▽ | REP/REP IN/OUT NOSE<br>SKINS               |                | ○ ○ □ ▽ | DELAY  |
| 115            | ● ○ □ ▽ | CLEAN/TREAT INTERNAL<br>CORROSION          |                | ○ ○ □ ▽ | MOVE TO 95                                       |
| 120            | ● ○ □ ▽ | INSTALL SKIN PANEL / ACCESS<br>DOORS       |                | ○ ○ □ ▽ | DELAY  |
| 170            | ● ○ □ ▽ | REPLACE BAD FASTENERS<br>EXTERNAL          | 430            | ● ○ □ ▽ | BALANCE AILERON<br>95 MBPCA                      |
| 180            | ● ○ □ ▽ | SERVICE/REP BEARING SUPPORT                | 440            | ● ○ □ ▽ | INSTALL DEAL WITH CURRENT<br>WEIGHT              |
| 190            | ● ○ □ ▽ | REPLACE DAMAGED SMALL<br>PARTS             | 450            | ● ○ □ ▽ | WORK COMPLETE / CONTINUE TAG                     |
| 250            | ● ○ □ ▽ | REPLACE BAD FASTENERS<br>INTERNAL          |                | ○ ○ □ ▽ |  |
| 260            | ● ○ □ ▽ | REMOVE TAB HINGE SPAR                      |                | ○ ○ □ ▽ |  |

\*\*\*\*\*  
 15249A \* WORK CONTROL DOCUMENT \* 1. DATE 80055 PAGE 1 OF 4 PAGES  
 \*\*\*\*\*  
 12. ORIG/PROD NR 13. QUANTITY 14. PROD SECTION/RCC 15. DATE SCHED 16. DATE COMP  
 MBPAB 89093

17. PART NUMBER 19. ITEM SERIAL NR 18/12. TECH DATA/OPTIONAL  
 1. SOW C/N: UC-1560FL/  
 28-1-32, DTD / AUG 78,  
 10. MODEL/DESIGN/SERIES 11. STOCK NR 2. REVISION NO 2 DTD  
 10-135 20 FEB 79.  
 3. WRITE IN ANY ADD'L  
 13. BISC 14. NOUN/END ITEM NOUN  
 MICHAEL TYTANIC/MADLDC/65261  
 4. MARKED FROM CONTROL  
 NO.)  
 5. " MARKLY DASHET "  
 P/N NON C/N  
 5-00170-103 1560007230007L 15222A  
 5-00170-117 (M) 1560008722400FL 15249A ✓  
 5-00170-93 1560006366184FL 15190A  
 5-00170-118 (M) 1560008722401FL 15250A ✓  
 5-00170-104 15600072300101L 15223A

15. DISP-16. PDN/  
 STATION/UP NO. 17. WORK TO BE ACCOMPLISHED 18. BLK 19. "P" 20. "Q"  
 2122 010 RECEIVE & UNCRATE CU / /  
 MBPAB MOVE TO WASH RACK MBPAB  
 2122 020 STRIP EXTERIOR PAINT IAW 40 / /  
 MBPAB 10-135(K)A-3 4, SEC X1 (PLUG ALL  
 DRAIN HOLES IAW PARA 2 OF S.O.W.)  
 2122 030 TREAT FOR CORROSION IAW 10-135(K) 40 / /  
 MBPAB A 3 4, SECT. IV. MOVE TO MABPAB  
 BLDG 95  
 95 040 REMOVE ALL ACCESS DOORS FOR ES / /  
 MBPAB INSPECTION AND REPAIR  
 95 050 REMOVE UPPER INBD & OUTBD SKIN ES / /  
 MBPAB PANELS FOR INSPECTION & REPAIR  
 OBSERVE CAUTION  
 95 055 ACC. SHAKEDOWN INSPECTION IAW ES / /  
 MBPAB S.O.W.  
 95 060 REPLACE WORN OR DAMAGED SEALS WITH ES / /  
 MBPAB NEW SEALS.  
 REQ'D \_\_\_\_\_ NOT REQ'D \_\_\_\_\_  
 95 070 REPLACE CRACKED RIBS AND WEBS, ETC ES / /  
 MBPAB REF S.O.W.  
 REQ'D \_\_\_\_\_ NOT REQ'D \_\_\_\_\_  
 95 075 REPAIR LEAD WEIGHTS FROM HINGE ES / /  
 MBPAB ASSY  
 REQ'D \_\_\_\_\_ NOT REQ'D \_\_\_\_\_  
 95 076 INSTALL LOWER SKIN PANELS UNDER ES / /  
 MBPAB HINGES.

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 15249A \* WORK CONTROL DOCUMENT \* 1. DATE 08055 PAGE 2 OF 4 PAGES  
 15. DICP-16. PDN/  
 STATION/OP NO. 17. WORK TO BE ACCOMPLISHED 18. RECH 19. "P" 20. "M"

|    |              |  |    |   |   |
|----|--------------|--|----|---|---|
| 95 | 077<br>MBPAB | REPLACE CRACKED BEARING CASTINGS.<br>REQD _____ NOT REQD _____   | ES | / | / |
|    | 000<br>MBPAB | CLEAN & TREAT CORROSION IAW 1C-135<br>(K)A-3-4, SLOTT V  | ES | / | / |
| 95 | 105<br>MBPAB | REPLACE BALANCE PANEL ATTACH. HINGE<br>ASSYS<br>REQ'D _____ NOT REQ'D _____  | ES | / | / |
| 95 | 108<br>MBPAB | REPLACE INBD AND OUTBD END CAPS<br>REQD _____ NOT REQD _____   | ES | / | / |
| 95 | 110<br>MBPAB | REPAIR/REPLACE SHORT NOSE GRIND<br>REQD _____ NOT REQD _____   | ES | / | / |
| 95 | 113<br>MBPAB | REPAIR OR REPLACE INBD & OUTBD NOSE<br>SKINS.<br>REQ'D _____ NOT REQ'D _____   | ES | / | / |
| 95 | 115<br>MBPAB | CLEAN & TREAT INTERNAL CORROSION IAW<br>1C-135(A)-3-4  | ES | E | / |
| 95 | 120<br>MBPAB | INSTALL LOWER SKIN PANEL & ACCESS<br>DOORS   | ES | / | / |
| 95 | 170<br>MBPAB | REPLACE ALL LOOSE, SHEARED, OR MISS-<br>ING FASTENERS (MARKED)<br>REQ'D _____ NOT REQ'D _____                          | ES | / | / |
| 95 | 180<br>MBPAB | SERVICE/REPLACE BEARING SUPPORTS<br>REQ'D _____ NOT REQ'D _____  | ES | / | / |
| 95 | 190<br>MBPAB | REPLACE DAMAGED HINGE RETAINERS,<br>ANGLES, CLIPS & CHANNELS<br>REQ'D _____ NOT REQ'D _____                            | ES | / | / |
| 95 | 250<br>MBPAB | REPLACE LOOSE, SHEARED, OR MISSING<br>INTERNAL FASTENERS<br>1C-135(E)C-2 11-1, FIG 1 2.<br>REQ'D _____ NOT REQ'D _____ | ES | / | / |
| 95 | 260<br>MBPAB | REMOVE TAB HINGE SPAR<br>REQD _____ NOT REQD _____   | ES | / | / |
| 95 | 270<br>MBPAB | CLEAN & TREAT EXTERNAL CORROSION IAW<br>1C-135(K)A-3 4, SLOTT IV.  | ES | / | / |
| 95 | 275<br>MBPAB | REMOVE OLD SKIN PANELS<br>REQD _____ NOT REQD _____  | ES | / | / |

|   |              |   |                                 |   |   |
|---|--------------|---|---------------------------------|---|---|
| *****                                       |              |   |                                 |   |   |
| 15249A - WORK CONTROL DOCUMENT              |              |   | 1. DATE 80055 PAGE 3 OF 4 PAGES |   |   |
| 15. DISP-16. PDN/                           |              |   |                                 |   |   |
| STATION OP NO. 117. WORK TO BE ACCOMPLISHED |              |   | 113. MECH 12" P 120" Q          |   |   |
| 95  | 280<br>MBPAB | LAYOUT & FABRICATE NLW SKIN PANELS  | LS                              | / | / |
|   |              | REQD _____ NOT REQD _____   |                                 |   |   |
| 95  | 285<br>MBPAB | REMOVE & REPLACE INBD AND OUTBD TRAILING EDGES                                | ES                              | / |   |
|   |              | REQD _____ NOT REQD _____   |                                 |   |   |
| 95  | 290<br>MBPAB | INSTALL AILERON IN JIG 590CJ1000 FOR ALIGNMENT CHECK.                         | ES                              | / | / |
|   |              | EDGE IAW 10-135(K)A-3-1   |                                 |   |   |
|   |              | REQ'D _____ NOT REQ'D _____   |                                 |   |   |
| 95  | 295<br>MBPAB | REPLACE I. B. HONEYCOMB TRAILING EDGE IAW 10-135(K)A-3-1                      | ES                              | / | / |
|   |              | REQD _____ NOT REQD _____   |                                 |   |   |
| 95  | 300<br>MBPAB | REPLACE O. B. HONEYCOMB TRAILING EDGE IAW 10-135(K)A-3-1                      | ES                              | / | / |
|   |              | REQ'D _____ NOT REQ'D _____   |                                 |   |   |
| 95  | 310<br>MBPAB | INSTALL NEW SKIN PANELS AND FAIRINGS  | ES                              | / | / |
|   |              | REQD _____ NOT REQD _____   |                                 |   |   |
| 95  | 320<br>MBPAB | REPAIR TAB HINGE SPAR IAW AC 135(K)A-3-1 FIG 2-103                            | ES                              | / | / |
|   |              | REQ'D _____ NOT REQ'D _____   |                                 |   |   |
| 95  | 330<br>MBPAB | REMOVE FOD. ACCOMP CLOSEOUT INSP.   | ES                              | E | / |
| 95  | 340<br>MBPAB | INSTALL INBOARD AND OUTBOARD SKIN PANELS                                      | ES                              | / | / |
| 95  | 350<br>MBPAB | PERFORM ALIGNMENT CHECK AND REMOVE AILERON FROM JIG                           | ES                              | E | / |
| 95  | 360<br>MBPAB | INSTALL SPAR HINGE HALVES   | LS                              | / | / |
|   |              | REQD _____ NOT REQD _____   |                                 |   |   |
| 95  | 380<br>MBPAB | REPLACE DAMAGED OR CRACKED ACCESSORY DOOR.                                    | ES                              | / | / |
|   |              | REQD _____ NOT REQD _____   |                                 |   |   |
| 95  | 390<br>MBPAB | INSTALL ACCESS DOORS  | ES                              | / | / |
| 95  | 395<br>MBPAB | REPAIR DENTS, SCRATCHES & COUGES IN OUTR SURFACES IAW 10-135(K)A-3-1 C-2-11-1 | ES                              | E | / |
|   |              | REQD _____ NOT REQD _____   |                                 |   |   |

|                                |        |                                      |           |                         |  |  |                      |  |  |
|--------------------------------|--------|--------------------------------------|-----------|-------------------------|--|--|----------------------|--|--|
| *****XXXXXXXXXXXXXXXXXXXX***** |        |                                      |           |                         |  |  |                      |  |  |
| 13249A WORK CONTROL DOCUMENT   |        |                                      |           | LCHN 33053              |  |  | PAGE 4 OF 4 PAGES    |  |  |
| 15.DISP-18.PDN/                |        |                                      |           |                         |  |  |                      |  |  |
| STATION/OP NO. 117             |        |                                      |           | WORK TO BE ACCOMPLISHED |  |  | 18.MECH 12"0" 120"0" |  |  |
| 75                             | 400    | FILL ALL SKIN, TRAILING EDGE, &      | ES        | E                       |  |  |                      |  |  |
|                                | MBFAB  | SKIN PANEL ACCESS COVER GAPS WITH    |           |                         |  |  |                      |  |  |
|                                |        | ENVIRONMENTAL SEALANT.               |           |                         |  |  |                      |  |  |
| 2200                           | 410    | FINAL WASH & CORROSION TREAT         |           |                         |  |  |                      |  |  |
|                                | MBPCB  | MOVE TO PAINT, BLDG 2200, MBPCB      |           |                         |  |  |                      |  |  |
| 420                            | 420    | PAINT AILERON IAW T.O. 10-135(K)     | B         |                         |  |  |                      |  |  |
|                                | MBPCB  | 3-3-1, 1-1-4, 10-135(K)A-3-4, OR     |           |                         |  |  |                      |  |  |
|                                |        | SPECIAL REQUIREMENT. MOVE TO         |           |                         |  |  |                      |  |  |
|                                |        | BLDG 22 MBPCB                        |           |                         |  |  |                      |  |  |
| 430                            | 430    | BALANCE AILERON ASSEMBLY IAW T.O.    | ES        |                         |  |  |                      |  |  |
|                                | MBPCB  | 10-135(K)A-3-3, FIG 1-3,             |           |                         |  |  |                      |  |  |
|                                |        | INSTALL NEW METAL CHL OR DECAL WITH  | ES        |                         |  |  |                      |  |  |
|                                | MBPCB  | CURRENT WEIGHT AND DATA AND DATE.    |           |                         |  |  |                      |  |  |
|                                |        | SERVICE BEARINGS & WRAP WITH BARRIER |           |                         |  |  |                      |  |  |
|                                |        | PAPER.                               |           |                         |  |  |                      |  |  |
| 25                             | 450    | WORK COMPLETED, CONDITION IAW IAW    | ES        | E                       |  |  |                      |  |  |
|                                | MBPCB  | AFM 67-1. DATE                       |           |                         |  |  |                      |  |  |
|                                |        | MOVE TO CRATING.                     |           |                         |  |  |                      |  |  |
|                                |        | NOTE: PART WILL HAVE EITHER OR ALL   |           |                         |  |  |                      |  |  |
|                                |        | FORM 586, 587, OR 588 IDENTIFICATION |           |                         |  |  |                      |  |  |
|                                |        | LABELS APPLIED TO COMPLETED ITEM IAW |           |                         |  |  |                      |  |  |
|                                |        | AFM 66-51, CHG 1. ACCEPTABLE DATE    |           |                         |  |  |                      |  |  |
|                                |        | ON THE LABEL ALONG WITH "N" STAMP    |           |                         |  |  |                      |  |  |
|                                |        | OF PERSON PERFORMING THE OVERHAUL    |           |                         |  |  |                      |  |  |
|                                |        | CAUTION: SURFACES TO WHICH LABELS    |           |                         |  |  |                      |  |  |
|                                |        | ARE APPLIED MUST BE FREE OF CONTA-   |           |                         |  |  |                      |  |  |
|                                |        | MINATION.                            |           |                         |  |  |                      |  |  |
|                                |        | " MARKET BASKET "                    |           |                         |  |  |                      |  |  |
| COORDINATION                   |        |                                      |           |                         |  |  |                      |  |  |
|                                | MABEFS | MIKE TYTANIC                         | 23 FEB 88 |                         |  |  |                      |  |  |
|                                | MAQBF  | TLD HAYES                            | 23 FEB 88 |                         |  |  |                      |  |  |
|                                | MABPAB | GARY HART                            | 23 FEB 88 |                         |  |  |                      |  |  |
|                                | MAQBSF | PAT HANLUCK                          | 23 FEB 88 |                         |  |  |                      |  |  |

# LABOR STANDARDS

**ENTER DATA AS NEEDED**





MBPAB F 15188A 00K10 707 CONVERSION  
MBPAB F 15188A 00R10 EDS CLEANUP

ENTER DATA AS NEEDED  
RCC PROD ...ELSE 'END'

<---><---><--->

?MBPAB15189A

| RCC   | FAC | PROD   | NO    | OPER                   | DESCRIPTION | SK   | OCC | T/S    | HOURS | TECH |
|-------|-----|--------|-------|------------------------|-------------|------|-----|--------|-------|------|
| MBPAB | F   | 15189A | 00B10 | REPAIR WING FLAP OTBD. | DS          | 1.00 | E   | 119.73 |       | W    |
| MBPAB | F   | 15189A | 00B20 | REPAIR FOREFLAP        | DS          | 1.00 | N   | 15.00  |       | T    |
| MBPAB | F   | 15189A | 00D10 | INSPECT FLAP           | DS          | 1.00 | N   | 1.00   |       | E    |
| MBPAB | F   | 15189A | 00J10 | MFG MISC PARTS         | FS          | 1.00 | N   | 13.00  |       | E    |
| MBPAB | F   | 15189A | 00K10 | 707 CONVERSION         | DS          | 1.00 | N   | 42.00  |       | E    |
| MBPAB | F   | 15189A | 00R10 | EDS CLEANUP            | DS          | 1.00 | N   | 3.17   |       | E    |

TA AS NEEDED  
-- 'END'

?MBPAB15154A

| RCC   | FAC | PROD   | NO    | OPER                   | DESCRIPTION | SK   | OCC | T/S    | HOURS | TECH |
|-------|-----|--------|-------|------------------------|-------------|------|-----|--------|-------|------|
| MBPAB | F   | 15154A | 00B10 | REPAIR WING FLAP OTBD. | DS          | 1.00 | E   | 119.73 |       | W    |
| MBPAB | F   | 15154A | 00B20 | REPAIR FOREFLAP        | DS          | 1.00 | N   | 15.00  |       | T    |
| MBPAB | F   | 15154A | 00D10 | INSPECT FLAP           | DS          | 1.00 | N   | 1.00   |       | E    |
| MBPAB | F   | 15154A | 00J10 | MFG MISC PARTS         | FS          | 1.00 | N   | 13.00  |       | E    |

ENTER DATA AS NEEDED  
RCC PROD ...ELSE 'END'

<---><---><--->

?MBPAB15151A

| RCC   | FAC | PROD   | NO    | OPER                   | DESCRIPTION | SK   | OCC | T/S    | HOURS | TECH |
|-------|-----|--------|-------|------------------------|-------------|------|-----|--------|-------|------|
| MBPAB | F   | 15151A | 00B10 | REPAIR WING FLAP INBD. | DS          | 1.00 | E   | 117.72 |       | W    |
| MBPAB | F   | 15151A | 00B20 | REPAIR FOREFLAP        | DS          | 1.00 | N   | 15.00  |       | T    |
| MBPAB | F   | 15151A | 00D10 | INSPECT FLAP           | DS          | 1.00 | N   | 1.00   |       | E    |
| MBPAB | F   | 15151A | 00J10 | MFG MISC PARTS         | FS          | 1.00 | N   | 23.00  |       | E    |

ENTER DATA AS NEEDED  
RCC PROD ...ELSE 'END'

<---><---><--->

?MBPAB15191A

| RCC   | FAC | PROD   | NO    | OPER                   | DESCRIPTION | SK   | OCC | T/S    | HOURS | TECH |
|-------|-----|--------|-------|------------------------|-------------|------|-----|--------|-------|------|
| MBPAB | F   | 15191A | 00B10 | REPAIR WING FLAP INBD. | DS          | 1.00 | E   | 117.72 |       | W    |
| MBPAB | F   | 15191A | 00B20 | REPAIR FOREFLAP        | DS          | 1.00 | N   | 15.00  |       | T    |
| MBPAB | F   | 15191A | 00D10 | INSPECT                | DS          | 1.00 | N   | 1.00   |       | E    |
| MBPAB | F   | 15191A | 00J10 | MFG MISC PARTS         | FS          | 1.00 | N   | 23.00  |       | E    |
| MBPAB | F   | 15191A | 00K10 | 707 CONVERSION         | DS          | 1.00 | N   | 42.00  |       | E    |
| MBPAB | F   | 15191A | 00R10 | EDS CLEANUP            | DS          | 1.00 | N   | 3.12   |       | E    |

ENTER DATA AS NEEDED  
RCC PROD ...ELSE 'END'

<---><---><--->

?MBPAB15192A

| RCC   | FAC | PROD   | NO    | OPER                   | DESCRIPTION | SK   | OCC | T/S    | HOURS | TECH |
|-------|-----|--------|-------|------------------------|-------------|------|-----|--------|-------|------|
| MBPAB | F   | 15192A | 00B10 | REPAIR WING FLAP INBD. | DS          | 1.00 | E   | 117.72 |       | W    |
| MBPAB | F   | 15192A | 00B20 | REPAIR FORE FLAP       | DS          | 1.00 | N   | 15.00  |       | E    |
| MBPAB | F   | 15192A | 00D10 | INSPECT                | DS          | 1.00 | N   | 1.00   |       | E    |
| MBPAB | F   | 15192A | 00J10 | MFG MISC PARTS         | FS          | 1.00 | N   | 23.00  |       | E    |
| MBPAB | F   | 15192A | 00K10 | 707 CONVERSION         | DS          | 1.00 | N   | 42.00  |       | E    |
| MBPAB | F   | 15192A | 00R10 | EDS CLEANUP            | DS          | 1.00 | N   | 3.12   |       | E    |

ENTER DATA AS NEEDED  
RCC PROD ...ELSE 'END'

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7MBPAB151400
RCC FAC PROD NO OPER <-----DESCRIPTION-----> SK OCC T/S HOURS TECH
MBPAB F 15140A 00B10 REPAIR FAIRING 004N FS 1.00 E 49.80 W
MBPAB F 15140A 00D10 SHAKEDOWN INSPECTION 312N FS 1.00 N .80 E
MBPAB F 15140A 00J10 MFG SUPP FAIRING 004N FS 1.00 N 7.04 E
MBPAB F 15140A 00R10 EDS CLEANUP 004N FS 1.00 N 1.05 E
51.65
ENTER DATA AS NEEDED
RCC PROD ...ELSE 'END'
<----><---->
7MBPAB15150A
RCC FAC PROD NO OPER <-----DESCRIPTION-----> SK OCC T/S HOURS TECH
MBPAB F 15150A 00B10 REPAIR NOSE COWL KC135 312E CS 1.00 E 82.09 W
MBPAB F 15150A 00D10 SHAKEDOWN INSPECTION 312N CS 1.00 N 1.14 E
MBPAB F 15150A 00J10 MFG SUPP NOSE COWL 401N FS 1.00 N 7.20 E
MBPAB F 15150A 00R10 EDS CLEANUP 401N CS 1.00 N 1.92 E
85.15
ENTER DATA AS NEEDED
RCC PROD ...ELSE 'END'
<----><---->
7MBPAB15175A
RCC FAC PROD NO OPER <-----DESCRIPTION-----> SK OCC T/S HOURS TECH
MBPAB F 15175A 00B10 REPAIR BOOM TAIL CONE FS 1.00 E 70.18 W
MBPAB F 15175A 00D10 SHAKEDOWN FS 1.00 N .67 E
MBPAB F 15175A 00J10 MFG SPLICES FS 1.00 N 1.00 E
MBPAB F 15175A 00R10 EDS CLEANUP FS 1.00 N 3.01 E
79.86
ENTER DATA AS NEEDED
RCC PROD ...ELSE 'END'
<----><---->
7MBPAB15178A
RCC FAC PROD NO OPER <-----DESCRIPTION-----> SK OCC T/S HOURS TECH
MBPAB F 15178A 00B10 REPAIR OIL COOLER FS 1.00 E 17.94 W
MBPAB F 15178A 00D10 SHAKEDOWN FS 1.00 N .56 E
MBPAB F 15178A 00J10 MFG PRTS SUPP O/Cooler FS 1.00 N 4.99 E
MBPAB F 15178A 00R10 EDS CLEANUP FS 1.00 N .47 E
18.97
ENTER DATA AS NEEDED
RCC PROD ...ELSE 'END'
<----><---->
7MBPAB15153A
RCC FAC PROD NO OPER <-----DESCRIPTION-----> SK OCC T/S HOURS TECH
MBPAB F 15153A 00B10 REPAIR WING FLAP OTBD. DS 1.00 E 119.73 W
MBPAB F 15153A 00B20 REPAIR FORD FLAP DS 1.00 N 15.00 T
MBPAB F 15153A 00D10 INSPECT FLAP DS 1.00 N 1.00 E
MBPAB F 15153A 00J10 MFG MISC PARTS FS 1.00 N 13.00 E
135.73
ENTER DATA AS NEEDED
RCC PROD ...ELSE 'END'
<----><---->
7MBPAB15188A
RCC FAC PROD NO OPER <-----DESCRIPTION-----> SK OCC T/S HOURS TECH
MBPAB F 15188A 00B10 REPAIR WING FLAP OTBD. DS 1.00 E 119.73 W
MBPAB F 15188A 00B20 REPAIR FOREFLAP DS 1.00 N 15.00 T
MBPAB F 15188A 00D10 INSPECT FLAP DS 1.00 N 1.00 E
MBPAB F 15188A 00J10 MFG MISC PARTS FS 1.00 N 13.00 E
MBPAB F 15188A 00K10 707 CONVERSION DS 1.00 N 42.00 E
MBPAB F 15188A 00R10 EDS CLEANUP DS 1.00 N 3.17 E
180.78
ENTER DATA AS NEEDED
RCC PROD ...ELSE 'END'

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?MBPAB15153A

| RCC   | FAC | PROD   | NO    | OPER             | DESCRIPTION | SK | OCC  | T/S | HOURS  | TECH |
|-------|-----|--------|-------|------------------|-------------|----|------|-----|--------|------|
| MBPAB | F   | 15153A | 00B10 | REPAIR WING FLAP | OTBD.       | DS | 1.00 | E   | 119.73 | W    |
| MBPAB | F   | 15153A | 00B20 | REPAIR FORE FLAP |             | DS | 1.00 | N   | 15.00  | T    |
| MBPAB | F   | 15153A | 00D10 | INSPECT FLAP     |             | DS | 1.00 | N   | 1.00   | E    |
| MBPAB | F   | 15153A | 00J10 | MFG MISC PARTS   |             | FS | 1.00 | N   | 13.00  | E    |

ENTER DATA AS NEEDED

RCC PROD ...ELSE 'END'

<----><---->

?MBPAB15154A

| RCC   | FAC | PROD   | NO    | OPER             | DESCRIPTION | SK | OCC  | T/S | HOURS  | TECH |
|-------|-----|--------|-------|------------------|-------------|----|------|-----|--------|------|
| MBPAB | F   | 15154A | 00B10 | REPAIR WING FLAP | OTBD.       | DS | 1.00 | E   | 119.73 | W    |
| MBPAB | F   | 15154A | 00B20 | REPAIR FOREFLAP  |             | DS | 1.00 | N   | 15.00  | T    |
| MBPAB | F   | 15154A | 00D10 | INSPECT FLAP     |             | DS | 1.00 | N   | 1.00   | E    |
| MBPAB | F   | 15154A | 00J10 | MFG MISC PARTS   |             | FS | 1.00 | N   | 13.00  | E    |

ENTER DATA AS NEEDED

RCC PROD ...ELSE 'END'

<----><---->

?MBPAB15188A

| RCC   | FAC | PROD   | NO    | OPER             | DESCRIPTION | SK | OCC  | T/S | HOURS  | TECH |
|-------|-----|--------|-------|------------------|-------------|----|------|-----|--------|------|
| MBPAB | F   | 15188A | 00B10 | REPAIR WING FLAP | OTBD.       | DS | 1.00 | E   | 119.73 | W    |
| MBPAB | F   | 15188A | 00B20 | REPAIR FOREFLAP  |             | DS | 1.00 | N   | 15.00  | T    |
| MBPAB | F   | 15188A | 00D10 | INSPECT FLAP     |             | DS | 1.00 | N   | 1.00   | E    |
| MBPAB | F   | 15188A | 00J10 | MFG MISC PARTS   |             | FS | 1.00 | N   | 13.00  | E    |
| MBPAB | F   | 15188A | 00K10 | 707 CONVERSION   |             | DS | 1.00 | N   | 42.00  | E    |
| MBPAB | F   | 15188A | 00R10 | EDS CLEANUP      |             | DS | 1.00 | N   | 3.17   | E    |

ENTER DATA AS NEEDED

RCC PROD ...ELSE 'END'

<----><---->

?MBPAB15189A

| RCC   | FAC | PROD   | NO    | OPER             | DESCRIPTION | SK | OCC  | T/S | HOURS  | TECH |
|-------|-----|--------|-------|------------------|-------------|----|------|-----|--------|------|
| MBPAB | F   | 15189A | 00B10 | REPAIR WING FLAP | OTBD.       | DS | 1.00 | E   | 119.73 | W    |
| MBPAB | F   | 15189A | 00B20 | REPAIR FOREFLAP  |             | DS | 1.00 | N   | 15.00  | T    |
| MBPAB | F   | 15189A | 00D10 | INSPECT FLAP     |             | DS | 1.00 | N   | 1.00   | E    |
| MBPAB | F   | 15189A | 00J10 | MFG MISC PARTS   |             | FS | 1.00 | N   | 13.00  | E    |
| MBPAB | F   | 15189A | 00K10 | 707 CONVERSION   |             | DS | 1.00 | N   | 42.00  | E    |
| MBPAB | F   | 15189A | 00R10 | EDS CLEANUP      |             | DS | 1.00 | N   | 3.17   | E    |

ENTER DATA AS NEEDED

RCC PROD ...ELSE 'END'

<----><---->

?15153A  
RCC FAC PROD NO OPER <-----DESCRIPTION-----> SK OCC T/S HOURS TECH

|         |        |       |                        |         |      |   |        |   |
|---------|--------|-------|------------------------|---------|------|---|--------|---|
| MBPAB F | 15153A | 00B10 | REPAIR WING FLAP OTBD. | DS      | 1.00 | E | 119.73 | W |
| MBPAB F | 15153A | 00B20 | REPAIR FORE FLAP       | DS      | 1.00 | N | 15.00  | T |
| MBPCA B | 15153A | 00C10 | STRIP & WASH           | WL      | 1.00 | N | 8.91   | E |
| MBPCB D | 15153A | 00C20 | PAINT & FINAL WASH     | B3      | 1.00 | N | 4.05   | E |
| MBPCD B | 15153A | 00C30 | UNCRATE                | CQ      | 1.00 | N | 1.53   | E |
| MBPAB F | 15153A | 00D10 | INSPECT FLAP           | DS      | 1.00 | N | 1.00   | E |
| MBPAB F | 15153A | 00J10 | MFG MISC PARTS         | FS      | 1.00 | N | 13.00  | E |
| MQCIA 1 | 15153A | CIX10 | 5-87851-145 OB FLAP    | 506N AI | 1.00 | N | .87    | E |

ENTER DATA AS NEEDED  
PROD ...ELSE 'END'

?15154A  
RCC FAC PROD NO OPER <-----DESCRIPTION-----> SK OCC T/S HOURS TECH

|         |        |       |                        |         |      |   |        |   |
|---------|--------|-------|------------------------|---------|------|---|--------|---|
| MBPAB F | 15154A | 00B10 | REPAIR WING FLAP OTBD. | DS      | 1.00 | E | 119.73 | W |
| MBPAB F | 15154A | 00B20 | REPAIR FOREFLAP        | DS      | 1.00 | N | 15.00  | T |
| MBPCA B | 15154A | 00C10 | STRIP & WASH           | WL      | 1.00 | N | 8.00   | E |
| MBPCB D | 15154A | 00C20 | PRIME & PAINT          | B3      | 1.00 | N | 3.06   | E |
| MBPCD B | 15154A | 00C30 | UNCRATE                | CQ      | 1.00 | N | 1.53   | E |
| MBPAB F | 15154A | 00D10 | INSPECT FLAP           | DS      | 1.00 | N | 1.00   | E |
| MBPAB F | 15154A | 00J10 | MFG MISC PARTS         | FS      | 1.00 | N | 13.00  | E |
| MQCIA 1 | 15154A | CIX10 | 5-87851-146 OB FLAP    | 506N AI | 1.00 | N | .87    | E |

ENTER DATA AS NEEDED  
PROD ...ELSE 'END'

?15188A  
RCC FAC PROD NO OPER <-----DESCRIPTION-----> SK OCC T/S HOURS TECH

|         |        |       |                        |         |      |   |        |   |
|---------|--------|-------|------------------------|---------|------|---|--------|---|
| MBPAB F | 15188A | 00B10 | REPAIR WING FLAP OTBD. | DS      | 1.00 | E | 119.73 | W |
| MBPAB F | 15188A | 00B20 | REPAIR FOREFLAP        | DS      | 1.00 | N | 15.00  | T |
| MBPCA B | 15188A | 00C10 | STRIP & WASH           | WL      | 1.00 | N | 8.91   | E |
| MBPCB D | 15188A | 00C20 | PAINT & FINAL WASH     | B3      | 1.00 | N | 4.05   | E |
| MBPCD B | 15188A | 00C30 | UNCRATE                | CQ      | 1.00 | N | 1.53   | E |
| MBPAB F | 15188A | 00D10 | INSPECT FLAP           | DS      | 1.00 | N | 1.00   | E |
| MBPAE A | 15188A | 00F10 | MOVE END ITEMS         | CQ      | 1.00 | N | 1.10   | E |
| MBPAB F | 15188A | 00J10 | MFG MISC PARTS         | FS      | 1.00 | N | 13.00  | E |
| MBPCB D | 15188A | 00K10 | 707 CONVERSION         | DS      | 1.00 | N | 42.00  | E |
| MBPAB F | 15188A | 00P10 | OPERATE TOOL CRIB      | B3      | 1.00 | N | .45    | E |
| MBSCM A | 15188A | 00R10 | EOS CLEANUP            | DS      | 1.00 | N | 3.17   | E |
| MBPAE A | 15188A | 00S15 | MIC POOL               | CQ      | 1.00 | N | 1.42   | E |
| MBPCA B | 15188A | 00T10 | OPERATE TOOL CRIB      | DQ      | 1.00 | N | 1.10   | E |
| MBPCA B | 15188A | 00W10 | EOS CLEANUP            | WL      | 1.00 | N | .62    | E |
| MBPCA B | 15188A | 00X10 | EOS CLEANUP            | WL      | 1.00 | N | .61    | E |
| MBPCA B | 15188A | 00Y10 | EOS CLEANUP            | B3      | 1.00 | N | .61    | E |
| MBPCD 9 | 15188A | 00Z10 | EOS CLEANUP            | CQ      | 1.00 | N | .43    | E |
| MQCIA 1 | 15188A | CIX10 | 5-87851-155 OB FLAP    | 506N AI | 1.00 | N | .87    | E |

ENTER DATA AS NEEDED  
PROD ...ELSE 'END'

COMMAND- 15025A  
 RCC FAC PROD NO OPER <-----DESCRIPTION-----> SK OCC T/S HOURS TECH  
 MBPCA 8 15025A SIDE COM LH C-135 AS 1.00 E 150.33 M  
 MBPCB D 15025A SIDE COM LH PRIME/PT WL 1.00 N 13.19 T  
 MBPCD 8 15025A UNCRATE NOSE COM L/H CQ 1.00 N 6.60 E  
 MBPCA 8 15025A UNCRATE NOSE COM L/H CQ 1.00 N .64 E  
 MBPCA 8 15025A UNCRATE NOSE COM L/H CQ 1.00 N 1.20 E  
 MBPCA 8 15025A UNCRATE NOSE COM L/H CQ 1.00 N 1.17 E  
 MBPCA 8 15025A UNCRATE NOSE COM L/H CQ 1.00 N 8.00 E  
 MBPCA 8 15025A UNCRATE NOSE COM L/H CQ 1.00 N .48 E  
 MBPCA 8 15025A UNCRATE NOSE COM L/H CQ 1.00 N 3.96 E  
 MBPCA 8 15025A UNCRATE NOSE COM L/H CQ 1.00 N 1.17 E  
 MBPCA 8 15025A UNCRATE NOSE COM L/H CQ 1.00 N .66 E  
 MBPCA 8 15025A UNCRATE NOSE COM L/H CQ 1.00 N .76 E  
 MBPCA 8 15025A UNCRATE NOSE COM L/H CQ 1.00 N .54 E  
 MBPCA 8 15025A UNCRATE NOSE COM L/H CQ 1.00 N .20 E  
 MBPCA 8 15025A UNCRATE NOSE COM L/H CQ 1.00 N .12 E  
 MBPCA 8 15025A UNCRATE NOSE COM L/H CQ 1.00 N .17 E  
 MBPCA 8 15025A UNCRATE NOSE COM L/H CQ 1.00 N 3.12 E  
 MBPCA 8 15025A UNCRATE NOSE COM L/H CQ 1.00 N .29 E  
 MBPCA 8 15025A UNCRATE NOSE COM L/H CQ 1.00 N .50 E  
 MBPCA 8 15025A UNCRATE NOSE COM L/H CQ 1.00 N .50 E

ENTER DATA AS NEEDED  
 PROD ...ELSE 'END'  
 <----->  
 715113A

RCC FAC PROD NO OPER <-----DESCRIPTION-----> SK OCC T/S HOURS TECH  
 MBPCA 8 15113A SIDE COM LH C-135 AS 1.00 E 142.74 M  
 MBPCB D 15113A SIDE COM LH PRIME/PT WL 1.00 N 12.73 T  
 MBPCD 8 15113A UNCRATE NOSE COM L/H CQ 1.00 N 6.60 E  
 MBPCA 8 15113A UNCRATE NOSE COM L/H CQ 1.00 N .70 E  
 MBPCA 8 15113A UNCRATE NOSE COM L/H CQ 1.00 N .75 E  
 MBPCA 8 15113A UNCRATE NOSE COM L/H CQ 1.00 N 1.22 E  
 MBPCA 8 15113A UNCRATE NOSE COM L/H CQ 1.00 N 1.12 E  
 MBPCA 8 15113A UNCRATE NOSE COM L/H CQ 1.00 N 8.00 E  
 MBPCA 8 15113A UNCRATE NOSE COM L/H CQ 1.00 N .45 E  
 MBPCA 8 15113A UNCRATE NOSE COM L/H CQ 1.00 N 3.76 E  
 MBPCA 8 15113A UNCRATE NOSE COM L/H CQ 1.00 N 1.69 E  
 MBPCA 8 15113A UNCRATE NOSE COM L/H CQ 1.00 N 1.12 E  
 MBPCA 8 15113A UNCRATE NOSE COM L/H CQ 1.00 N .63 E  
 MBPCA 8 15113A UNCRATE NOSE COM L/H CQ 1.00 N .73 E  
 MBPCA 8 15113A UNCRATE NOSE COM L/H CQ 1.00 N .73 E  
 MBPCA 8 15113A UNCRATE NOSE COM L/H CQ 1.00 N .51 E  
 MBPCA 8 15113A UNCRATE NOSE COM L/H CQ 1.00 N .20 E  
 MBPCA 8 15113A UNCRATE NOSE COM L/H CQ 1.00 N .12 E  
 MBPCA 8 15113A UNCRATE NOSE COM L/H CQ 1.00 N .17 E  
 MBPCA 8 15113A UNCRATE NOSE COM L/H CQ 1.00 N 3.17 E  
 MBPCA 8 15113A UNCRATE NOSE COM L/H CQ 1.00 N .73 E

ENTER DATA AS NEEDED  
 PROD ...ELSE 'END'  
 <----->  
 715119A

RCC FAC PROD NO OPER <-----DESCRIPTION-----> SK OCC T/S HOURS TECH  
 MBPCA 8 15119A REPAIR DOOR ASSY MLB FB 1.00 E 83.40 M  
 MBPCA 8 15119A REPAIR DOOR ASSY MLB FB 1.00 N 3.69 E  
 MBPCB D 15119A REPAIR DOOR ASSY MLB FB 1.00 N 10.00 E

DOBIO REPAIR  
 00 CIO WASH/STRIP  
 00 C30 PAINT  
 00 C50 REC/UNCRATE  
 00 DIO SHKDN/INSP.  
 SAYN30 ABRASIVE BLAST

(150.33/2) + 13.19 + 6.6 + 1.2 + 3.12  
 75.17+  
 99.915

| MB      | PROD   | NO    | OPER                | DESCRIPTION | SK   | OCC | T/S | HOURS | TECH |
|---------|--------|-------|---------------------|-------------|------|-----|-----|-------|------|
| MBPCB B | 15119A | 00C10 | STRIP AND WASH DOOR | 003N WL     | 1.00 |     |     | 3.59  | E    |
| MBPCB D | 15119A | 00C20 | PAINT DOOR ASSY     | J247 B3     | 1.00 | N   |     | 10.00 | E    |
| MBPCB E | 15119A | 00C50 | UNCRATE DOOR ASSY   | 003N CQ     | 1.00 | N   |     | .37   | E    |
| MBPCB F | 15119A | 00B10 | INSPECT DOOR ASSY   | 003N F8     | 1.00 | N   |     | 3.08  | E    |
| MBPCB G | 15119A | 00B10 | EDS CLEANUP         | 003N F8     | 1.00 | N   |     | 3.28  | E    |
| MBPCB H | 15119A | 00B15 | MIC POOL            | CQ          | 1.00 | N   |     | 1.47  | E    |
| MBPCB A | 15119A | 00X10 | EDS CLEANUP         | WL          | 1.00 | N   |     | .63   | E    |
| MBPCB B | 15119A | 00X10 | EDS CLEANUP         | WL          | 1.00 | N   |     | .63   | E    |
| MBPCB C | 15119A | 00Y10 | EDS CLEANUP         | B3          | 1.00 | N   |     | .63   | E    |
| MBPCD 9 | 15119A | 00Z10 | EDS CLEANUP         | CQ          | 1.00 | N   |     | .45   | E    |

ENTER DATA AS NEEDED  
PROD ...ELSE 'END'

715321A

| RCC     | FAC    | PROD  | NO                  | OPER    | DESCRIPTION | SK | OCC | T/S   | HOURS | TECH |
|---------|--------|-------|---------------------|---------|-------------|----|-----|-------|-------|------|
| MBPCA B | 15321A | 00C10 | WASH DOOR ASSY      | 111N WL | 1.00        | E  |     | 84.21 | W     |      |
| MBPCB O | 15321A | 00C20 | PAINT DOOR ASSY     | 111N B3 | 1.00        | N  |     | 4.14  | E     |      |
| MBPCB D | 15321A | 00C50 | UNCRATE DOOR ASSY   | CQ      | 1.00        | N  |     | 10.00 | E     |      |
| MBPCA A | 15321A | 00F10 | MOVE PARTS          | 111N F8 | 1.00        | N  |     | .41   | E     |      |
| MBPCB D | 15321A | 00F10 | TOOL CRIB ATTENDANT | CQ      | 1.00        | N  |     | 2.73  | E     |      |
| MBPCA A | 15321A | 00B15 | MIC POOL            | B3      | 1.00        | N  |     | .92   | E     |      |
| MBPCA B | 15321A | 00T10 | TOOL CRIB ATTENDANT | 111N F8 | 1.00        | N  |     | .37   | E     |      |
| MBPCA C | 15321A | 00W10 | TOOL CRIB ATTENDANT | CQ      | 1.00        | N  |     | 3.28  | E     |      |
| MBPCA D | 15321A | 00X10 | EDS CLEANUP         | DQ      | 1.00        | N  |     | 1.47  | E     |      |
| MBPCA E | 15321A | 00Y10 | EDS CLEANUP         | WL      | 1.00        | N  |     | .92   | E     |      |
| MBPCA F | 15321A | 00Z10 | EDS CLEANUP         | WL      | 1.00        | N  |     | .52   | E     |      |
| MBPCA G | 15321A | 00Z10 | EDS CLEANUP         | WL      | 1.00        | N  |     | .63   | E     |      |
| MBPCA H | 15321A | 00Z10 | EDS CLEANUP         | B3      | 1.00        | N  |     | .63   | E     |      |
| MBPCA I | 15321A | 00Z10 | EDS CLEANUP         | CQ      | 1.00        | N  |     | .45   | E     |      |

ENTER DATA AS NEEDED  
PROD ...ELSE 'END'

715136A

| RCC     | FAC    | PROD  | NO                    | OPER | DESCRIPTION | SK | OCC | T/S   | HOURS | TECH |
|---------|--------|-------|-----------------------|------|-------------|----|-----|-------|-------|------|
| MBPCA B | 15136A | 00C10 | STRIP/WASH AILERON    | ES   | 1.00        | N  |     | 76.34 | W     |      |
| MBPCA D | 15136A | 00C20 | PRIME & PAINT AILERON | WL   | 1.00        | N  |     | 6.00  | E     |      |
| MBPCB D | 15136A | 00C50 | UNCRATE AILERON       | B3   | 1.00        | N  |     | 2.64  | E     |      |
| MBPCA A | 15136A | 00F10 | MOVE PARTS            | CQ   | 1.00        | N  |     | 1.32  | E     |      |
| MBPCA B | 15136A | 00F10 | TOOL CRIB ATTENDANT   | ES   | 1.00        | N  |     | .90   | E     |      |
| MBPCA C | 15136A | 00F10 | TOOL CRIB ATTENDANT   | CQ   | 1.00        | N  |     | .57   | E     |      |
| MBPCA D | 15136A | 00F10 | TOOL CRIB ATTENDANT   | B3   | 1.00        | N  |     | .23   | E     |      |
| MBPCA E | 15136A | 00F10 | TOOL CRIB ATTENDANT   | ES   | 1.00        | N  |     | 1.94  | E     |      |
| MBPCA F | 15136A | 00F10 | TOOL CRIB ATTENDANT   | CQ   | 1.00        | N  |     | .87   | E     |      |
| MBPCA G | 15136A | 00F10 | TOOL CRIB ATTENDANT   | DQ   | 1.00        | N  |     | .57   | E     |      |
| MBPCA H | 15136A | 00F10 | TOOL CRIB ATTENDANT   | WL   | 1.00        | N  |     | .32   | E     |      |
| MBPCA I | 15136A | 00F10 | EDS CLEANUP           | WL   | 1.00        | N  |     | .37   | E     |      |
| MBPCA J | 15136A | 00F10 | EDS CLEANUP           | B3   | 1.00        | N  |     | .57   | E     |      |
| MBPCA K | 15136A | 00F10 | EDS CLEANUP           | WL   | 1.00        | N  |     | .26   | E     |      |
| MBPCA L | 15136A | 00F10 | EDS CLEANUP           | CQ   | 1.00        | N  |     | .930  | E     |      |

ENTER DATA AS NEEDED  
PROD ...ELSE 'END'

715137A

| RCC     | FAC    | PROD  | NO                    | OPER | DESCRIPTION | SK | OCC | T/S   | HOURS | TECH |
|---------|--------|-------|-----------------------|------|-------------|----|-----|-------|-------|------|
| MBPCA B | 15137A | 00C10 | WASH/STRIP AILERON    | ES   | 1.00        | E  |     | 76.34 | W     |      |
| MBPCA D | 15137A | 00C20 | PRIME & PAINT AILERON | WL   | 1.00        | N  |     | 6.00  | E     |      |
| MBPCB D | 15137A | 00C50 | UNCRATE AILERON       | B3   | 1.00        | N  |     | 2.64  | E     |      |
| MBPCA A | 15137A | 00F10 | MOVE PARTS            | CQ   | 1.00        | N  |     | 1.32  | E     |      |
| MBPCA B | 15137A | 00F10 | TOOL CRIB ATTENDANT   | ES   | 1.00        | N  |     | .90   | E     |      |
| MBPCA C | 15137A | 00F10 | TOOL CRIB ATTENDANT   | CQ   | 1.00        | N  |     | .57   | E     |      |
| MBPCA D | 15137A | 00F10 | TOOL CRIB ATTENDANT   | B3   | 1.00        | N  |     | .23   | E     |      |
| MBPCA E | 15137A | 00F10 | TOOL CRIB ATTENDANT   | ES   | 1.00        | N  |     | 1.94  | E     |      |

| MBF     | 15137A | 00P10 | TOOL | UNIT    | ATTEND | ES   | 1.00 | 1.94 | E |
|---------|--------|-------|------|---------|--------|------|------|------|---|
| MBPCB A | 15137A | 00B15 | EDS  | CLEANUP | ES     | 1.00 | 1.00 | 1.87 | E |
| MBPCB B | 15137A | 00B15 | MIC  | POOL    | CQ     | 1.00 | 1.00 | .87  | E |
| MBPCB C | 15137A | 00T10 | TOOL | CRIB    | DQ     | 1.00 | 1.00 | .57  | E |
| MBPCB D | 15137A | 00X10 | EDS  | CLEANUP | WL     | 1.00 | 1.00 | .32  | E |
| MBPCB E | 15137A | 00Y10 | EDS  | CLEANUP | B3     | 1.00 | 1.00 | .37  | E |
| MBPCB F | 15137A | 00Z10 | EDS  | CLEANUP | CQ     | 1.00 | 1.00 | .26  | E |
| MBPCB G | 15137A | 00Z10 | EDS  | CLEANUP | CQ     | 1.00 | 1.00 | .75  | E |
| MBPCB H | 15137A | 00Z10 | EDS  | CLEANUP | CQ     | 1.00 | 1.00 | 9.30 | E |

ENTER DATA AS NEEDED  
PROD ...ELSE 'END'

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715140A

| RCC   | FAC | PROD   | NO    | OPER    | DESCRIPTION        | SK      | OCC  | T/S | HOURS | TECH |
|-------|-----|--------|-------|---------|--------------------|---------|------|-----|-------|------|
| MBPCA | B   | 15140A | 00C10 | WASH    | STRIP NOSE COWL    | 004N FB | 1.00 | E   | 49.80 | M    |
| MBPCB | D   | 15140A | 00C20 | FINAL   | WASH/PAINT FAIRING | 004N B3 | 1.00 | N   | 1.35  | E    |
| MBPCD | B   | 15140A | 00C50 | UNCRATE | FAIRING            | 004N CQ | 1.00 | N   | .54   | E    |
| MBPAE | A   | 15140A | 00F10 | MOVE    | PARTS              | 004N FB | 1.00 | N   | .35   | E    |
| MBPCB | D   | 15140A | 00P10 | TOOL    | CRIB ATTENDANT     | 004N FB | 1.00 | N   | 7.04  | E    |
| MBPCB | F   | 15140A | 00R10 | EDS     | CLEANUP            | B3      | 1.00 | N   | .14   | E    |
| MBPCB | A   | 15140A | 00S15 | MIC     | POOL               | CQ      | 1.00 | N   | 1.05  | E    |
| MBPAE | A   | 15140A | 00T10 | TOOL    | CRIB ATTENDANT     | DQ      | 1.00 | N   | .35   | E    |
| MBPCA | B   | 15140A | 00W10 | TOOL    | CRIB ATTENDANT     | WL      | 1.00 | N   | .02   | E    |
| MBPCA | 9   | 15140A | 00X10 | EDS     | CLEANUP            | WL      | 1.00 | N   | .20   | E    |
| MBPCB | D   | 15140A | 00Y10 | EDS     | CLEANUP            | B3      | 1.00 | N   | .20   | E    |
| MBPCD | 9   | 15140A | 00Z10 | EDS     | CLEANUP            | CQ      | 1.00 | N   | .14   | E    |

ENTER DATA AS NEEDED  
PROD ...ELSE 'END'

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715150A

| RCC   | FAC | PROD   | NO    | OPER    | DESCRIPTION        | SK      | OCC  | T/S | HOURS | TECH |
|-------|-----|--------|-------|---------|--------------------|---------|------|-----|-------|------|
| MBPCA | B   | 15150A | 00C10 | WASH    | STRIP NOSE COWL    | 312E WL | 1.00 | E   | 82.09 | M    |
| MBPCB | D   | 15150A | 00C20 | FINAL   | WASH/PAINT FAIRING | 004N B3 | 1.00 | N   | 4.05  | E    |
| MBPCD | B   | 15150A | 00C50 | UNCRATE | FAIRING            | 004N CQ | 1.00 | N   | 1.25  | E    |
| MBPAE | A   | 15150A | 00F10 | MOVE    | PARTS              | 004N FB | 1.00 | N   | .70   | E    |
| MBPCB | D   | 15150A | 00P10 | TOOL    | CRIB ATTENDANT     | 004N FB | 1.00 | N   | 7.20  | E    |
| MBPCB | F   | 15150A | 00R10 | EDS     | CLEANUP            | B3      | 1.00 | N   | .28   | E    |
| MBPCB | A   | 15150A | 00S15 | MIC     | POOL               | CQ      | 1.00 | N   | 1.92  | E    |
| MBPAE | A   | 15150A | 00T10 | TOOL    | CRIB ATTENDANT     | DQ      | 1.00 | N   | .70   | E    |
| MBPCA | B   | 15150A | 00W10 | TOOL    | CRIB ATTENDANT     | WL      | 1.00 | N   | .39   | E    |
| MBPCA | 9   | 15150A | 00X10 | EDS     | CLEANUP            | WL      | 1.00 | N   | .37   | E    |
| MBPCB | D   | 15150A | 00Y10 | EDS     | CLEANUP            | B3      | 1.00 | N   | .37   | E    |
| MBPCD | 9   | 15150A | 00Z10 | EDS     | CLEANUP            | CQ      | 1.00 | N   | .26   | E    |
| MBPCA | 1   | 15150A | 00Z10 | EDS     | CLEANUP            | CQ      | 1.00 | N   | .83   | E    |

ENTER DATA AS NEEDED  
PROD ...ELSE 'END'

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715175A

| RCC   | FAC | PROD   | NO    | OPER    | DESCRIPTION        | SK      | OCC  | T/S | HOURS | TECH |
|-------|-----|--------|-------|---------|--------------------|---------|------|-----|-------|------|
| MBPCA | B   | 15175A | 00C10 | WASH    | STRIP NOSE COWL    | 004N FB | 1.00 | N   | 12.14 | E    |
| MBPCB | D   | 15175A | 00C20 | FINAL   | WASH/PAINT FAIRING | 004N B3 | 1.00 | N   | 4.00  | E    |
| MBPCD | B   | 15175A | 00C50 | UNCRATE | FAIRING            | 004N CQ | 1.00 | N   | 3.40  | E    |
| MBPCA | 1   | 15175A | 00Z10 | EDS     | CLEANUP            | CQ      | 1.00 | N   | 1.11  | E    |

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MBF 3 15175A 00C50 UNCRATE BOOM TAILCONE 0197 CQ 1.00 1.11 E
MBPAB A 15175A 00D10 SHAKEDOWN FB 1.00 .67 E
MBPAB A 15175A 00F10 MOVE PARTS CQ 1.00 .67 E
MBPAB F 15175A 00J10 MFE OIL COOLER FB 1.00 1.00 E
MBPCB D 15175A 00J10 TOOL CRIB ATTENDANT B3 1.00 .28 E
MBPAB 4 15175A 00G10 CYLINDER ASSY S-96715-5 DH 1.00 4.00 E
MBPAB A 15175A 00S15 MIC POOL CQ 1.00 1.01 E
MBPAB A 15175A 00T10 TOOL CRIB ATTENDANT CQ 1.00 1.35 E
MBPAB 3 15175A 00T30 CHECK, TEST & PURGE SYS M257 AP 1.00 .67 E
MBPCA B 15175A 00W10 TOOL CRIB ATTENDANT WL 1.00 4.00 E
MBPCA B 15175A 00X10 EDS CLEANUP WL 1.00 .38 E
MBPCB D 15175A 00Y10 EDS CLEANUP B3 1.00 .58 E
MBPCD 9 15175A 00Z10 EDS CLEANUP CQ 1.00 .58 E
MBPAB 3 15175A ACV10 S-96715-1 RMV SCREWS CM 1.00 .41 E
MBPAB 3 15175A ACV10 S-96715-1 RMV SCREWS CM 1.00 .15 E

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ENTER DATA AS NEEDED  
PROD ...ELSE 'END'

715178A

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RCC FAC PROD NO OPER <-----DESCRIPTION-----> SK OCC T/S HOURS TECH
MBPAB F 15178A 00B10 REPAIR OIL COOLER FS 1.00 E 17.94 M
MBPCA B 15178A 00C10 STRIP/WASH OIL COOLER WL 1.00 N 1.03 E
MBPCB D 15178A 00C20 FIN WASH/PAINT B3 1.00 N 1.24 E
MBPCD 8 15178A 00C50 UNCRATE CQ 1.00 N .44 E
MBPAB F 15178A 00D10 SHAKEDOWN FB 1.00 N .56 E
MBPAB F 15178A 00F10 MOVE END ITEM CQ 1.00 N .26 E
MBPCB D 15178A 00J10 MFE PRTS SUPP OIL COOLER FS 1.00 N 4.99 E
MBPAB 4 15178A 00J10 OPERATE TOOL CRIB B3 1.00 N .11 E
MBPCA A 15178A 00S15 MIC POOL FS 1.00 N .47 E
MBPCA A 15178A 00T10 OPERATE TOOL CRIB CQ 1.00 N .21 E
MBPCA B 15178A 00W10 OPERATE TOOL CRIB WL 1.00 N .26 E
DOX10 EDS CLEANUP WL 1.00 N .09 E
MBPCB D 15178A 00Y10 EDS CLEANUP CQ 1.00 N .06 E
MBPCA B 15178A SAMS ABRASIVE E
601N AW 1.00 N .44 E

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ENTER DATA AS NEEDED  
PROD ...ELSE 'END'

715178A

15178A  
RECORD NOT FOUND \15178

ENTER DATA AS NEEDED  
PROD ...ELSE 'END'

715178A

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RCC FAC PROD NO OPER <-----DESCRIPTION-----> SK OCC T/S HOURS TECH
MBPAB F 15178A 00B10 REPAIR OIL COOLER FS 1.00 E 17.94 M
MBPCA B 15178A 00C10 STRIP/WASH OIL COOLER WL 1.00 N 1.03 E
MBPCB D 15178A 00C20 FIN WASH/PAINT B3 1.00 N 1.24 E
MBPCD 8 15178A 00C50 UNCRATE CQ 1.00 N .44 E
MBPAB F 15178A 00D10 SHAKEDOWN FB 1.00 N .56 E
MBPAB F 15178A 00F10 MOVE END ITEM CQ 1.00 N .26 E
MBPCB D 15178A 00J10 MFE PRTS SUPP OIL COOLER FS 1.00 N 4.99 E
MBPCA A 15178A 00S15 MIC POOL FS 1.00 N .47 E
MBPCA A 15178A 00T10 OPERATE TOOL CRIB CQ 1.00 N .21 E
MBPCA B 15178A 00W10 OPERATE TOOL CRIB WL 1.00 N .26 E

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B 15178A OOW10 OPERATE TOOL CRIB WL 1.00 N .14 E  
 MBPCA B 15178A OOX10 EDS CLEANUP WL 1.00 N .09 E  
 MBPCB D 15178A OOV10 EDS CLEANUP B3 1.00 N .09 E  
 MBPCD 9 15178A OOW10 EDS CLEANUP CQ 1.00 N .06 E  
 MBPCA B 15178A SAW30 ABRASIVE BLAST OIL COOLER TA WL 1.00 N .40 E  
 MTPIN 6 15178A W0211 50-2458-41 COOLE 35A002 60IN AW 1.00 N .44 E

ENTER DATA AS NEEDED  
 PROD ...ELSE 'END'  
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715153A

RCC FAC PROD NO OPER <-----DESCRIPTION-----> SK OCC T/S HOURS TECH

MBPCA B 15153A OOW10 OPERATE TOOL CRIB DB 1.00 E 119.73 N  
 MBPCB D 15153A OOX10 EDS CLEANUP DB 1.00 N 15.00 E  
 MBPCD 8 15153A OOC10 STRIP & WASH WL 1.00 N 8.91 E  
 MBPCD 9 15153A OOC20 PAINT & FINAL WASH B3 1.00 N 4.05 E  
 MBPCD 8 15153A OOC50 UNCRATE CQ 1.00 N 1.53 E  
 MBPCA 1 15153A CIX10 5-87851-145 OB FLAP 506N AI 1.00 N .87 E

ENTER DATA AS NEEDED  
 PROD ...ELSE 'END'  
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715188A

RCC FAC PROD NO OPER <-----DESCRIPTION-----> SK OCC T/S HOURS TECH

MBPCA B 15188A OOC10 STRIP & WASH WL 1.00 N 8.91 E  
 MBPCB D 15188A OOC20 PAINT & FINAL WASH B3 1.00 N 4.05 E  
 MBPCD 8 15188A OOC50 UNCRATE CQ 1.00 N 1.53 E  
 MBPCA A 15188A OOF10 MOVE END ITEMS CQ 1.00 N 1.10 E  
 MBPAB F 15188A OOV10 MFG MISC PARTS FS 1.00 N 13.00 E  
 MBPAB F 15188A OOK10 707 CONVERSION DS 1.00 N 42.00 E  
 MBPCD D 15188A OOP10 OPERATE TOOL CRIB B3 1.00 N .43 E  
 MBPCA A 15188A OOS15 MIC POOL CQ 1.00 N 8.45 E  
 MBPCA A 15188A OOT10 OPERATE TOOL CRIB DQ 1.00 N 1.42 E  
 MBPCA B 15188A OOW10 OPERATE TOOL CRIB WL 1.00 N 1.10 E  
 MBPCA B 15188A OOX10 EDS CLEANUP WL 1.00 N .62 E  
 MBPCD 9 15188A OOV10 EDS CLEANUP B3 1.00 N .61 E  
 MBPCD 9 15188A OOV10 EDS CLEANUP B3 1.00 N .61 E  
 MBPCA 1 15188A CIX10 5-87851-155 OB FLAP 506N AI 1.00 N .43 E  
 MBPCA 1 15188A CIX10 5-87851-155 OB FLAP 506N AI 1.00 N .87 E

ENTER DATA AS NEEDED  
 PROD ...ELSE 'END'  
 <----->

715189A

RCC FAC PROD NO OPER <-----DESCRIPTION-----> SK OCC T/S HOURS TECH

MBPCA B 15189A OOC10 STRIP & WASH WL 1.00 E 119.73 N  
 MBPCB D 15189A OOX10 EDS CLEANUP WL 1.00 N 15.00 E  
 MBPCD 8 15189A OOC20 PAINT & FINAL WASH B3 1.00 N 8.91 E  
 MBPCD 8 15189A OOC50 UNCRATE CQ 1.00 N 1.53 E  
 MBPCA A 15189A OOF10 MOVE END ITEMS CQ 1.00 N 1.10 E  
 MBPAB F 15189A OOV10 MFG MISC PARTS FS 1.00 N 13.00 E  
 MBPAB F 15189A OOK10 707 CONVERSION DS 1.00 N 42.00 E  
 MBPCD D 15189A OOP10 OPERATE TOOL CRIB B3 1.00 N .43 E  
 MBPCA A 15189A OOS15 MIC POOL CQ 1.00 N 8.45 E  
 MBPCA A 15189A OOT10 OPERATE TOOL CRIB DQ 1.00 N 1.42 E  
 MBPCA B 15189A OOW10 OPERATE TOOL CRIB WL 1.00 N 1.10 E  
 MBPCA B 15189A OOX10 EDS CLEANUP WL 1.00 N .62 E

```

M. 15189A 00W10 OPERATE TOOL CRIB WL 1.00 N .62 E
MBPCA B 15189A 00X10 EDS CLEANUP WL 1.00 N .61 E
MBPCB D 15189A 00Y10 EDS CLEANUP B3 1.00 N .61 E
MBPCD 9 15189A 00Z10 EDS CLEANUP CQ 1.00 N .43 E
MQCIA 1 15189A CIX10 5-87851-156 OB FLAP 506N AI 1.00 N .87 E

```

ENTER DATA AS NEEDED  
PROD ...ELSE 'END'

715154A

RCC FAC PROD NO OPER <-----DESCRIPTION-----> SK OCC T/S HOURS TECH

```

MBPCA B 15154A 00C10 STRIP & WASH WL 1.00 N 118.73 E
MBPCB D 15154A 00C20 PRIME & PAINT WL 1.00 N 15.00 E
MBPCD 8 15154A 00C50 UNCRATE B3 1.00 N 8.00 E
MQCIA 1 15154A CIX10 3-87851-146 OB FLAP 506N AI 1.00 N 13.00 E

```

ENTER DATA AS NEEDED  
PROD ...ELSE 'END'

715151A

RCC FAC PROD NO OPER <-----DESCRIPTION-----> SK OCC T/S HOURS TECH

```

MBPCA B 15151A 00C10 STRIP & WASH WL 1.00 N 117.72 E
MBPCB D 15151A 00C20 PRIME & PAINT WL 1.00 N 9.90 E
MBPCD 8 15151A 00C50 UNCRATE B3 1.00 N 3.06 E
MQCIA 1 15151A CIX10 5-86892-119 FLAP IB 506N AI 1.00 N 1.00 E

```

ENTER DATA AS NEEDED  
PROD ...ELSE 'END'

715191AS

RCC FAC PROD NO OPER <-----DESCRIPTION-----> SK OCC T/S HOURS TECH

```

MBPCA B 15191A 00C10 STRIP & WASH WL 1.00 N 117.72 E
MBPCB D 15191A 00C20 PAINT & FINAL WASH WL 1.00 N 16.00 E
MBPCD 8 15191A 00C50 UNCRATE B3 1.00 N 8.91 E
MQCIA 1 15191A CIX10 5-86892-129 FLAP IB 506N AI 1.00 N 4.05 E

```

ENTER DATA AS NEEDED  
PROD ...ELSE 'END'

715192A

RCC FAC PROD NO OPER <-----DESCRIPTION-----> SK OCC T/S HOURS TECH

```

MBPCA B 15192A 00C10 STRIP & WASH WL 1.00 N 117.72 E
MBPCB D 15192A 00C20 PAINT & FINAL WASH WL 1.00 N 16.00 E
MBPCD 8 15192A 00C50 UNCRATE B3 1.00 N 8.91 E
MQCIA 1 15192A CIX10 5-86892-129 FLAP IB 506N AI 1.00 N 4.05 E

```

ENTER DATA AS NEEDED  
PROD ...ELSE 'END'

715192A

RCC FAC PROD NO OPER <-----DESCRIPTION-----> SK OCC T/S HOURS TECH

```

MBPCA B 15192A 00C10 STRIP & WASH WL 1.00 N 117.72 E
MBPCB D 15192A 00C20 PAINT & FINAL WASH WL 1.00 N 16.00 E
MBPCD 8 15192A 00C50 UNCRATE B3 1.00 N 8.91 E
MQCIA 1 15192A CIX10 5-86892-129 FLAP IB 506N AI 1.00 N 4.05 E

```

| RCC   | C | PROD   | NO    | OPER                  | DESCRIPTION | SK   | OCC  | T/S  | HOURS  | TECH |
|-------|---|--------|-------|-----------------------|-------------|------|------|------|--------|------|
| MBPAB | E | 15192A | 00810 | REPAIR WING FLAP INRD | 506N        | 1.00 | 1.00 | 1.00 | 117.72 | E    |
| MBPCA | B | 15192A | 00C10 | STRIP & WASH          | WL          | 1.00 | 1.00 | 1.00 | 8.91   | E    |
| MBPCB | D | 15192A | 00C20 | PAINT & FINAL WASH    | B3          | 1.00 | 1.00 | 1.00 | 4.05   | E    |
| MBPCD | B | 15192A | 00C50 | UNCRATE               | CQ          | 1.00 | 1.00 | 1.00 | 1.53   | E    |
| MBPAB | F | 15192A | 00D10 | INSPECT               | DS          | 1.00 | 1.00 | 1.00 | 1.00   | E    |
| MBPAE | A | 15192A | 00S10 | MOVE END ITEMS        | CQ          | 1.00 | 1.00 | 1.00 | 1.16   | E    |
| MBPCB | D | 15192A | 00P10 | OPERATE TOOL CRIB     | B3          | 1.00 | 1.00 | 1.00 | 4.7    | E    |
| MBSCM | A | 15192A | 00S15 | MIC POOL              | CQ          | 1.00 | 1.00 | 1.00 | 1.40   | E    |
| MBPAE | A | 15192A | 00T10 | OPERATE TOOL CRIB     | DQ          | 1.00 | 1.00 | 1.00 | 1.16   | E    |
| MBPCA | B | 15192A | 00M10 | OPERATE TOOL CRIB     | WL          | 1.00 | 1.00 | 1.00 | .65    | E    |
| MBPCA | B | 15192A | 00X10 | EOS CLEANUP           | WL          | 1.00 | 1.00 | 1.00 | .60    | E    |
| MBPCD | D | 15192A | 00Y10 | EOS CLEANUP           | B3          | 1.00 | 1.00 | 1.00 | .60    | E    |
| MBPCD | 9 | 15192A | 00Z10 | EOS CLEANUP           | CQ          | 1.00 | 1.00 | 1.00 | .43    | E    |
| MQCIA | 1 | 15192A | CIX10 | 5-86892-130 FLAP IB   | 506N        | 1.00 | 1.00 | 1.00 | .87    | E    |

ENTER DATA AS NEEDED  
PROD ...ELSE 'END'

715152A

| RCC   | FAC | PROD   | NO    | OPER                   | DESCRIPTION | SK   | OCC  | T/S  | HOURS  | TECH |
|-------|-----|--------|-------|------------------------|-------------|------|------|------|--------|------|
| MBPAB | E   | 15192A | 00810 | REPAIR WING FLAP INRD  | 506N        | 1.00 | 1.00 | 1.00 | 117.72 | E    |
| MBPCA | B   | 15192A | 00C10 | STRIP & WASH           | WL          | 1.00 | 1.00 | 1.00 | 9.90   | T    |
| MBPCB | D   | 15192A | 00C20 | PRIME & PAINT          | B3          | 1.00 | 1.00 | 1.00 | 3.06   | E    |
| MBPCD | B   | 15192A | 00C50 | UNCRATE                | CQ          | 1.00 | 1.00 | 1.00 | 1.53   | E    |
| MBPAB | F   | 15192A | 00D10 | INSPECT FLAP           | DS          | 1.00 | 1.00 | 1.00 | .51    | E    |
| MQCIA | 1   | 15192A | CIX10 | 5-86892-120 RH IB FLAP | 506N        | 1.00 | 1.00 | 1.00 | .87    | E    |

ENTER DATA AS NEEDED  
PROD ...ELSE 'END'

715236A

| RCC   | FAC | PROD   | NO    | OPER                            | DESCRIPTION | SK   | OCC  | T/S  | HOURS  | TECH |
|-------|-----|--------|-------|---------------------------------|-------------|------|------|------|--------|------|
| MBPAB | E   | 15236A | 00810 | REPAIR ACT. CANNING             | 506N        | 1.00 | 1.00 | 1.00 | 117.09 | E    |
| MBPCA | B   | 15236A | 00C10 | STRIP WASH/ANODIZE              | WL          | 1.00 | 1.00 | 1.00 | 9.00   | E    |
| MBPCB | D   | 15236A | 00C20 | FIN WASH/PNT SLEEVE             | B3          | 1.00 | 1.00 | 1.00 | 4.25   | E    |
| MBPCD | B   | 15236A | 00C50 | UNCRATE SLEEVE                  | CQ          | 1.00 | 1.00 | 1.00 | 2.00   | E    |
| MBPAB | F   | 15236A | 00R10 | EOS CLEANUP                     | FS          | 1.00 | 1.00 | 1.00 | 4.50   | E    |
| MBSCM | A   | 15236A | 00S15 | MIC POOL                        | CQ          | 1.00 | 1.00 | 1.00 | 2.02   | E    |
| MBPCA | B   | 15236A | 00X10 | EOS CLEANUP                     | WL          | 1.00 | 1.00 | 1.00 | .87    | E    |
| MBPCB | D   | 15236A | 00Y10 | EOS CLEANUP                     | B3          | 1.00 | 1.00 | 1.00 | .61    | E    |
| MBPCD | 9   | 15236A | 00Z10 | EOS CLEANUP                     | CQ          | 1.00 | 1.00 | 1.00 | .06    | E    |
| MTPIA | C   | 15236A | ACZ10 | 65-10526 LINK ASSY              | 35A045      | 1.00 | 1.00 | 1.00 | 3.00   | E    |
| MQCIA | 1   | 15236A | CIX10 | 65-10505-269 BLEEVE AY          | AI          | 1.00 | 1.00 | 1.00 | 4.68   | E    |
| MBPCA | B   | 15236A | SAW30 | 65-10505-269 SLV ASSY           | 004N        | 1.00 | 1.00 | 1.00 | .13    | E    |
| MTPTT | 1   | 15236A | TCZ10 | 65-10526 LINK ASSY              | 35A045      | 1.00 | 1.00 | 1.00 | 1.50   | E    |
| MTPIW | 6   | 15236A | WCZ10 | 65-10505-269 135 AFT THR SLE AW | AW          | 1.00 | 1.00 | 1.00 | .63    | E    |
| MTPIW | 6   | 15236A | WCZ11 | 65-10505-5 HAT RING SECTION     | AW          | 1.00 | 1.00 | 1.00 | .63    | E    |
| MTPIW | 6   | 15236A | WCZ12 | 65-10505-122 HAT RING SECT      | AW          | 1.00 | 1.00 | 1.00 | .63    | E    |

ENTER DATA AS NEEDED  
PROD ...ELSE 'END'

715237A

| RCC   | FAC | PROD   | NO    | OPER               | DESCRIPTION | SK   | OCC  | T/S  | HOURS | TECH |
|-------|-----|--------|-------|--------------------|-------------|------|------|------|-------|------|
| MBPAB | E   | 15237A | 00810 | REPAIR EMBLING ACT | 506N        | 1.00 | 1.00 | 1.00 |       |      |

| PROJ   | FAC | PROD  | NO | OPER  | <-----DESCRIPTION-----> | SK | OCC  | T/S | HOURS | TECH |
|--------|-----|-------|----|-------|-------------------------|----|------|-----|-------|------|
| 15126A | F   | MBPAB | F  | 00B10 | REPAIR DOOR ASSY MLG    | FS | 1.00 | E   | 82.59 | W    |
| 15126A | B   | MBPCA | B  | 00C10 | STRIP AND WASH DOOR     | WL | 1.00 | N   | 3.45  | E    |
| 15126A | D   | MBPCD | D  | 00C20 | PAINT DOOR ASSY         | B3 | 1.00 | N   | 10.00 | E    |
| 15126A | B   | MBPCD | B  | 00C50 | UNCRATE DOOR ASSY       | CQ | 1.00 | N   | .35   | E    |
| 15126A | F   | MBPBF | F  | 00D10 | INSPECT DOOR ASSY       | FS | 1.00 | N   | 2.88  | E    |
| 15126A | A   | MBPAE | A  | 00F10 | MUOVE PARTS             | CQ | 1.00 | N   | .92   | E    |
| 15126A | D   | MBPCD | D  | 00P10 | TOOL CRIB ATTENDANT     | B3 | 1.00 | N   | .37   | E    |
| 15126A | F   | MBPBF | F  | 00R10 | EDS CLEANUP             | FS | 1.00 | N   | 3.26  | E    |
| 15126A | A   | MBSCM | A  | 00S15 | MIC POOL                | CQ | 1.00 | N   | 1.47  | E    |
| 15126A | A   | MBPAE | A  | 00T10 | TOOL CRIB ATTENDANT     | DQ | 1.00 | N   | .92   | E    |
| 15126A | B   | MBPCA | B  | 00W10 | TOOL CRIB ATTENDANT     | WL | 1.00 | N   | .52   | E    |
| 15126A | D   | MBPCD | D  | 00V10 | TOOLS CLEANING          | WL | 1.00 | N   | .47   | E    |

| MBP-CA B | 15126A | 00X10 | EDS | CLEANUP | WL | 1.00 | N | 1.00 | 92.30 | W |
|----------|--------|-------|-----|---------|----|------|---|------|-------|---|
| MBP-CB D | 15126A | 00Y10 | EDS | CLEANUP | B3 | 1.00 | N | 1.00 | 3.30  | E |
| MBP-CD 9 | 15126A | 00Z10 | EDS | CLEANUP | CQ | 1.00 | N | 1.00 | 10.00 | E |
|          |        |       |     |         |    |      |   |      | .33   | E |
|          |        |       |     |         |    |      |   |      | 2.75  | E |
|          |        |       |     |         |    |      |   |      | .92   | E |
|          |        |       |     |         |    |      |   |      | .37   | E |
|          |        |       |     |         |    |      |   |      | 3.26  | E |
|          |        |       |     |         |    |      |   |      | 1.47  | E |
|          |        |       |     |         |    |      |   |      | .92   | E |
|          |        |       |     |         |    |      |   |      | .63   | E |
|          |        |       |     |         |    |      |   |      | .63   | E |
|          |        |       |     |         |    |      |   |      | .45   | E |

ENTER DATA AS NEEDED  
 PROD ...ELSE 'END'  
 <----->  
 715300A  
 RCC FAC PROD NO OPER <-----DESCRIPTION-----> SK

| MBPAB F | 15300A | 00R10 | REPAIR  | DOOR    | ASSY      | M.L. | FS      |
|---------|--------|-------|---------|---------|-----------|------|---------|
| MBPCA B | 15300A | 00C10 | STRIP   | & WASH  | DOOR      | ASSY | A340 WL |
| MBPCB D | 15300A | 00C20 | PAINT   | DOOR    | ASSY      |      | A340 B3 |
| MBPCD 8 | 15300A | 00C50 | UNCRATE | DOOR    | ASSY      |      | A340 CQ |
| MBPAB F | 15300A | 00D10 | INSPECT | DOOR    | ASSY      |      | FS      |
| MBPAE A | 15300A | 00F10 | MOVE    | PARTS   |           |      | CQ      |
| MBPCB D | 15300A | 00F10 | TOOL    | CRIB    | ATTENDANT |      | B3      |
| MBPAB F | 15300A | 00R10 | EDS     | CLEANUP |           |      | FS      |
| MBSCM A | 15300A | 00S15 | MIC     | POOL    |           |      | CQ      |
| MBPAE A | 15300A | 00T10 | TOOL    | CRIB    | ATTENDANT |      | DQ      |
| MBPCA B | 15300A | 00W10 | TOOL    | CRIB    | ATTENDANT |      | WL      |
| MBPCA B | 15300A | 00X10 | EDS     | CLEANUP |           |      | WL      |
| MBPCB D | 15300A | 00Y10 | EDS     | CLEANUP |           |      | B3      |
| MBPCD 9 | 15300A | 00Z10 | EDS     | CLEANUP |           |      | CQ      |

ENTER DATA AS NEEDED  
 PROD ...ELSE 'END'  
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?MBPAB15151A
RCC FAC PROD NO OPER <-----DESCRIPTION-----> SK OCC T/S HOURS TECH

MBPAB F 15151A 00B10 REPAIR WING FLAP INBD. DS 1.00 E 117.72 W
MBPAB F 15151A 00B20 REPAIR FOREFLAP DS 1.00 N 15.00 T
MBPAB F 15151A 00D10 INSPECT FLAP DS 1.00 N 1.00 E
MBPAB F 15151A 00J10 MFG MISC PARTS FS 1.00 N 23.00 E

```

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ENTER DATA AS NEEDED
RCC PROD ...ELSE 'END'
<---><--->

```

```

?MBPAB15152A
RCC FAC PROD NO OPER <-----DESCRIPTION-----> SK OCC T/S HOURS TECH

MBPAB F 15152A 00B10 REPAIR WING FLAP INBD. DS 1.00 E 117.72 W
MBPAB F 15152A 00B20 REPAIR FOREFLAP DS 1.00 N 16.50 T
MBPAB F 15152A 00D10 INSPECT FLAP DS 1.00 N .51 E
MBPAB F 15152A 00J10 MFG MISC PARTS FS 1.00 N 23.00 E

```

```

ENTER DATA AS NEEDED
RCC PROD ...ELSE 'END'
<---><--->

```

```

?MBPAB15191A
RCC FAC PROD NO OPER <-----DESCRIPTION-----> SK OCC T/S HOURS TECH

MBPAB F 15191A 00B10 REPAIR WING FLAP INBD. DS 1.00 E 117.72 W
MBPAB F 15191A 00B20 REPAIR FOREFLAP DS 1.00 N 15.00 T
MBPAB F 15191A 00D10 INSPECT DS 1.00 N 1.00 E
MBPAB F 15191A 00J10 MFG MISC PARTS FS 1.00 N 23.00 E
MBPAB F 15191A 00K10 707 CONVERSION DS 1.00 N 42.00 E
MBPAB F 15191A 00R10 EOS CLEANUP DS 1.00 N 3.12 E

```

```

ENTER DATA AS NEEDED
RCC PROD ...ELSE 'END'
<---><--->

```

```

?MBPAB15192A
RCC FAC PROD NO OPER <-----DESCRIPTION-----> SK OCC T/S HOURS TECH

MBPAB F 15192A 00B10 REPAIR WING FLAP INBD. DS 1.00 E 117.72 W
MBPAB F 15192A 00B20 REPAIR FORE FLAP DS 1.00 N 15.00 E
MBPAB F 15192A 00D10 INSPECT DS 1.00 N 1.00 E
MBPAB F 15192A 00J10 MFG MISC PARTS FS 1.00 N 23.00 E
MBPAB F 15192A 00K10 707 CONVERSION DS 1.00 N 42.00 E
MBPAB F 15192A 00R10 EOS CLEANUP DS 1.00 N 3.12 E

```

```

ENTER DATA AS NEEDED
RCC PROD ...ELSE 'END'
<---><--->

```

AS TO BE MADE

| <u>U.S. #</u> | <u>IL #</u> | <u>DATE</u> | <u>U.S. #</u> | <u>IL #</u> | <u>DATE</u> |
|---------------|-------------|-------------|---------------|-------------|-------------|
| 15132M        | 15136M      | 88205       | 15136A        | 15132A      | 88055       |
| 15132N        | 15136A      | 88205       | 15132A        | 15137A      | 88055       |
| 15154A        | 15158A      | 88059       | 15154A        | "           | " (88059)   |

only one more experiment  
on the 7<sup>th</sup>

(Since you, ~~MAFAB~~ are embedded in the  
mission and in MAF by nature, it wasn't  
then after everything that was said, since  
there's no way to retrieve or edit info. I can  
only let you know so that you will be  
able to ~~retrieve the file also~~. Hope  
this doesn't cause a problem. ) Give

Found in NEQ. to use ORGANIZATION: 1

—DOPE my LAST DAY, WORK TO THE ORIGINAL  
DISK. BYE, PEEGGY

342, 2866y

DISK #4

| ACC. |   | WCD #  | PCN #  | WCD DATE | TOTAL |
|------|---|--------|--------|----------|-------|
| 1    | — | 15025A | 15025A | 88054    | 1     |
| 1    | — | 15113A | 15113A | "        | 1     |
| 39   | — | 15119A | 15119A | 88074    | 19    |
|      |   | "      | "      | 88072    | 1     |
|      |   | "      | 15321A | 88074    | 19    |
| 2    | — | 15126A | 15126A | "        | 1     |
|      |   | "      | 15300A | "        | 1     |
| 28   | — | 15136A | 15136A | 87223    | 1     |
|      |   | "      | "      | 88205    | 14    |
|      |   | "      | "      | 88055    | 2     |
|      |   | "      | 15137A | "        | 1     |
|      |   | "      | "      | 88205    | 10    |
|      |   | "      | "      | 87223    | 1     |
| 1    | — | 15137A | 15137A | 88205    | 1     |
| 1    | — | 15140A | 15140A | 88067    | 1     |
| 1    | — | 15150A | 15150A | 88054    | 1     |
| 1    | — | 15151A | 15191A | 87198    | 1     |
| 2    | — | 15153A | 15188A | 88055    | 1     |
|      |   | "      | 15189A | "        | 1     |
| 3    | — | 15154A | "      | 87059    | 1     |
|      |   | "      | 15188A | 88055    | 2     |
| 23   | — | 15175A | 15175A | 88069    | 19    |
|      |   | "      | "      | 88203    | 4     |
| 1    | — | 15178A | 15178A | 88054    | 1     |
| 11   | — | 15222A | 15249A | 87258    | 1     |
|      |   | "      | 15249A | 88055    | 5     |
|      |   | "      | 15250A | 87258    | 1     |
|      |   | "      | "      | 88055    | 4     |
| 1    | — | 15244A | 15244A | 88205    | 1     |
| 1    | — | 15245A | 15245A | 88055    | 1     |
| 11   | — | 15249A | 15249A | "        | 4     |
|      |   | "      | 15250A | "        | 7     |
| 33   | — | 15178A | 15178A | 88054    |       |
| 25   | — | 15151A | 15192A |          |       |
| 43   | — | 15152A | 15191A |          | 23    |
|      |   | "      | 15192A |          | 20    |



DISK 1

OC15113A.DAT 15113A 88054

OC MABPAB.DAT 15113A 88054  
15119A 88074

OCMBPAB.DAT 15236A 88054  
15025A 88054

OCMBPBA.DAT 15025A 88054

DISK 2

OC MABPAB.DAT 15113A 88054  
15119A 88074

DISK 3

OC MABPAB.DAT 15119A 88074

4-19-88

9999

| <u>WCD</u> | <u>PCN</u> | <u>LAST OP.</u> | <u>DATE CAMP</u> |
|------------|------------|-----------------|------------------|
| 15151A     | 15192A     | 06-23-88        | 06-23-88         |
| "          | "          | 06-28           | 06-28            |
| "          | "          | 08-10           | 08-10            |
| "          | "          | 08-17           | 08-16 → 17 or 18 |
| "          | "          | 08-22           | 08-22            |
| "          | "          | "               | "                |
| "          | "          | 08-24           | 08-24            |
| "          | "          | 08-25           | 08-24            |
| "          | "          | 08-26           | 08-26            |
| "          | "          | 09-07           | 09-06            |
| "          | "          | 09-13           | 09-13            |
| "          | "          | 09-17           | 09-17            |
| "          | "          | 09-21           | 09-21            |
| "          | "          | 09-27           | 09-28            |
| "          | "          | "               | 09-27            |
| 15152A     | 15192A     | 06-23-88        | 06-23-88         |
| "          | "          | 06-28           | 06-28            |
| "          | "          | 08-10           |                  |
| "          | "          | 08-17           | 08-17            |
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| "          | "          | "               | "                |
| "          | "          | 08-24           | 08-24            |
| "          | "          | 08-26           | 08-26            |
| "          | "          | 09-06           | 09-07            |
| "          | "          | 09-13           | 09-13            |
| "          | "          | 09-17           | 09-17            |
| "          | "          | 09-21           | 09-21            |
| "          | "          | 09-27           | 09-29            |
| "          | "          | 09-27           | "                |
| 15152A     | 15191A     | 06-28-88        | 06-28-88         |
| "          | "          | 08-10           |                  |
| "          | "          | 08-16           | 08-17            |
| "          | "          | 08-22           | 08-22            |
| "          | "          | "               | "                |
| "          | "          | 08-24           | 08-24            |
| "          | "          | "               | 08-25            |
| "          | "          | 08-26           | 08-26            |

| <u>WCD</u> | <u>ACN</u> | <u>LAST DP</u> | <u>DATE COMP</u> |
|------------|------------|----------------|------------------|
| 15152A     | 15192A     | 09.06.88       | 09.07.88         |
| "          | "          | 09.13          | 09.13            |
| "          | "          | 09.21          | 09.21            |
| "          | "          | 09.27          | 09.29            |
| "          | "          | 09.29          | 09.29            |

4-18-88

|          |        |          |          |
|----------|--------|----------|----------|
| 15151A   | 15192A | 07.18.88 | 07.18.88 |
| "        | "      | 07.25    | 07.26    |
| "        | "      | 01.11.89 | 01.11.89 |
| "        | "      | 01.30    | 01.30    |
| "        | "      | 01.31    | 01.31    |
| "        | "      | 02.09    | 02.09    |
| "        | "      | 02.15    | 02.16    |
| "        | "      | 03.13    | 03.14    |
| "        | "      | 03.24    | 03.27    |
| "        | "      | 04.04    | 03.30    |
| - 15152A | 15151A | 07.18.88 | 07.18.88 |
| "        | "      | 07.25    | 07.26    |
| "        | "      | 01.11.89 | 01.11.89 |
| "        | "      | 01.30    | 01.30    |
| "        | "      | 01.31    |          |
| "        | "      | 02.01    |          |
| "        | "      | 02.09    |          |
| "        | "      | 02.16    |          |
| "        | "      | 03.24    |          |
| "        | "      | 04.04    |          |
| 15152A   | 15152A | 07.18.88 | 07.18.88 |
| "        | "      | 07.25    | 07.26    |
| "        | "      | 01.11.89 |          |
| "        | "      | 01.30.   | 01.30.89 |
| "        | "      | 01.31    |          |
| "        | "      | 02.09    |          |
| "        | "      | 03.24    |          |

| <u>WCD</u> | <u>PCN</u> | <u>LAST OP</u> | <u>DATE CAMP</u>                  |
|------------|------------|----------------|-----------------------------------|
| 15126A     | 15126A     | 10-19-88       | 10-20-88                          |
| "          | "          | 10-25          | 10-26                             |
| "          | "          | 10-28          | 10-28                             |
| "          | "          | 10-02          | 11-03                             |
| "          | "          | 11-07          | 11-07                             |
| "          | "          | 11-14          | 11-14                             |
| "          | "          | 11-18          | 11-18                             |
| "          | "          | 11-22          | 11-25                             |
| "          | "          | 11-28          | 11-28                             |
| "          | "          | 11-28          | 11-28                             |
| "          | "          | 11-30          | 11-29                             |
| "          | "          | 12-05          | 12-05                             |
| "          | "          | 12-07          | 12-07                             |
| "          | "          | 12-09          | 12-09                             |
| "          | "          | 12-13          | 12-13                             |
| "          | "          | 12-15          | 12-15                             |
| "          | "          | 12-28          | 12-28                             |
| "          | "          | 12-29          | 12-29                             |
| "          | "          | 12-30          | 12-30 (PAPERWORK LOST - NO DATES) |
| 15126A     | 15300A     | 10-03-88       | 10-07-88 (CONDEMNED)              |
| "          | "          | 10-19          | 10-20                             |
| "          | "          | 10-25          | 10-26                             |
| "          | "          | 10-28          | 10-28                             |
| "          | "          | 10-02          | 11-03                             |
| "          | "          | 11-07          | 11-07                             |
| "          | "          | 11-14          | 11-14                             |
| "          | "          | 11-18          | 11-18                             |
| "          | "          | 11-22          | 11-25                             |
| "          | "          | 11-28          | 11-28                             |
| "          | "          | 11-28          | 11-28                             |
| "          | "          | 11-30          | 11-29                             |
| "          | "          | 12-05          | 12-05                             |
| "          | "          | 12-07          | 12-07                             |
| "          | "          | 12-09          | 12-09                             |
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| "          | "          | 12-28          | 12-28                             |
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| "          | "          | 12-30          | 12-30                             |

| <u>WCA</u> | <u>PCN</u> | <u>LAST OP</u> | <u>DATE COMP</u> |
|------------|------------|----------------|------------------|
| 15140A     | 15140A     | 12-01-88       | 12-01-88         |
| "          | "          | 12-05          | 12-05            |
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| "          | "          | 12-09          | 12-09            |
| "          | "          | 12-13          | 12-13            |
| "          | "          | "              | "                |
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| "          | "          | "              | "                |
| "          | "          | 12-16          | 12-16            |
| "          | "          | 12-19          | 12-20            |
| "          | "          | 12-22          | 12-23            |
| "          | "          | 12-23          | 12-23            |
| "          | "          | "              | "                |
| "          | "          | 12-28          | 12-29            |
| "          | "          | 12-28          | "                |
| "          | "          | "              | 12-28            |
| "          | "          | 12-16          | 12-15            |
| "          | "          | "              | "                |
| "          | "          | "              | "                |
| 15025A     | 15025A     | 09-21          | 09-21            |
| "          | "          | 09-27          | 09-27            |
| "          | "          | 09-27          | 09-27            |
| "          | "          | 09-27          | 09-27            |
| "          | "          | 09-27          | 09-29            |
| "          | "          | 09-30          | 09-30            |
| "          | "          | 10-03          | 10-03            |
| "          | "          | "              | "                |
| "          | "          | "              | "                |
| "          | "          | "              | "                |
| "          | "          | "              | "                |
| "          | "          | 01-12-89       | 01-12-89         |
| "          | "          | 01-18-         | 01-18            |
| "          | "          | "              | "                |
| "          | "          | 01-23          | 01-23            |
| "          | "          | 01-26          | 01-26            |

(PAPERWORK LOST - NO DATES)

| <u>WCD</u> | <u>PCN</u> | <u>LAST OP</u> | <u>DATE COMP</u>  |
|------------|------------|----------------|-------------------|
| 15025A     | 15025A     | N-30-89        | 01-27-89          |
| "          | "          | 02-07          | 02-07             |
| "          | "          | 02-09          | 02-09             |
| "          | "          | 02-10          | 02-17             |
| "          | "          | "              | "                 |
| "          | "          | 03-01          | 02-27             |
| "          | "          | 02-27          | 03-01             |
| "          | "          | 02-27          | 03-01             |
| "          | "          | 03-03          | 03-03             |
| "          | "          | 03-13          | 03-14             |
| "          | "          | "              | "                 |
| "          | "          | 03-20          | 03-20             |
| "          | "          | 03-24          | 03-24             |
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| 15150A     | 15150A     | 09-09-88       | 09-09-88          |
| "          | "          | 09-13          | 09-13             |
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| "          | "          | 09-30          | 09-30             |
| "          | "          | 01-11-89       | 01-12-89          |
| "          | "          | 01-18          | 01-19             |
| "          | "          | "              | 01-30 (CONDEMNED) |
| "          | "          | 01-31          | 01-31             |
| "          | "          | 02-03          | 02-03             |
| "          | "          | "              | "                 |
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| "          | "          | 02-21          | 02-21             |
| "          | "          | 02-23          | 02-23             |
| "          | "          | 03-09          | 03-09             |
| "          | "          | 03-15          | 03-15             |
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| "          | "          | "              | "                 |
| "          | "          | 03-22          | 03-22             |
| "          | "          | 03-27          | 03-27             |
| "          | "          | "              | "                 |

| <u>WCD</u> | <u>PCN</u> | <u>LAST OP</u> | <u>DATE COMP</u>     |
|------------|------------|----------------|----------------------|
| 15150A     | 15150A     | 03-28-89       | 03-27-89             |
| "          | "          | "              | "                    |
| "          | "          | 03-29-         | 03-29                |
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| "          | "          | "              | "                    |
| "          | "          | 03-30          | 03-30                |
| "          | "          | "              | 03-30                |
| "          | "          | 03-29          | "                    |
| 15113A     | 15113A     |                | 02-21-89 (CONDEMNED) |
| "          | "          | 09-12-88       | 09-12-88             |
| "          | "          | 09-21-         | 09-21                |
| "          | "          | 09-22          | 09-22                |
| "          | "          | 09-29          | 09-29                |
| "          | "          | 10-01          | 10-03                |
| "          | "          | 01-13-89       | 01-12-89             |
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| "          | "          | 01-20          | 01-20                |
| "          | "          | 01-23          | 01-23                |
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| "          | "          | 02-07          | 02-07                |
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| "          | "          | 02-08          | 02-08                |
| "          | "          | 02-09          | 02-09                |
| "          | "          | 02-21          | 02-21                |
| "          | "          | 03-01          | 03-01                |
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| "          | "          | "              | "                    |
| "          | "          | 03-16          | 03-16                |
| "          | "          | 03-21          | 03-21                |
| "          | "          | "              | "                    |
| "          | "          | 03-24          | 03-24                |
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| "          | "          | 03-27          | 03-27                |

| <u>WCD</u> | <u>PCN</u> | <u>LAST OP</u> | <u>DATE CAMP</u> |
|------------|------------|----------------|------------------|
| 15113A     | 15113A     | 03-31-89       | 03-30-89         |
| "          | "          | "              | "                |
| 15313A     |            | 01-19-89       | 01-19-89         |
| 15236A     |            | 12-20-88       | 12-20-88         |
| "          |            | "              | 12-20            |
| "          | 15236A     | 01-20-89       | 01-20-89         |
| "          |            | 02-02-89       | 02-02-89         |
| "          |            | 02-22          | 02-22            |
| "          | "          | 02-24          | 03-01-           |
| "          |            | 03-01          | "                |
| "          |            | 03-02          | 03-02            |
| "          |            | 03-10          | 03-13            |
| "          |            | 03-14          | 03-14            |
| "          |            | 03-22          | 03-22            |
| "          |            | 03-30          | 03-30            |
| 15178A     | 15178A     | 10-11-88       | 10-11-88         |
| "          | "          | "              | "                |
| "          | "          | 10-21-88       | 10-19-88         |
| "          | "          | 10-19-         | "                |
| "          | "          | "              | "                |
| "          | "          | 11-14          | 11-14            |
| "          | "          | "              | 11-14            |
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| "          | "          | 11-15          | 11-15            |
| "          | "          | "              | "                |
| "          | "          | 11-29          | 11-29            |
| "          | "          | "              | "                |
| "          | "          | "              | "                |
| "          | "          | 12-13          | 12-13            |
| "          | "          | 12-15          | 12-15            |
| "          | "          | 12-16          | 12-16            |
| "          | "          | "              | "                |
| "          | "          | 12-22          | 12-22            |
| "          | "          | 12-23          | 12-23            |
| "          | "          | 12-28          | 12-27            |
| "          | "          | 01-06-89       | 01-06-89         |
| "          | "          | "              | "                |
| "          | "          | 01-09          | 01-09-           |



| <u>WCD</u> | <u>PCN</u> | <u>LAST OP</u> | <u>DATE COMP</u>       |
|------------|------------|----------------|------------------------|
| 15178A     | 15178A     | 01-09-89       | 01-09-89               |
| "          | "          | 01-11-         | 01-11-                 |
| "          | "          | 01-19          | 01-19                  |
| "          | "          | 01-20          | 01-24                  |
| "          | "          | 02-03          | 02-03                  |
| "          | "          | 02-13          | 02-15                  |
| "          | "          | 02-21          | 02-21                  |
| "          | "          | "              | "                      |
| "          | "          | 02-22          | 02-22                  |
| "          | "          | 03-03          | 03-03                  |
| 15237A     | 15237A     | 12-28-88       | 12-27-88               |
| "          | "          | 12-01          | 12-01 (PAPERWORK LOST) |

TOTALS -

|             |                |      |
|-------------|----------------|------|
| 15178A - 33 |                |      |
| 15237A - 2  |                | → 4  |
| 15315A - 1  |                |      |
| 15236A - 12 |                | → 6  |
| 15025A - 31 | (1 CONDEMNED)  | → 27 |
| 15150A - 31 | (1 CONDEMNED)  | → 35 |
| 15113A - 31 | (1 CONDEMNED)  | → 53 |
| 15124A - 38 | (2 - NO DATES) | → 35 |
| 15140A - 21 | (3 - NO DATES) | → 18 |
| 15151A - 23 |                |      |
| 15152A - 44 |                |      |
| 15119A -    |                | → 25 |

178  
151  
152 ✓

237  
236 }

113. ✓

+ 9.

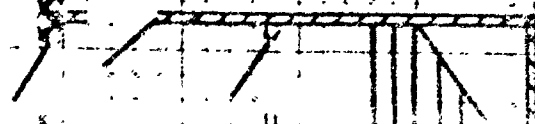
OC -- MABPAB

| PCN        | WCD     |
|------------|---------|
| *****      | *****   |
| 15025A     | 15025A  |
| 15113A     | 15113A  |
| 15119A     | 15119A  |
| 15126A     | 15126A  |
| 15136A     | 15136A  |
| 15137A     | 15136AA |
| 15140A     | 15140A  |
| 15150A     | 15150A  |
| 15175A     | 15175A  |
| 15178A     | 15178A  |
| 15188A     | 15153A  |
| 15188ASUB1 | 15154A  |
| 15189ASUB1 | 15154AA |
| 15189A     | 15153AA |
| 15191A     | 15151A  |
| 15191ASUB1 | 15152A  |
| 15192A     | 15151AA |
| 15192ASUB1 | 15152AA |
| 15236A     | 15236A  |
| 15237ASUB1 | 15236B  |
| 15237A     | 15237A  |
| 15249A     | 15249A  |
| 15250A     | 15249AA |
| 15300A     | 15126AA |
| 15321A     | 15119AA |

1

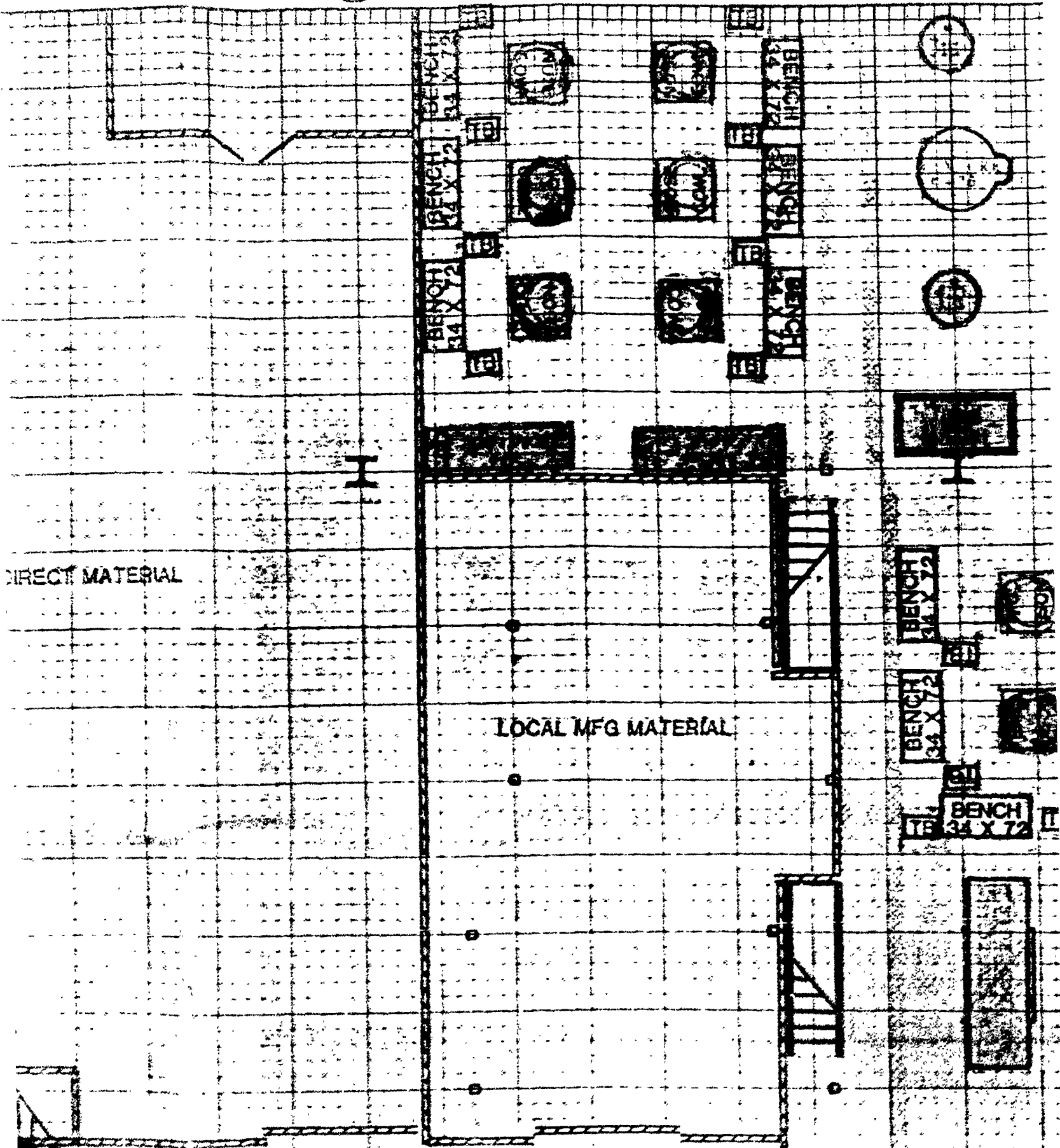
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DIRECT MA



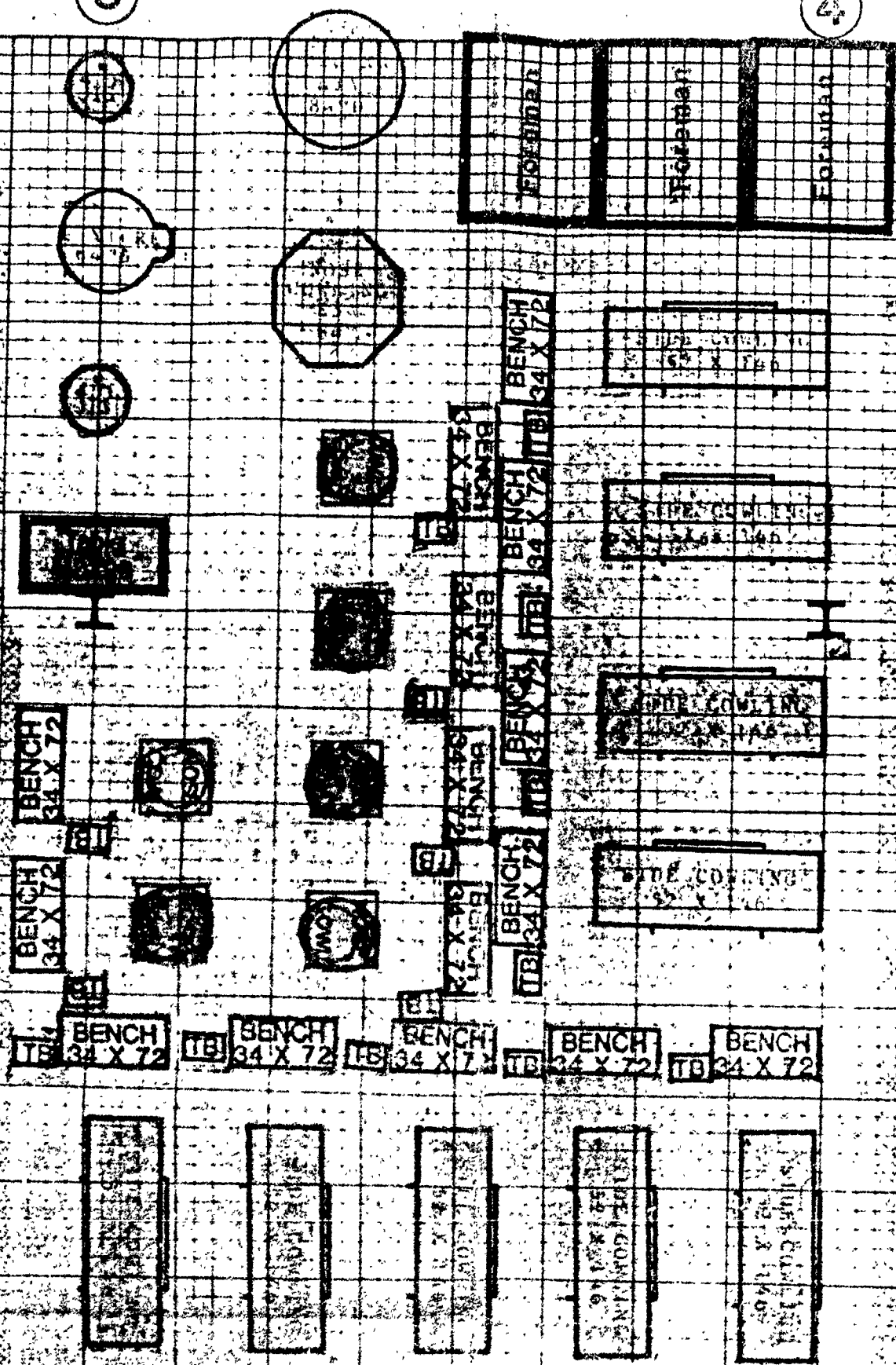
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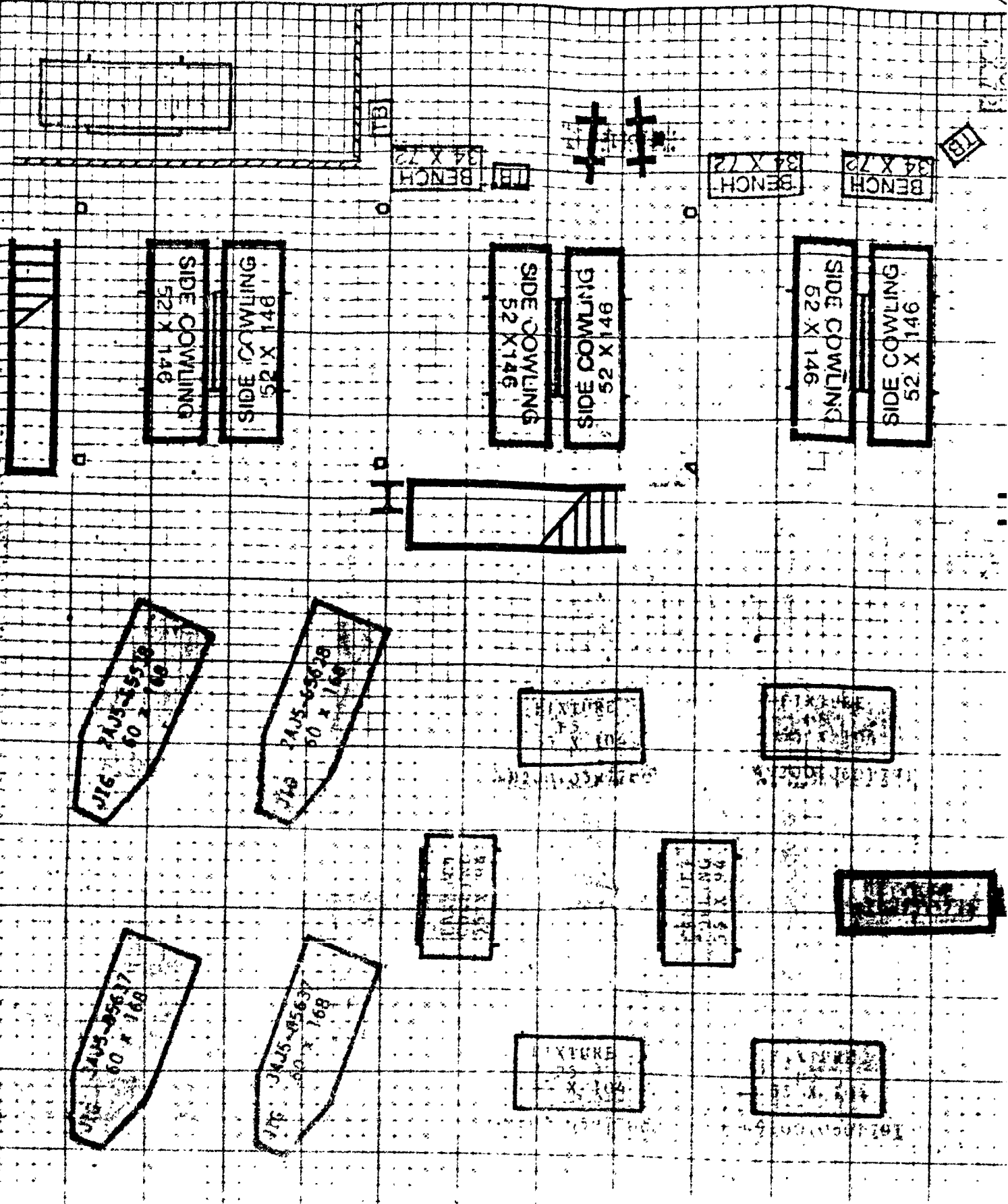
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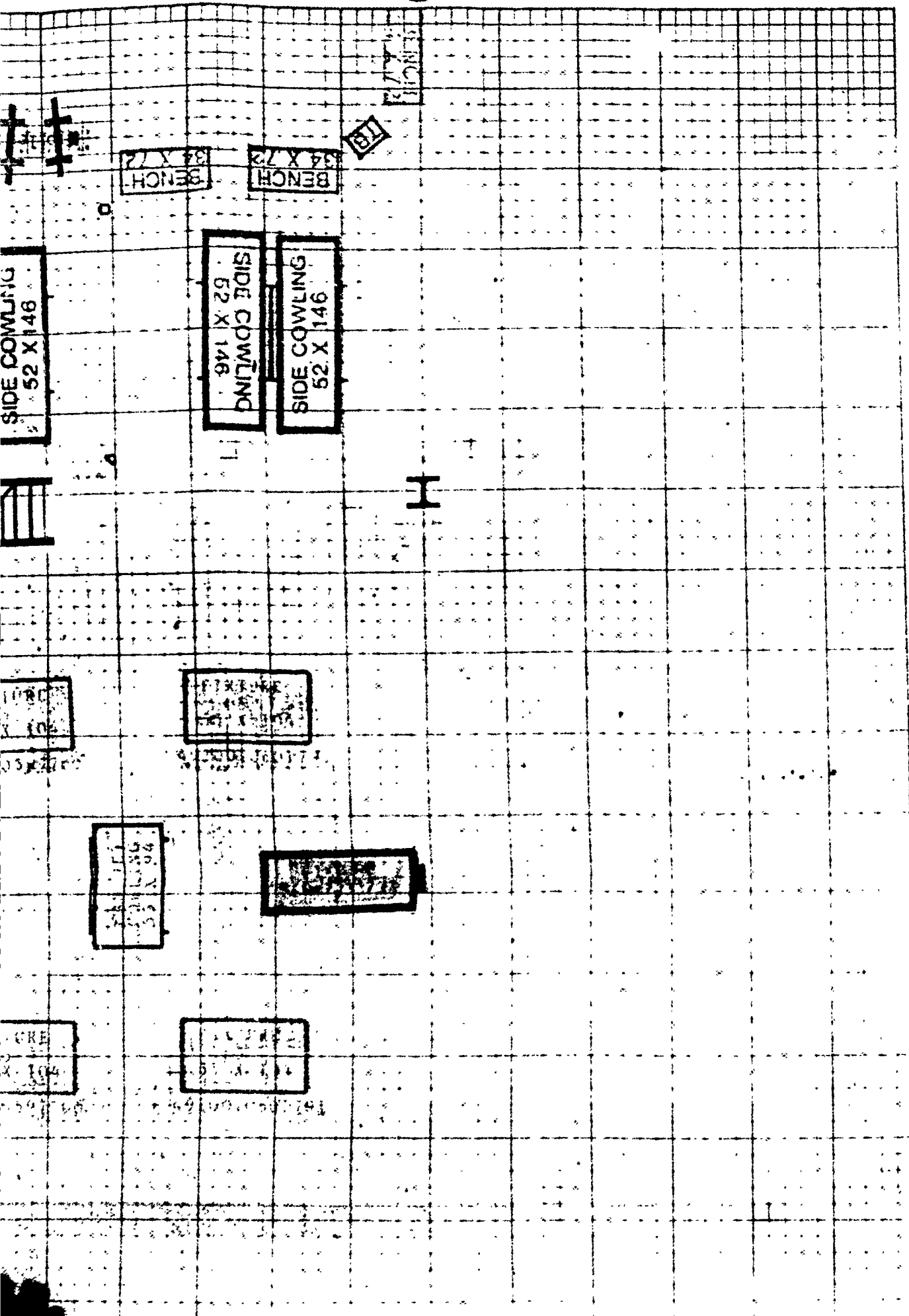


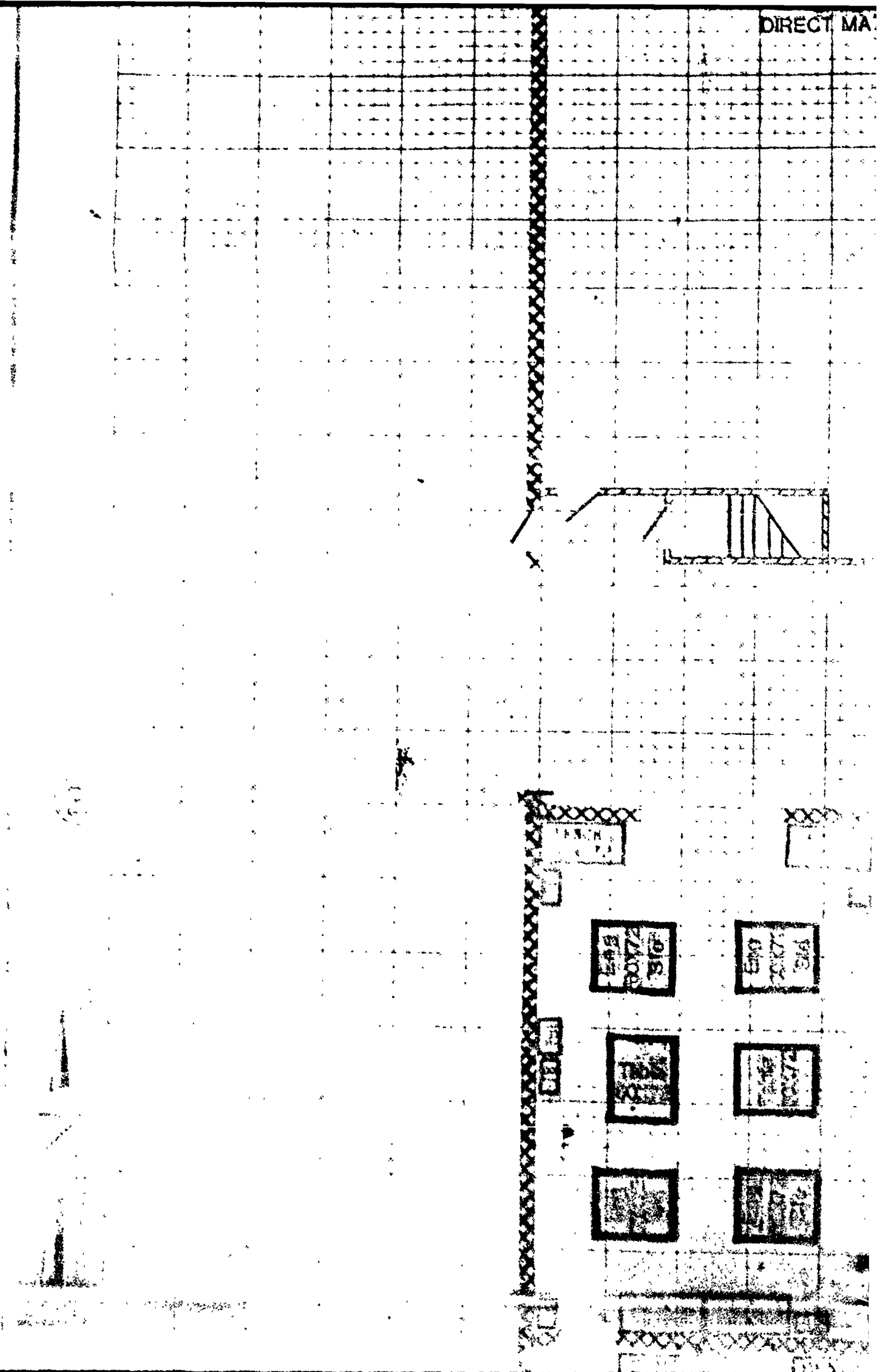
JIC 21  
JIC 21

5



6







**LÖCÄ**

TB
BENCH  
34 X 72
TB
BE  
34

**BENCH**  
**31 X 72**

BENCH  
64 X 72

**BENCH**  
**34 X 72**

**BENCH**  
34072

**BENCH**  
**94-X-72**

**BENCH**


BENCH  
24 Y 73

BENCH

**BENCH**  
34-X-72

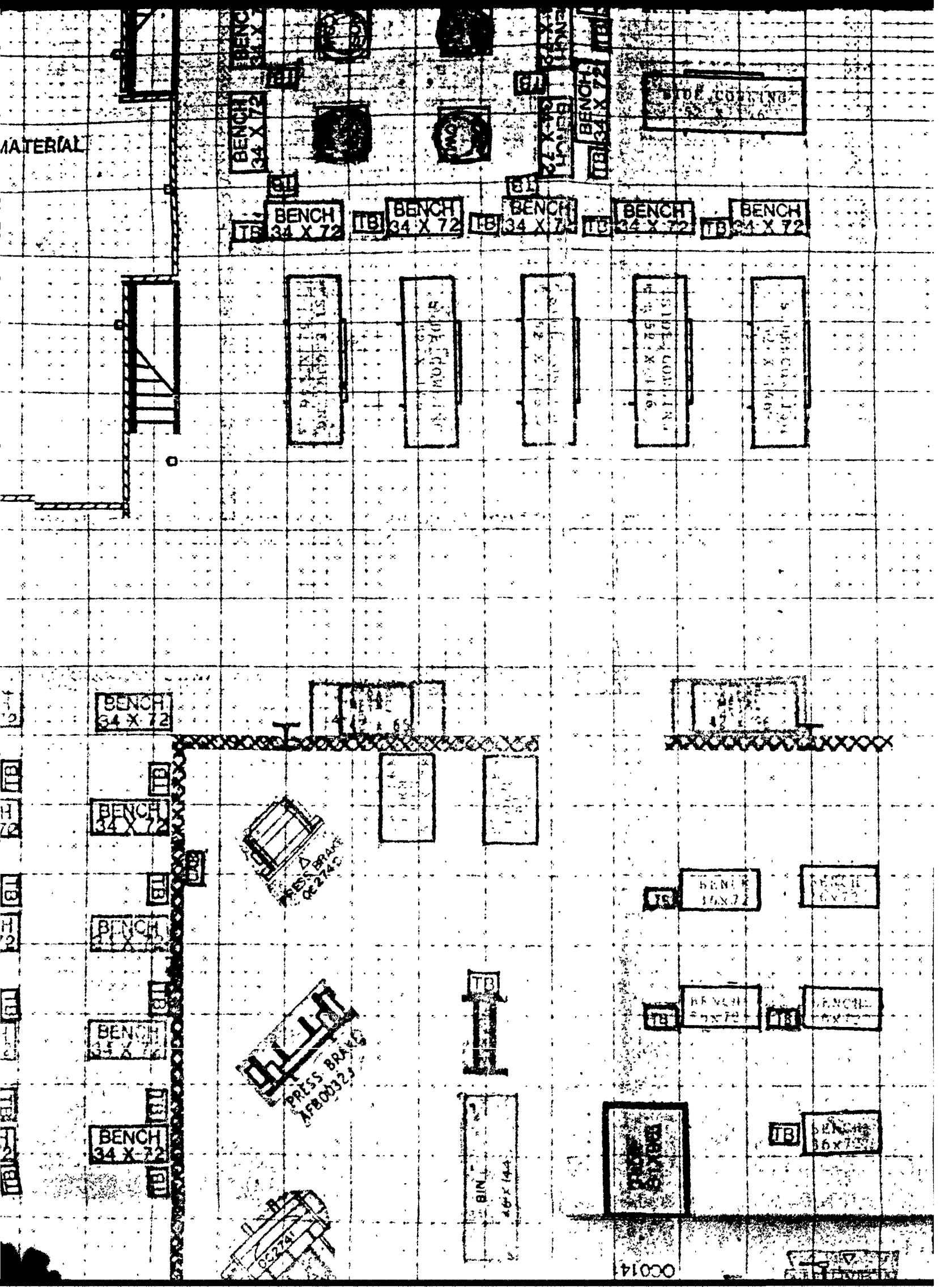
BENCH  
34 X-72

LESS BRAN  
Q274



002791

MATERIAL



COIN

JLG 3405-85637  
60 X 168

JLG 3405-85637  
60 X 168

FIXTURE  
45 X 108

BENCH  
34 X 72

FIXTURE  
45 X 108

SHED COIN  
52 X 116

SHED COIN  
52 X 116

JLG 3405-85637  
60 X 168

JLG 3405-85637  
60 X 168

FIXTURE  
45 X 108

SHED COIN  
52 X 116

BENCH  
34 X 72

BENCH  
34 X 72

TRAILER  
4 X 10

BENCH  
34 X 72

BENCH  
34 X 72

MLG DOOR  
FIXTURE

SHED COIN  
52 X 116

SHED COIN  
52 X 116

MLG DOOR  
FIXTURE

BENCH  
34 X 72

BENCH  
34 X 72

BENCH  
34 X 72

BENCH  
34 X 72

MLG DOOR  
FIXTURE

SHED COIN  
52 X 116

SHED COIN  
52 X 116

MLG DOOR  
FIXTURE

TRAILER  
45 X 108

SHED COIN  
52 X 116

BENCH  
34 X 72

SHED COIN  
52 X 116

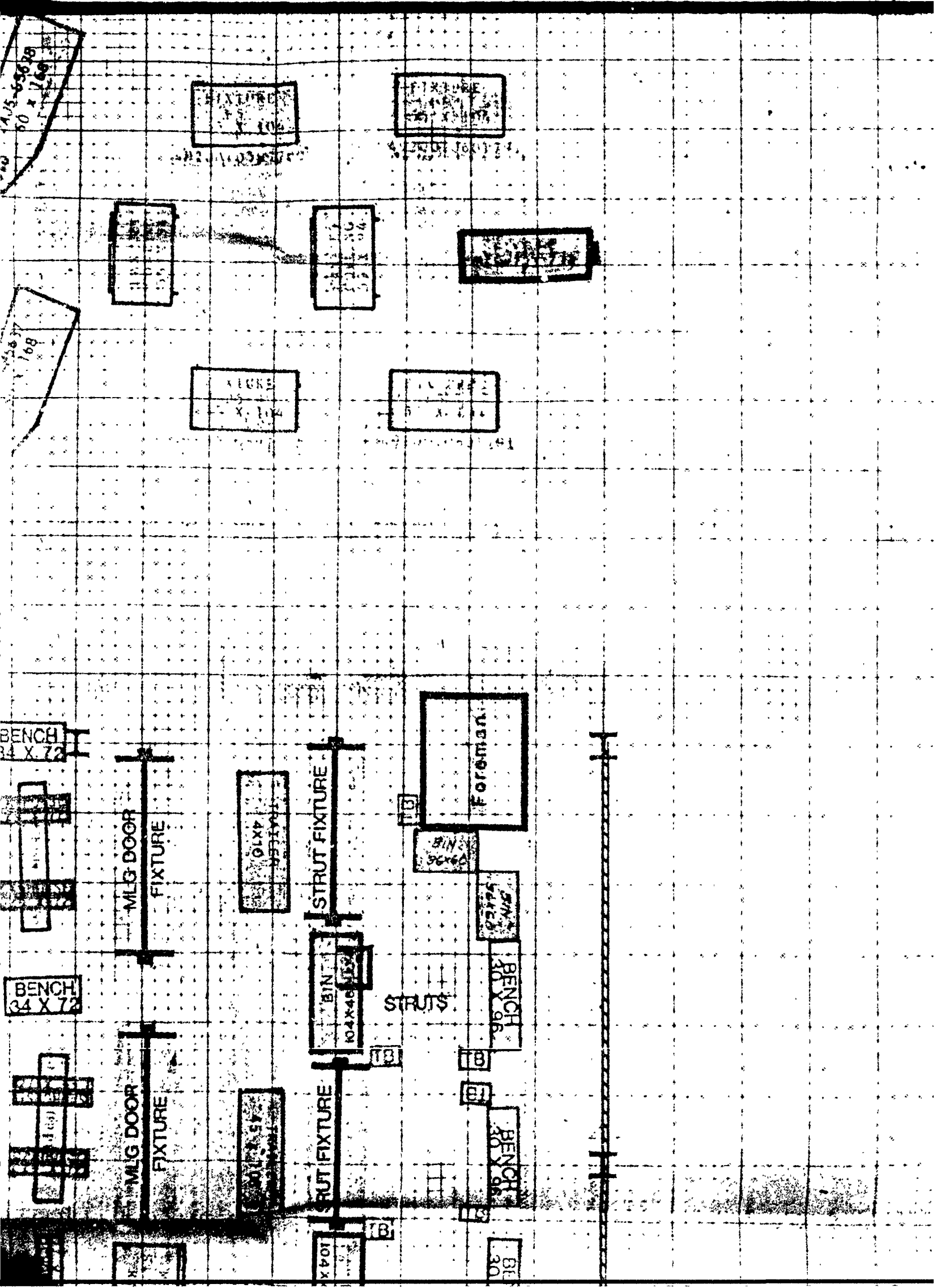
SHED COIN  
52 X 116

SHED COIN  
52 X 116

SHED COIN  
52 X 116

SHED COIN  
52 X 116

SHED COIN  
52 X 116



FIXTURE

FIXTURE

FIXTURE

Foreman

BENCH  
36x60

BENCH  
30x96

BENCH  
30x96

BENCH  
30x96

BENCH  
30x96

STRUTS

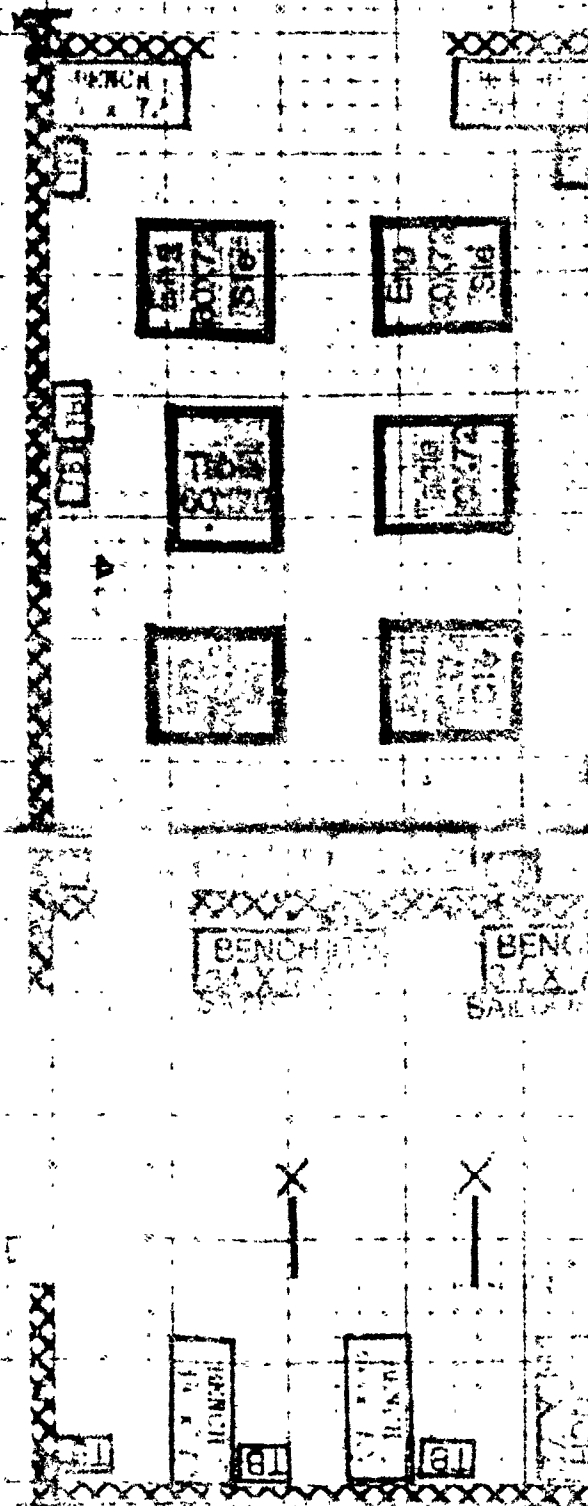
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4  
3  
2  
1

104X48

104X48

(E)

(G)



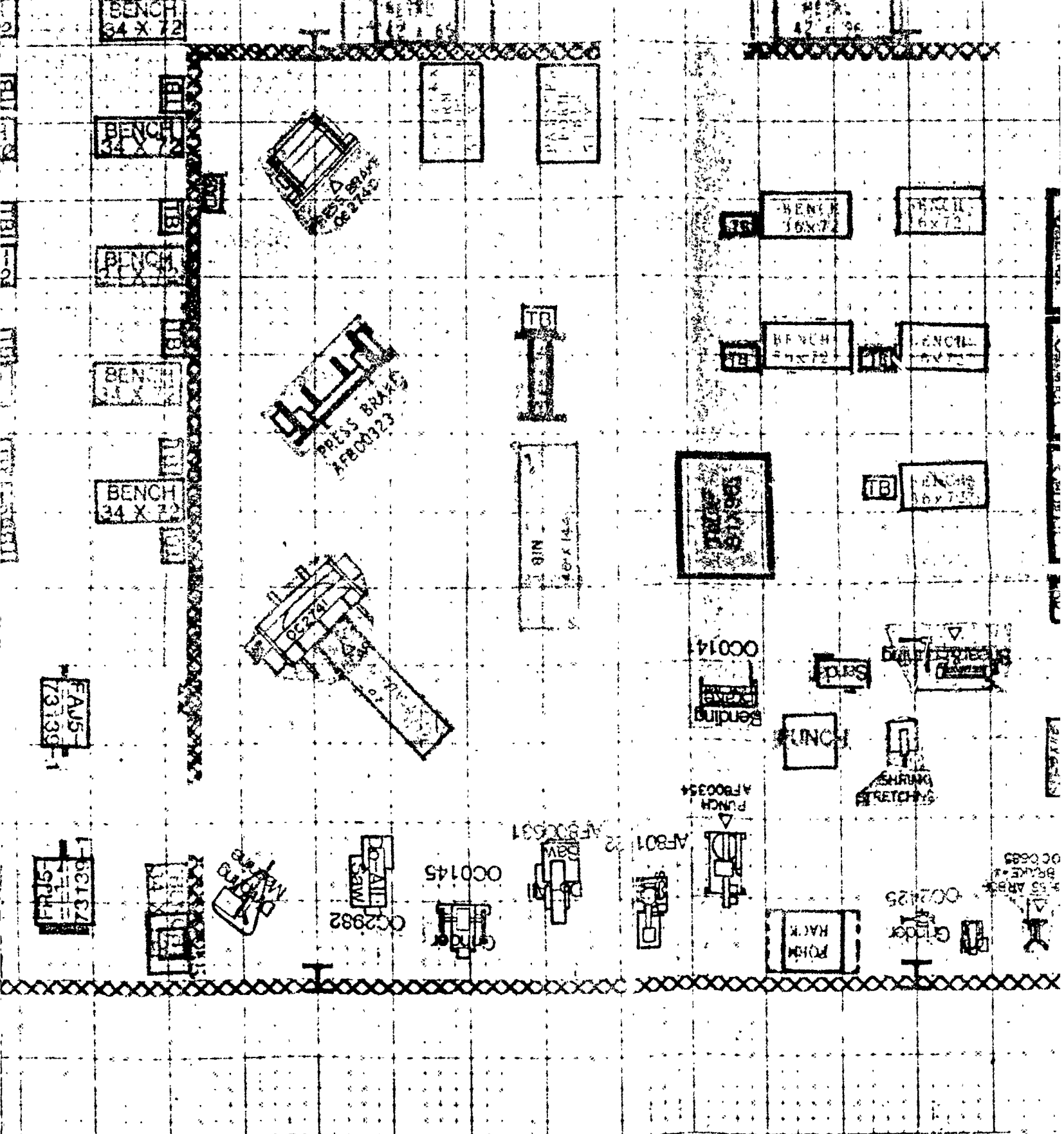
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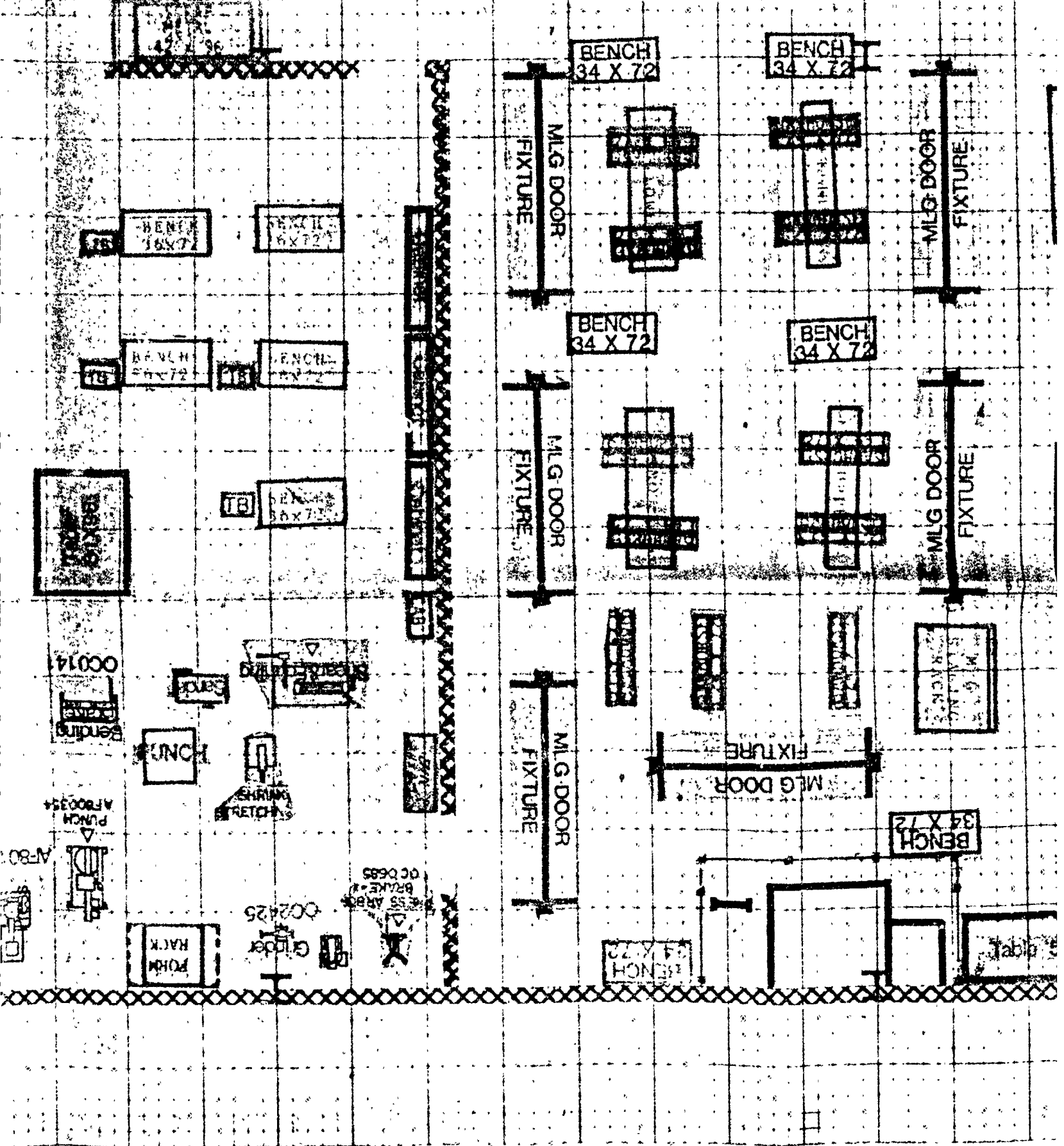
BLDG 2101

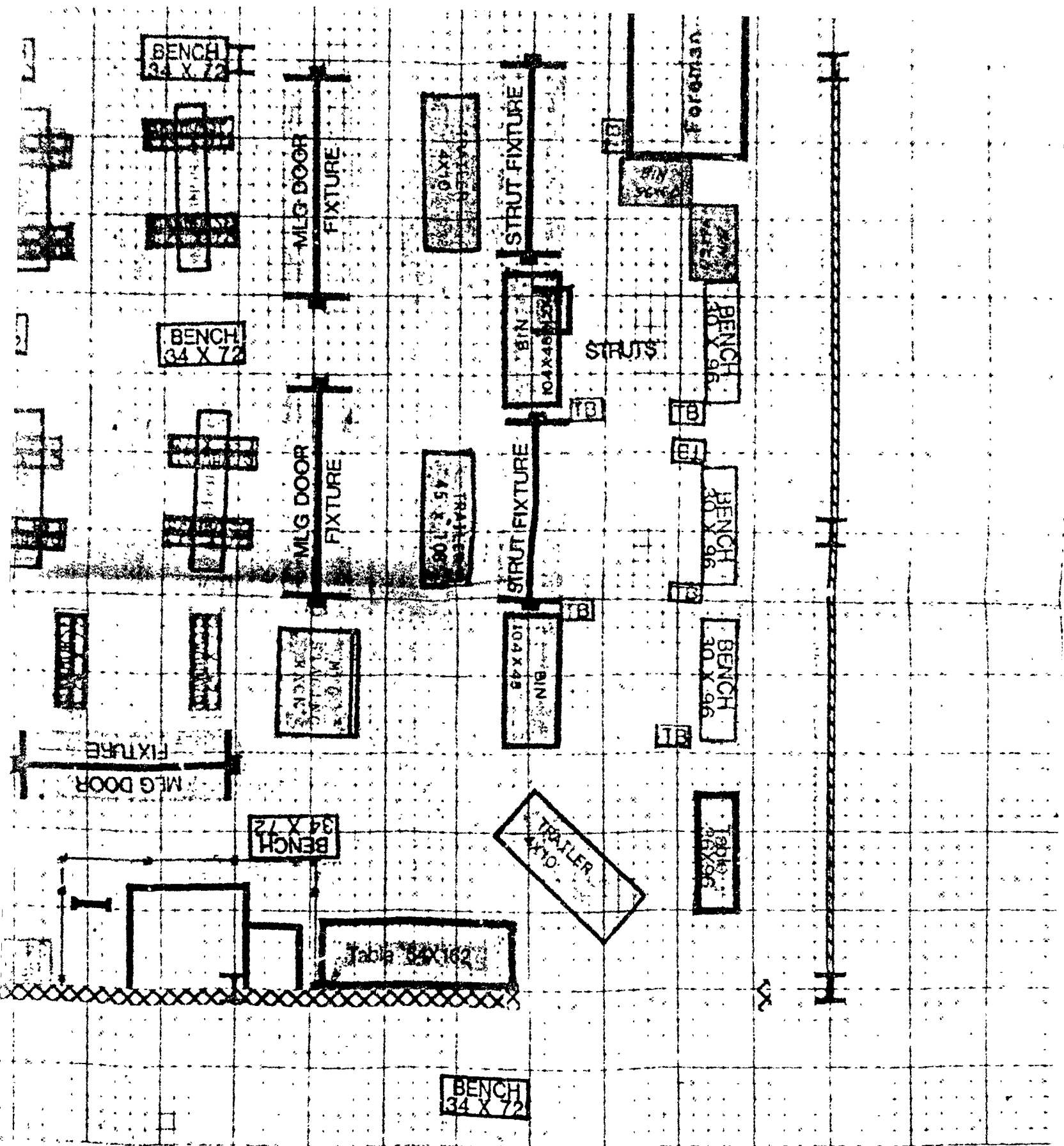
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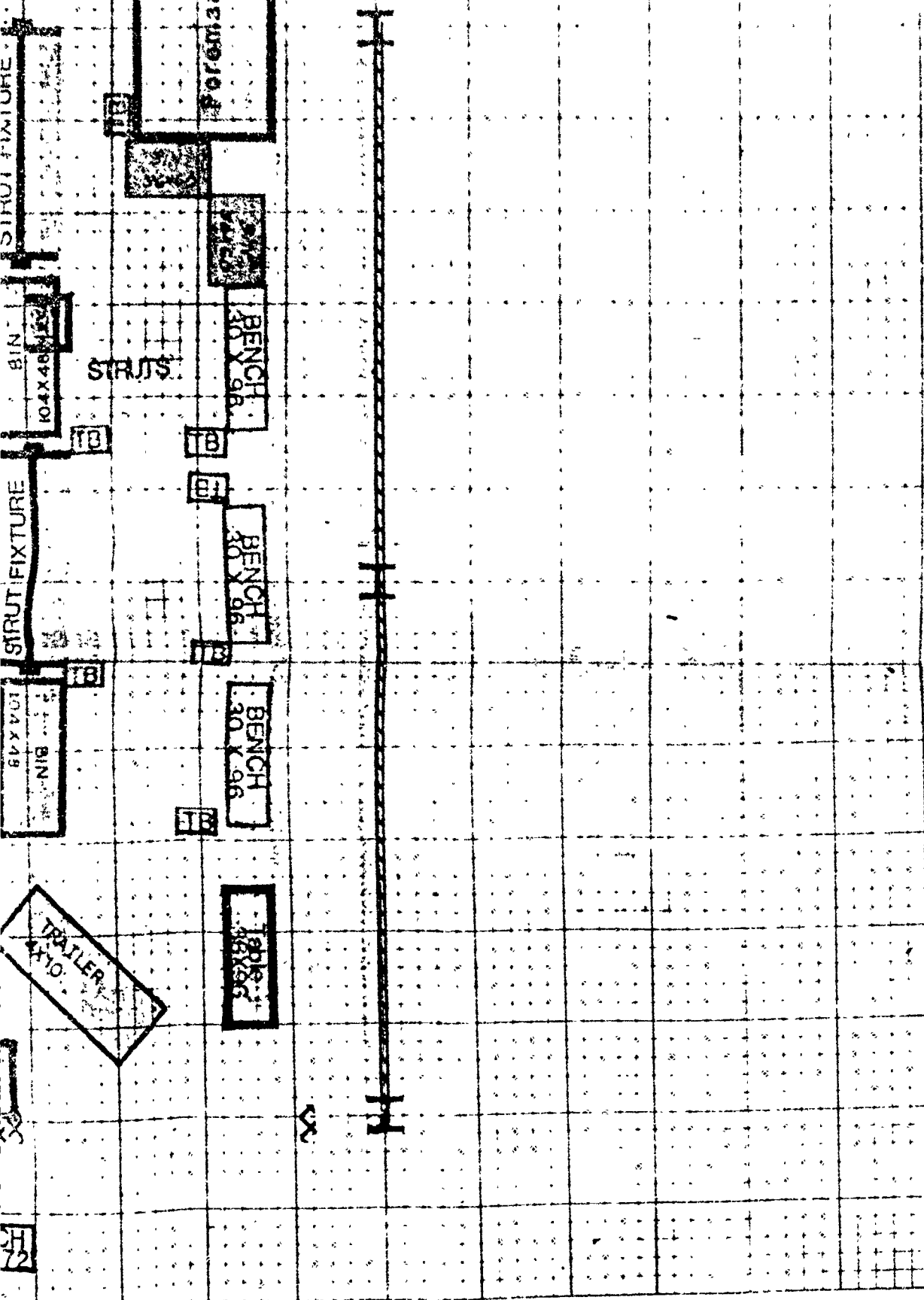






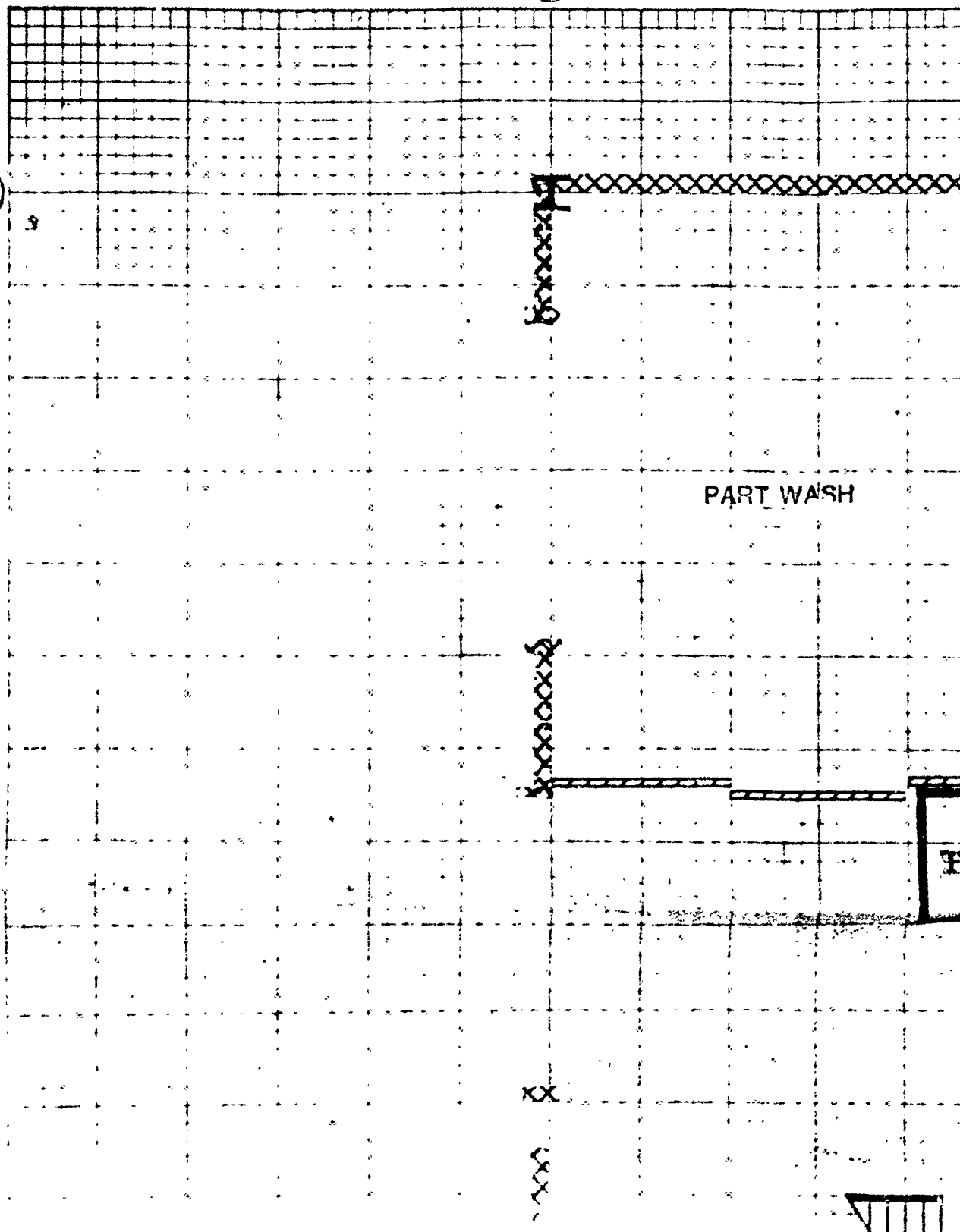






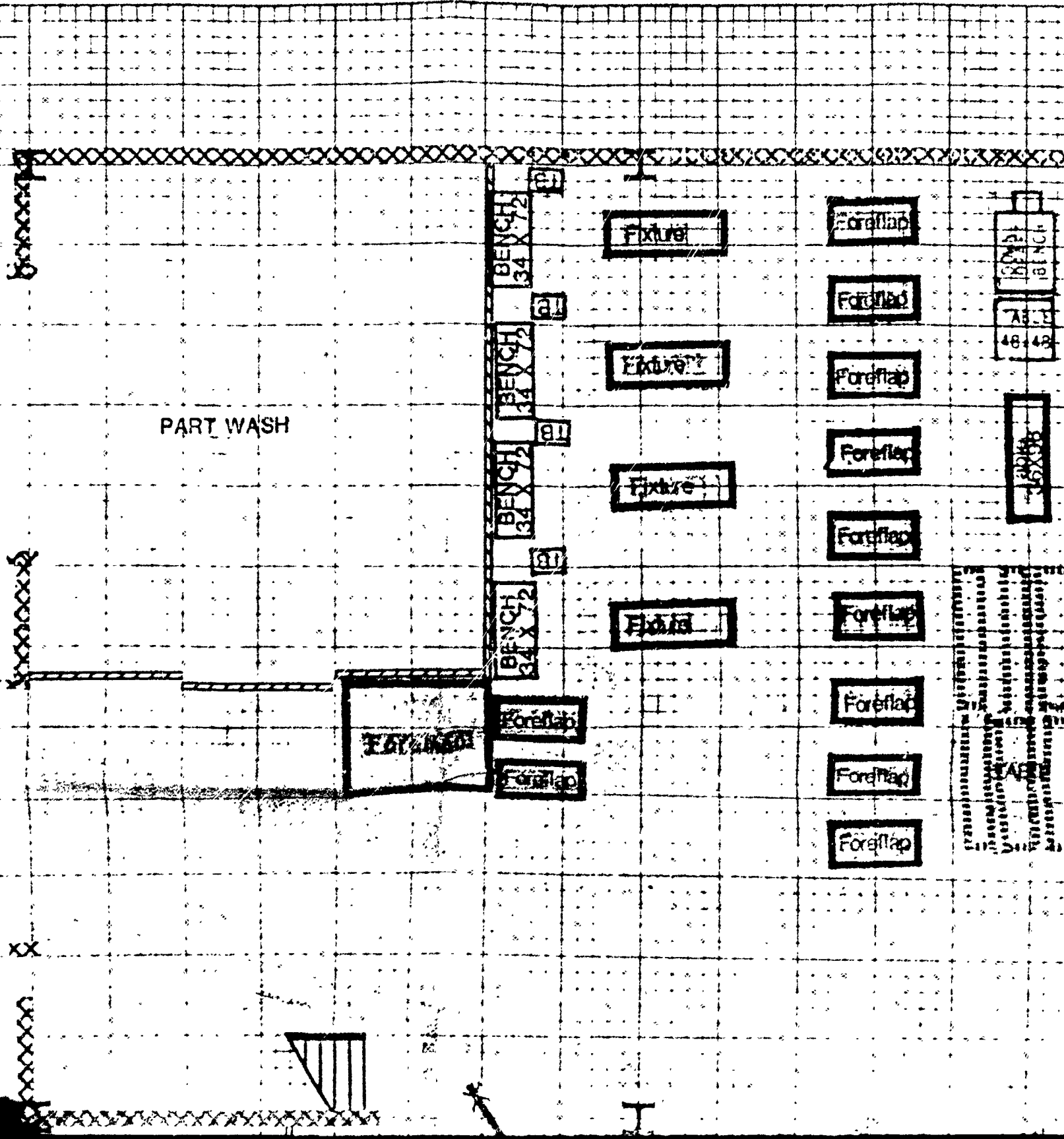
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A

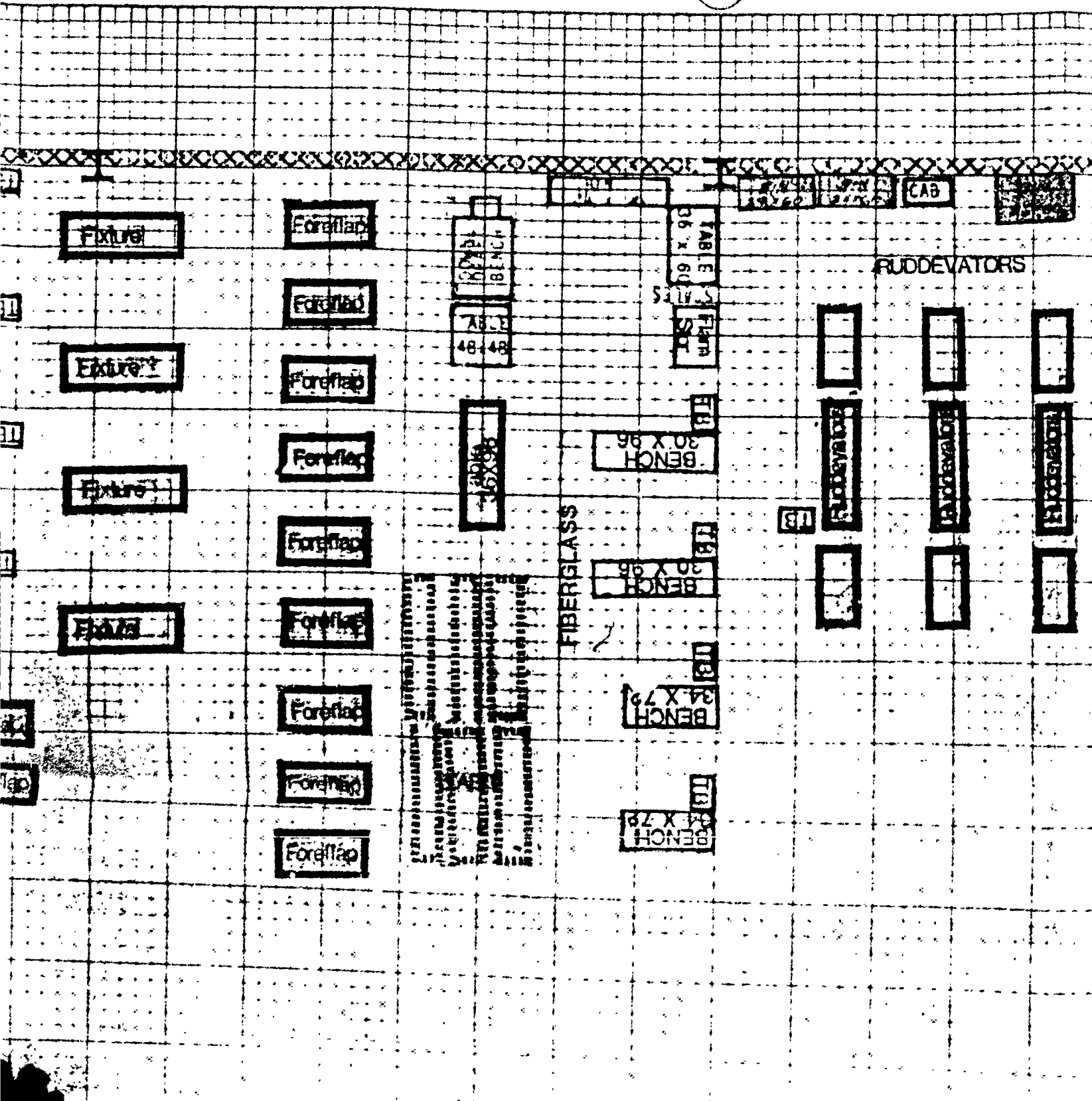


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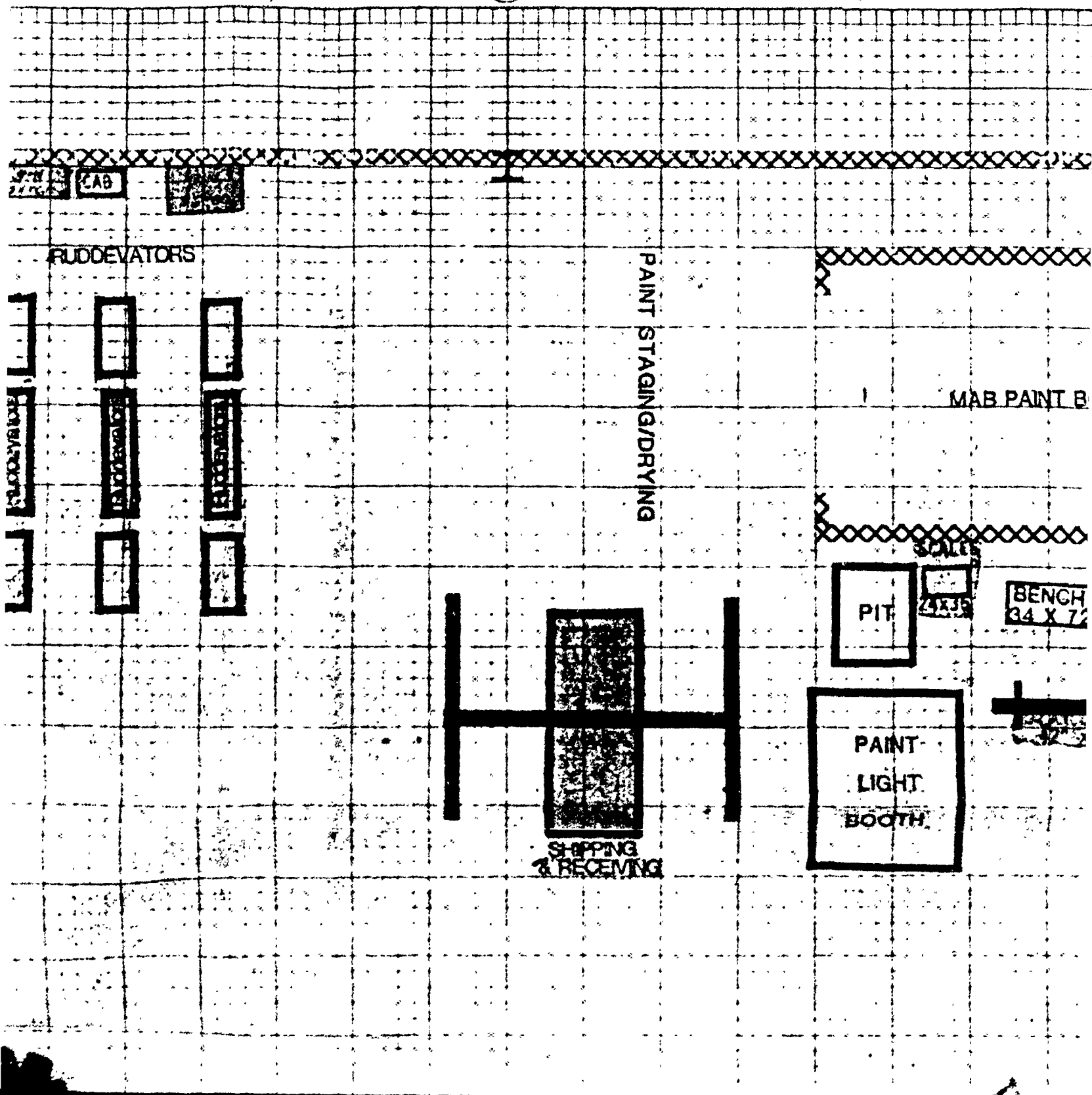
2



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4





5

6

MAB PAINT BOOTH

1/P PAINT BOOTH

PIT

BENCH  
34 X 72

BENCH  
34 X 72

PIT

BENCH  
34 X 72

BENCH  
34 X 72

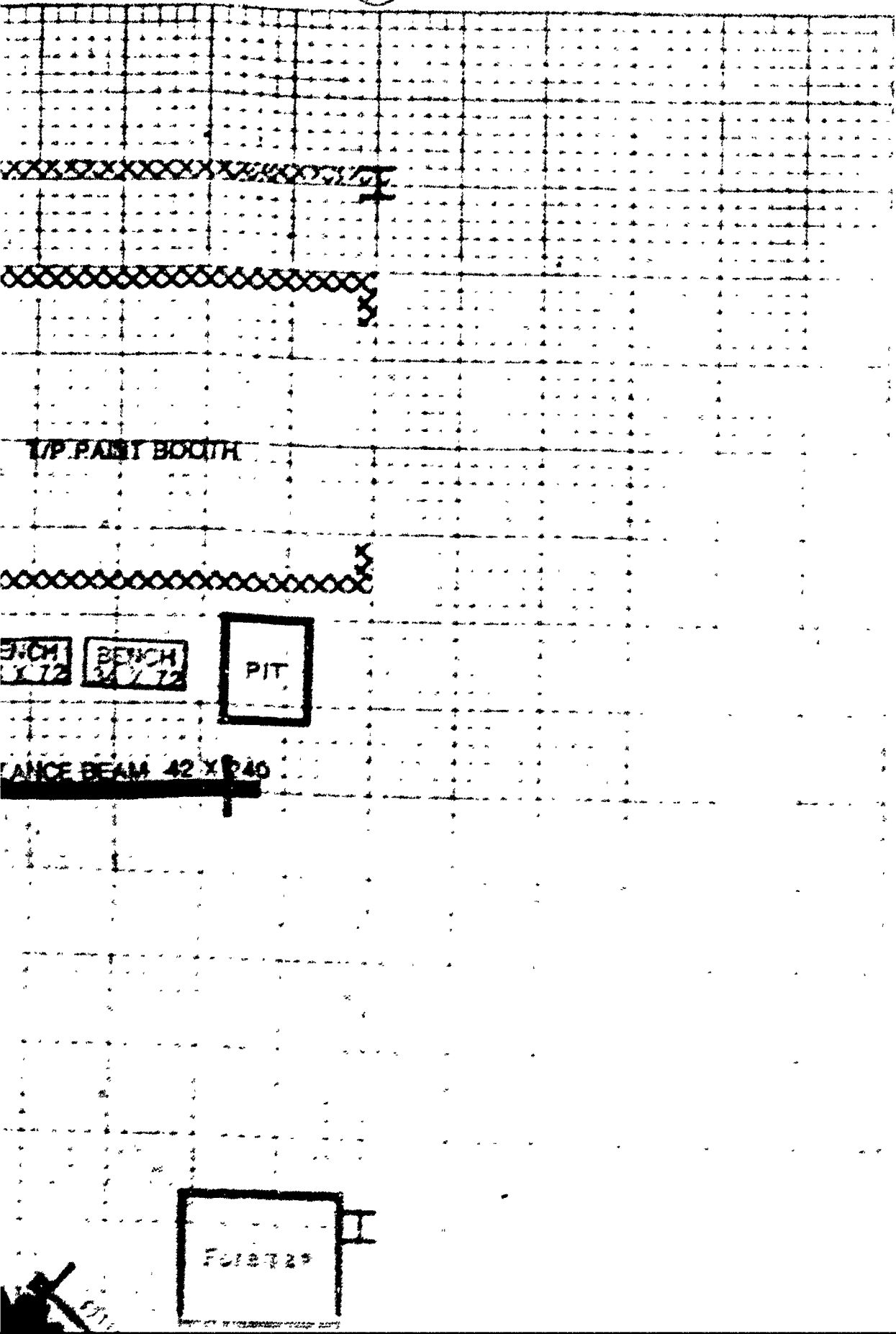
PIT

PANT  
LIGHT  
BOOTH

BALANCE BEAM 42 X 240

WEIGHT BALANCE

6

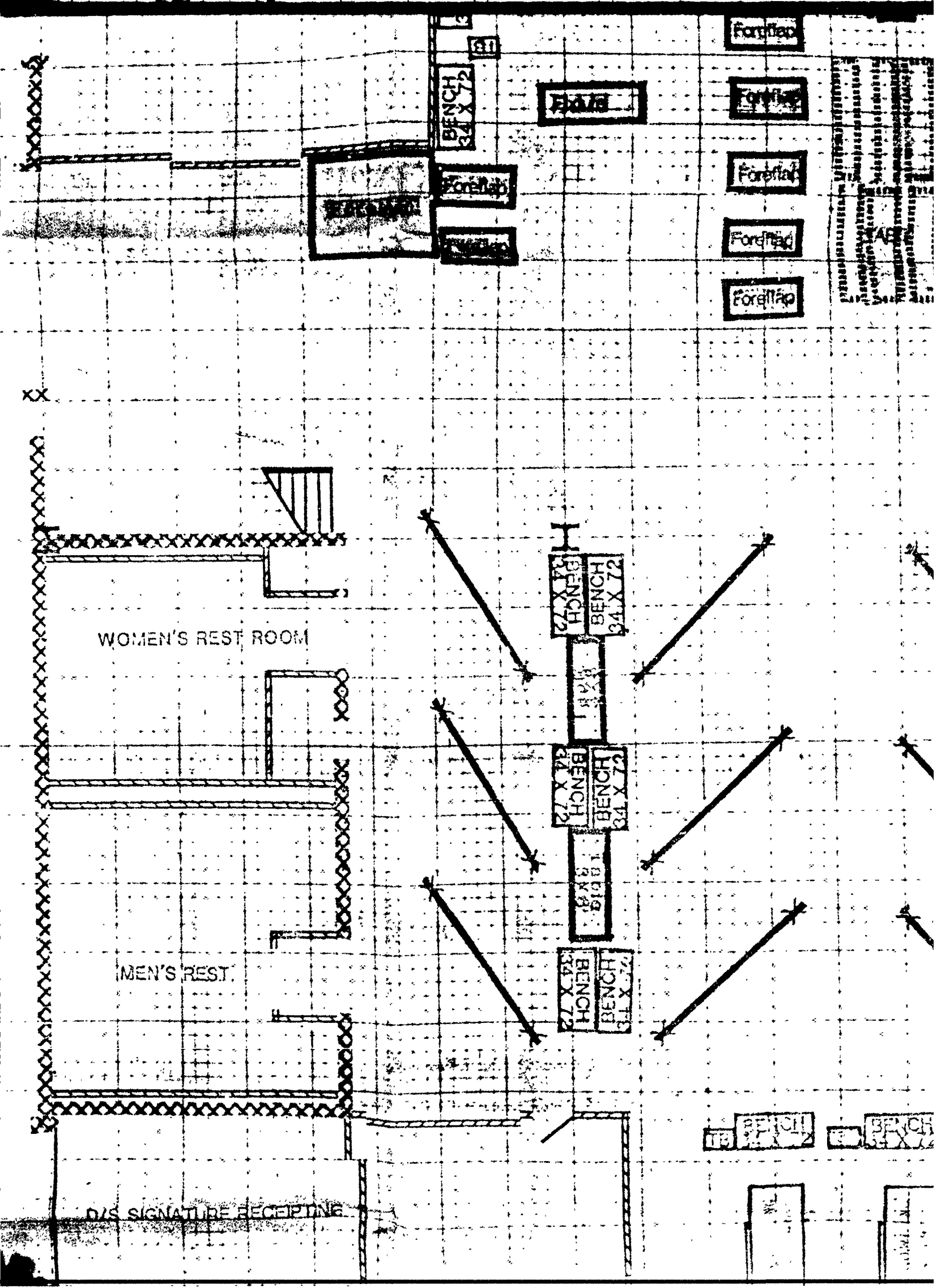


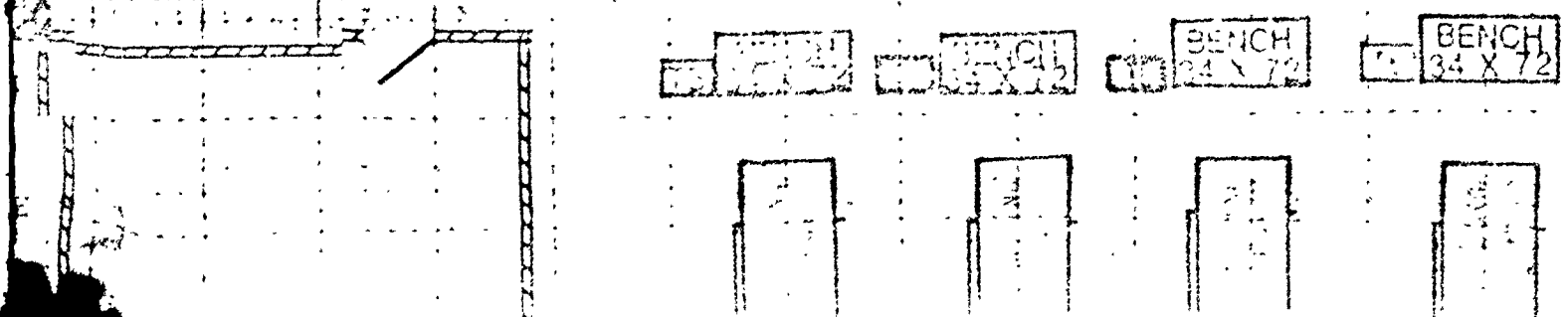
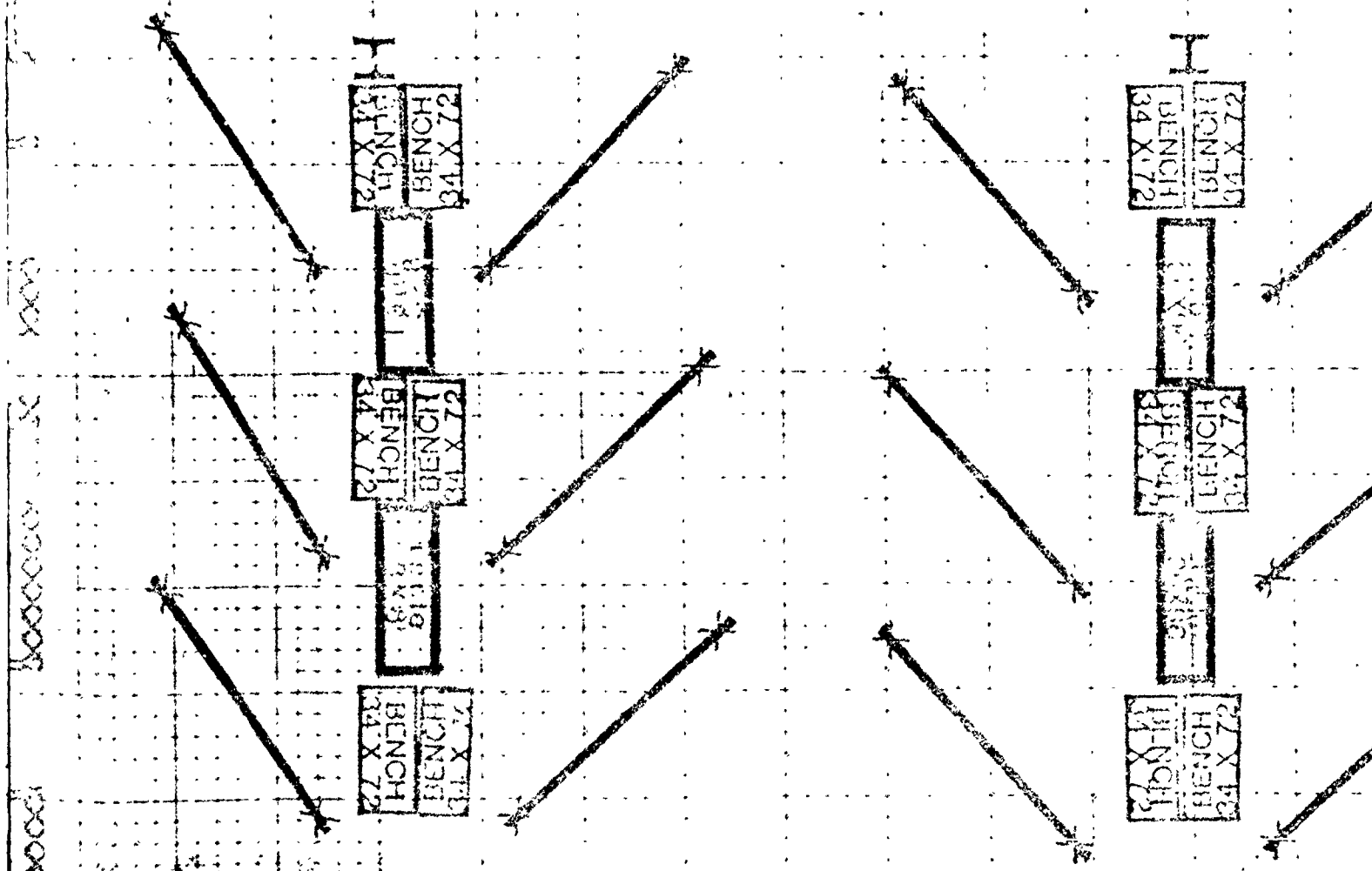
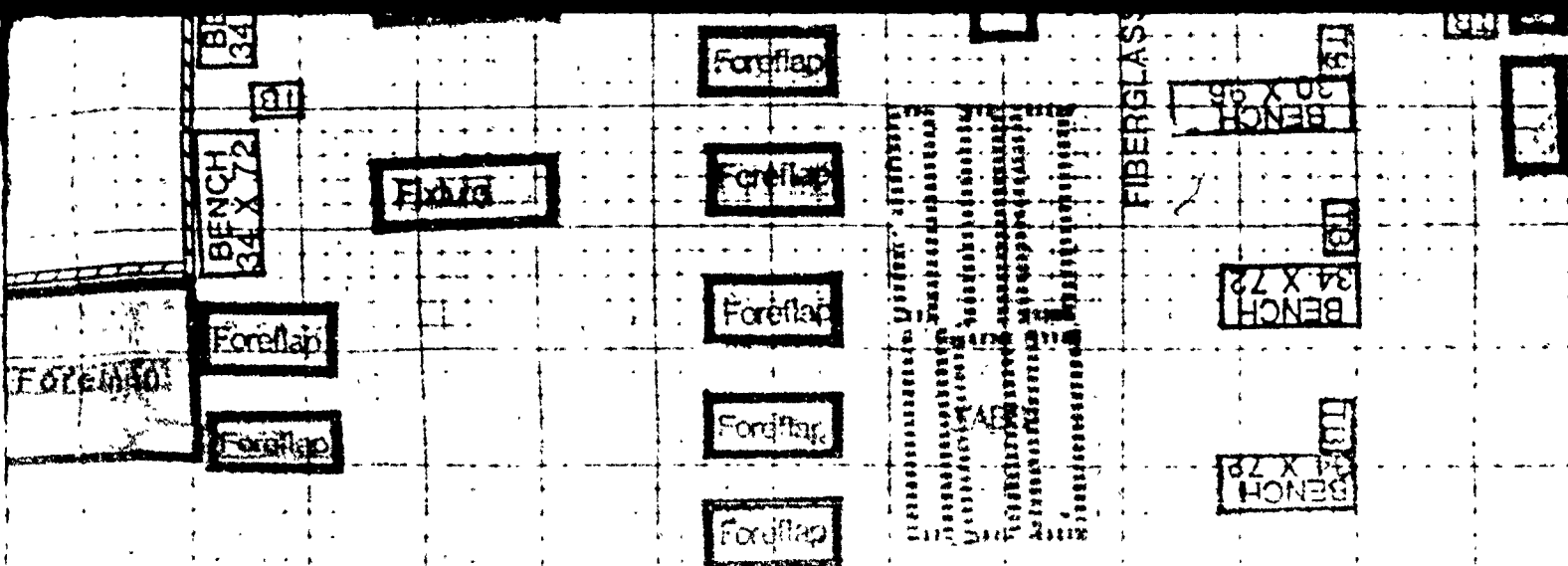
(E)

WOMEN'S REST ROOM

MEN'S REST.

D/S SIGNATURE RECEIPTING





ING

FIBERGLASS

BENCH  
34 X 72

BENCH  
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34 X 72

BENCH  
34 X 72

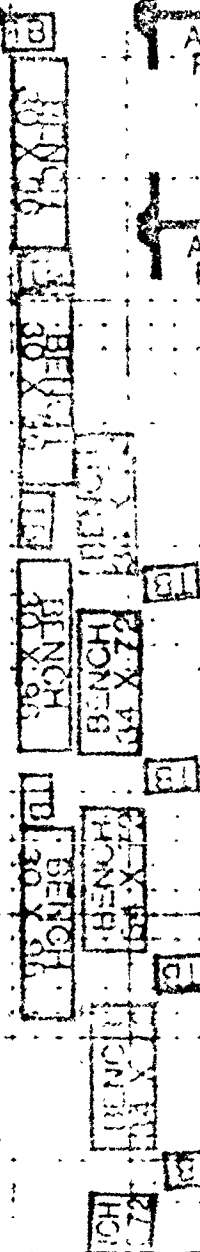
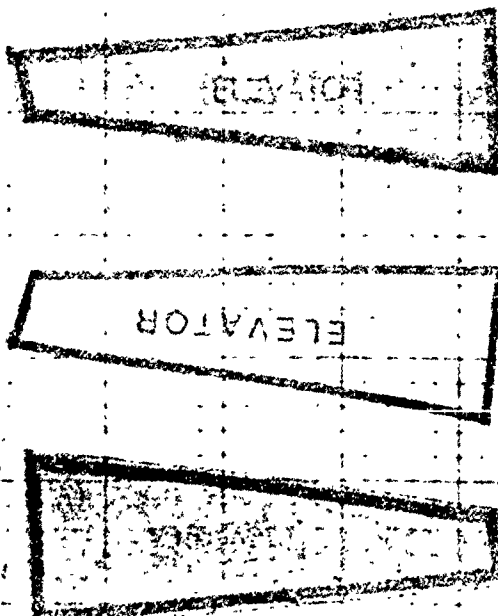
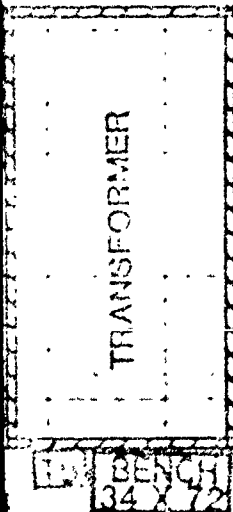
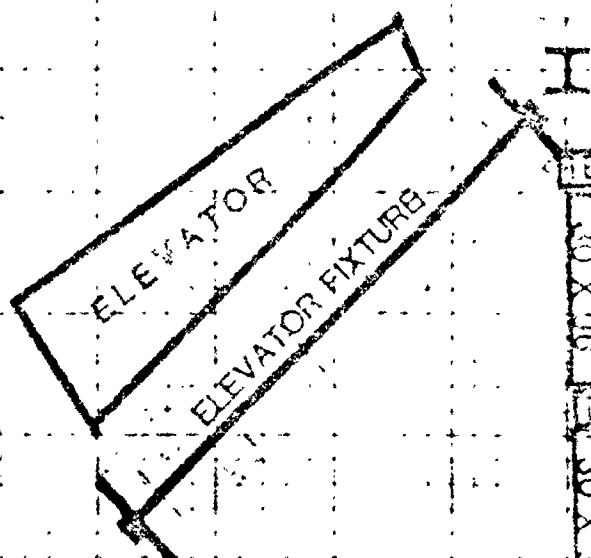
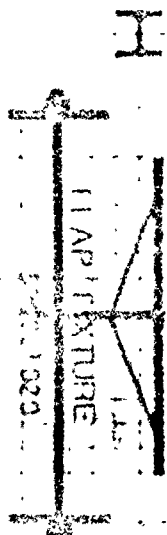
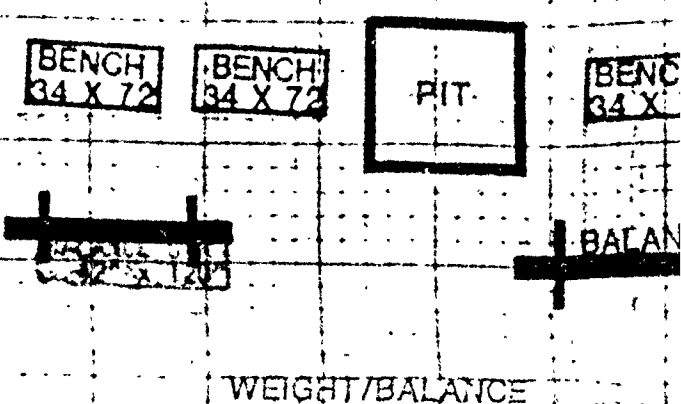
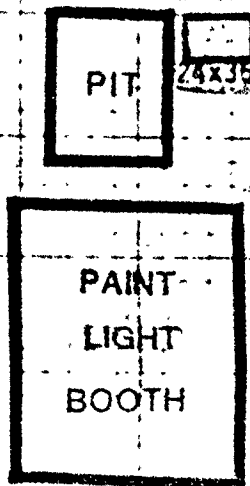
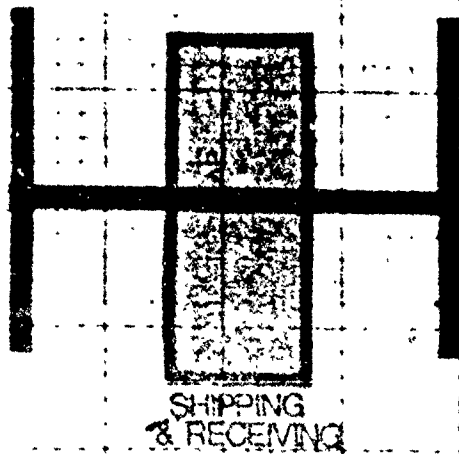
SHIPPING  
& RECEIVING

LAP FECTURE

LAP FECTURE

Foreman

TRANSFORMER



BENCH  
34 X 72

BENCH  
34 X 72

PIT

BENCH  
34 X 72

BENCH  
34 X 72

PIT

BALANCE BEAM 42 X 240

WEIGHT/BALANCE

INBD  
AILERON  
FIXTURE

INBD  
AILERON  
FIXTURE

INBD  
AILERON  
FIXTURE

OUTBD AILERON FIXTURE

BENCH  
34 X 72

BENCH  
34 X 72

BENCH  
34 X 72

BENCH  
34 X 72

BENCH  
34 X 72

BENCH  
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BENCH  
34 X 72

BENCH  
34 X 72

BENCH  
34 X 72

BENCH  
34 X 72



CM  
72

BENCH  
34 X 72

PIT

NCE BEAM 42 X 240

Foreign

OTPC AIRCRAFT FIXTURE

BENCH  
34 X 72

18

BENCH  
34 X 72

12

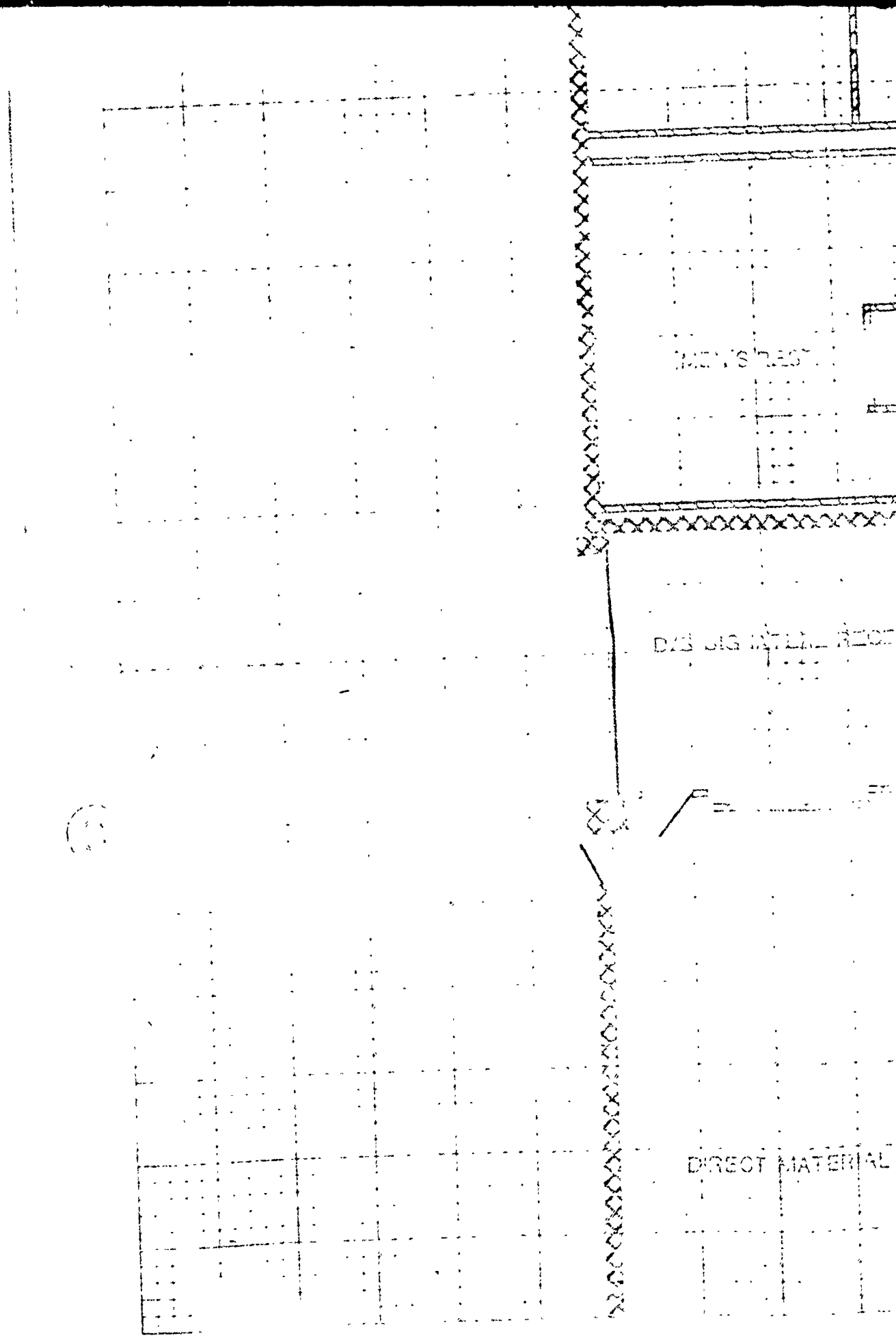
BENCH  
34 X 72

13

BENCH  
34 X 72

18

BENCH  
34 X 72



1-TL

7

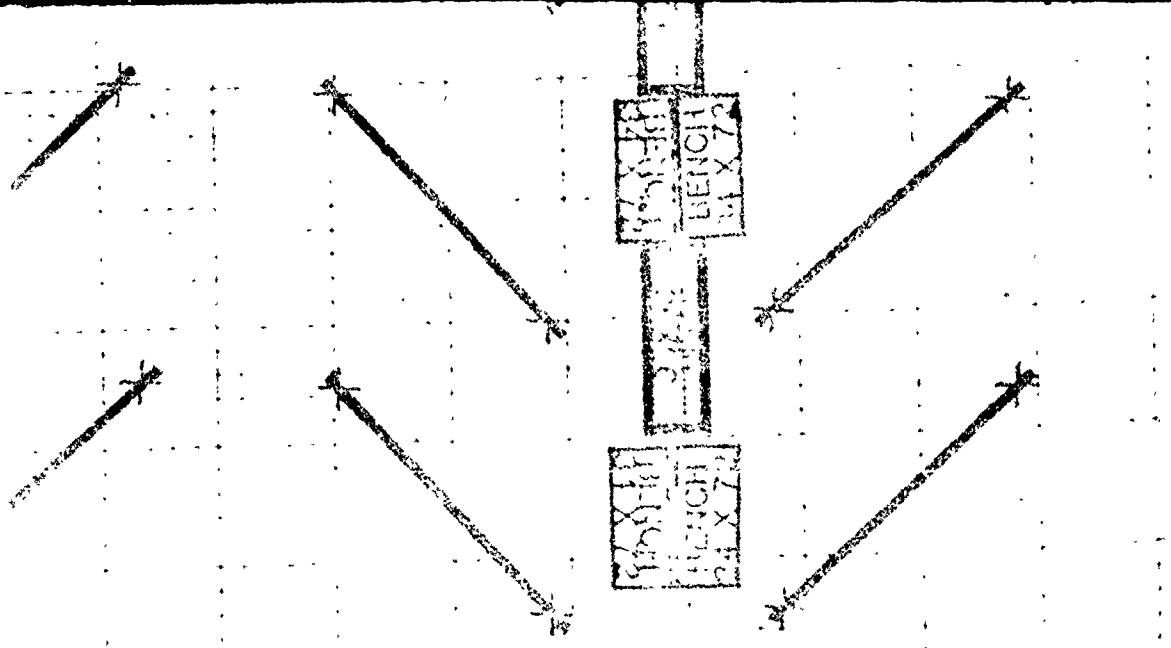
BLDG 2101

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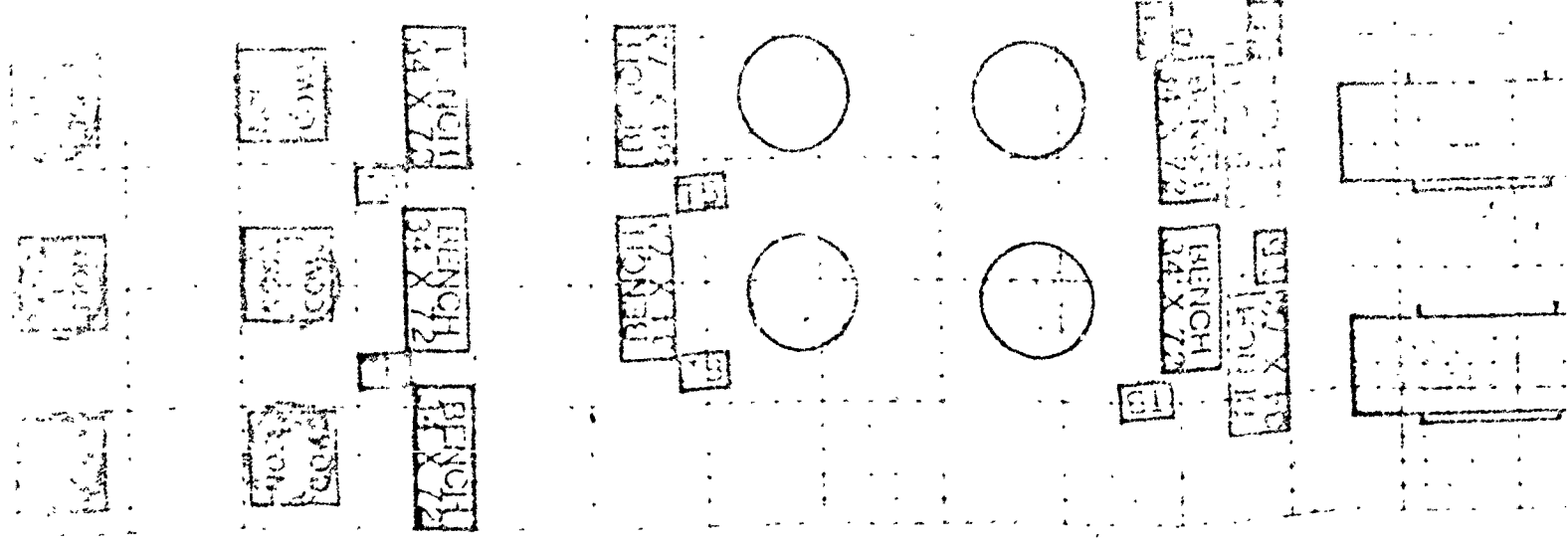
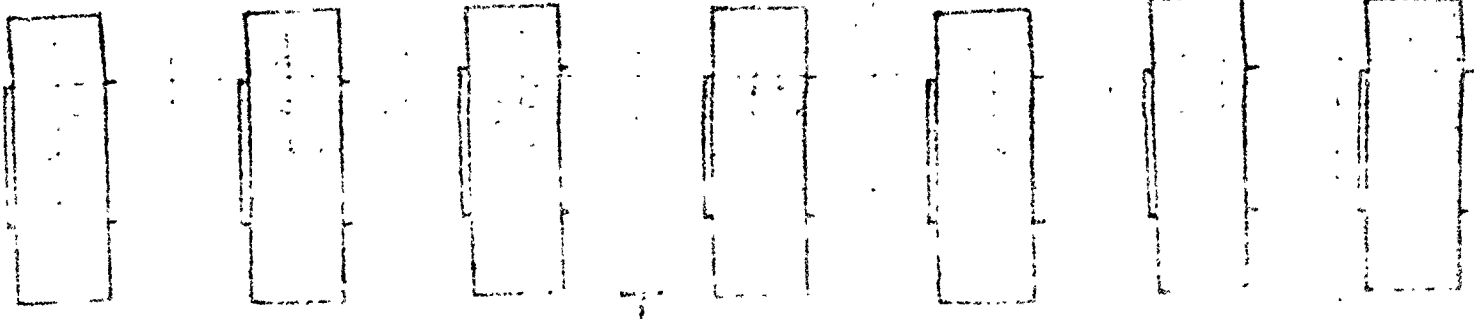


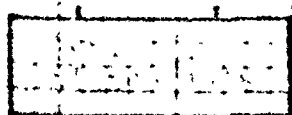
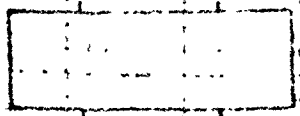
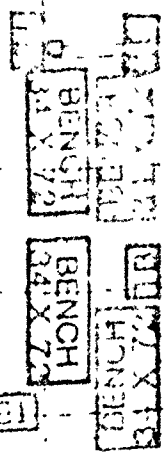
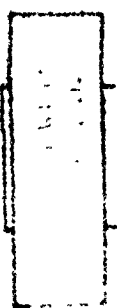
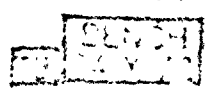
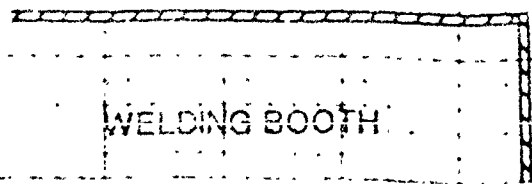
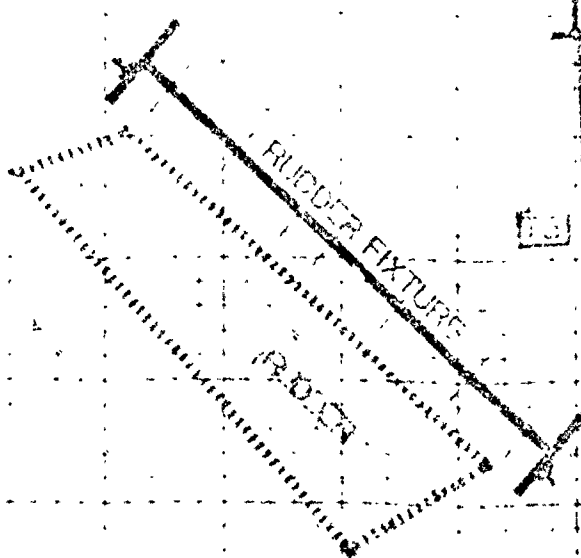
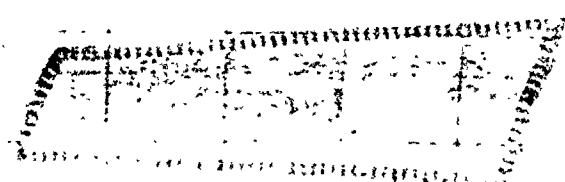
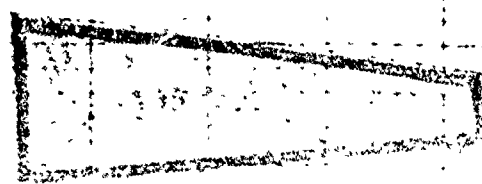
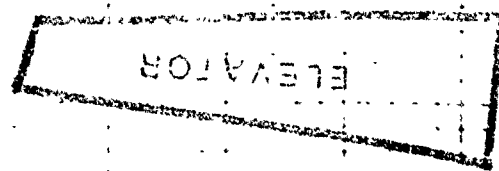
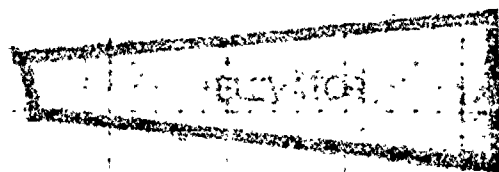
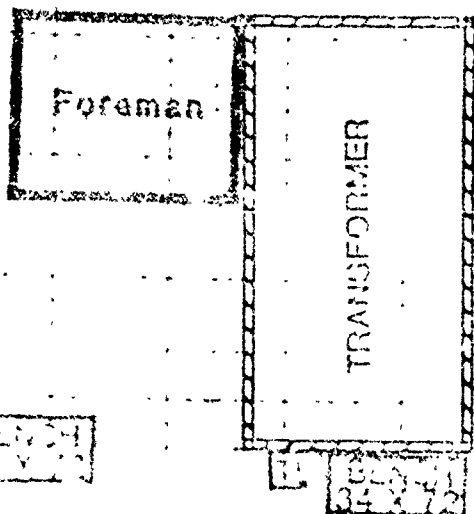
FIGURE 1

Foreman



BENCH 34 X 72





ALLEYWAY  
FLAT

WED  
WED

ELEVATION

ELEVATION

BENCH  
30 X 72

BENCH  
30 X 72

BENCH  
30 X 72

BENCH  
30 X 72

BENCH  
30 X 72

BENCH  
30 X 72

BENCH  
30 X 72

BENCH  
30 X 72

BENCH  
30 X 72

BENCH  
30 X 72

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BENCH  
30 X 72

BENCH  
30 X 72

BENCH  
30 X 72

BENCH  
30 X 72

BENCH  
30 X 72

BENCH  
30 X 72

BENCH  
30 X 72

BENCH  
30 X 72

BENCH  
30 X 72

BENCH  
30 X 72

BENCH  
30 X 72

RUDDER FIXTURE

RUDDER

ENGINE BOOTH

SPOOLER FIXTURE

SPOOLERS

SPOOLER FIXTURE

BENCH  
34 X 72

13

BENCH  
34 X 72

13

BENCH  
34 X 72

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BENCH  
34 X 72

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BENCH  
34 X 72

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BENCH  
34 X 72

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BENCH  
34 X 72

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BENCH  
34 X 72

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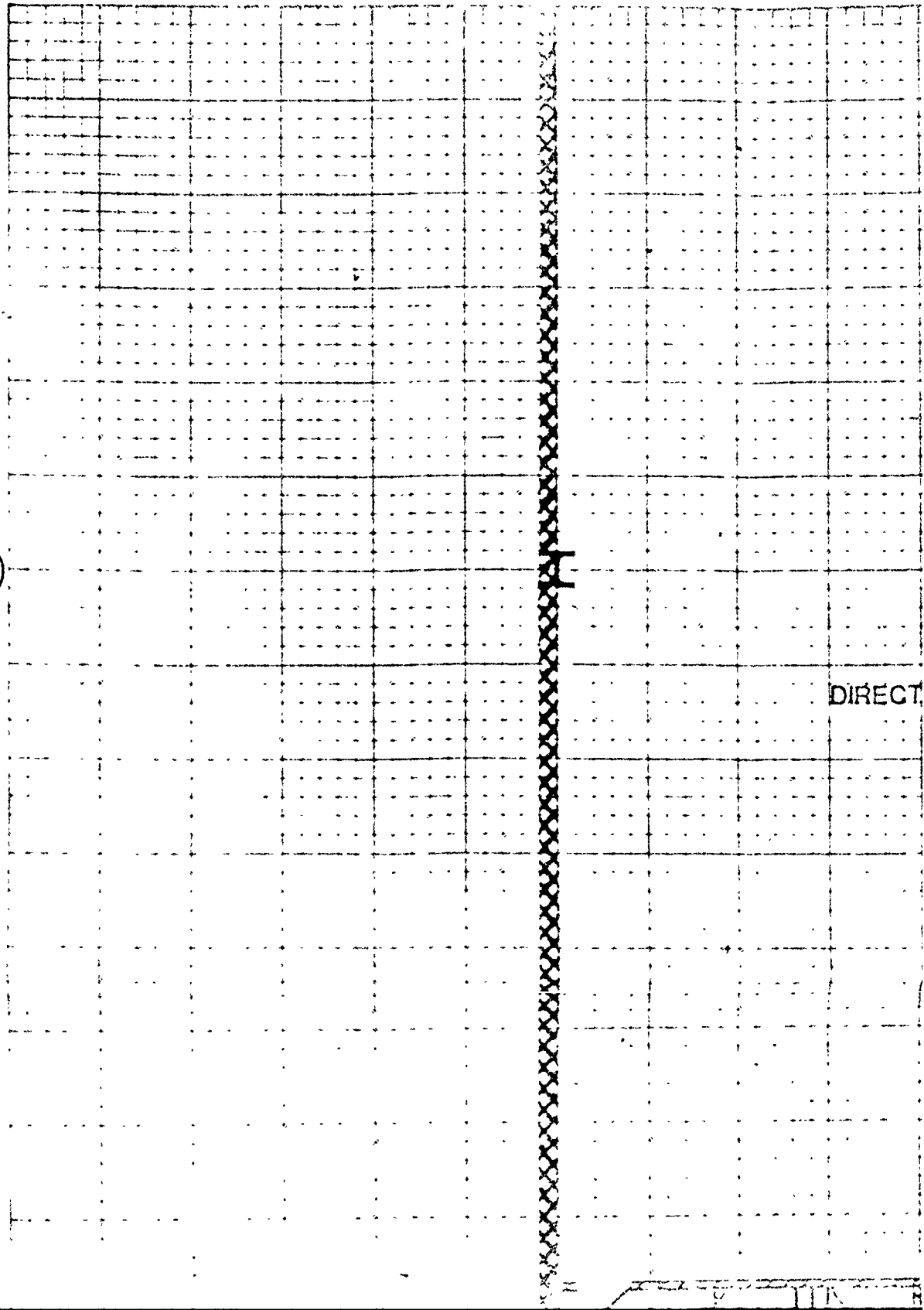
13

SPOKER  
FIXTURE

13

(D)

(C)

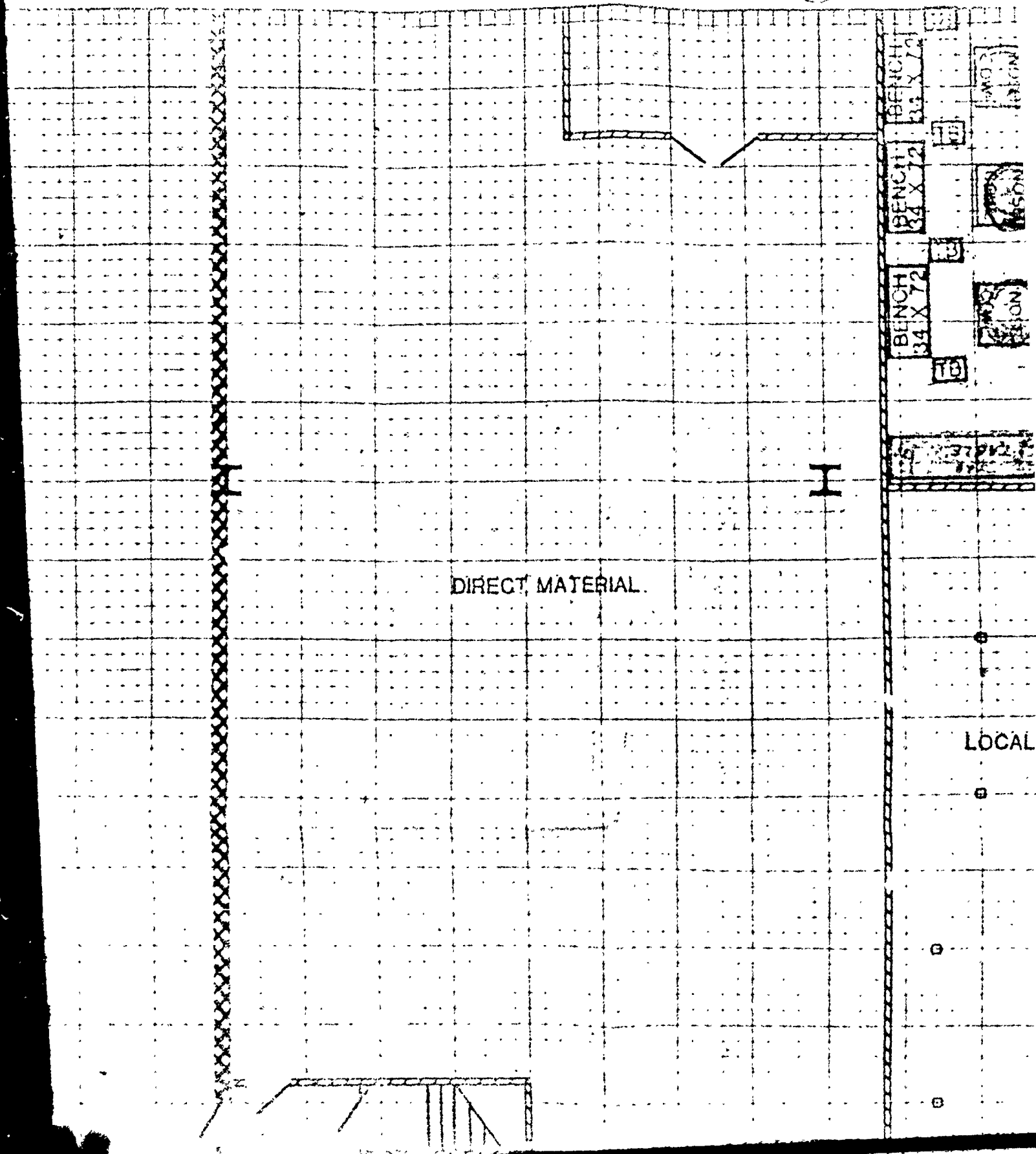


DIRECT



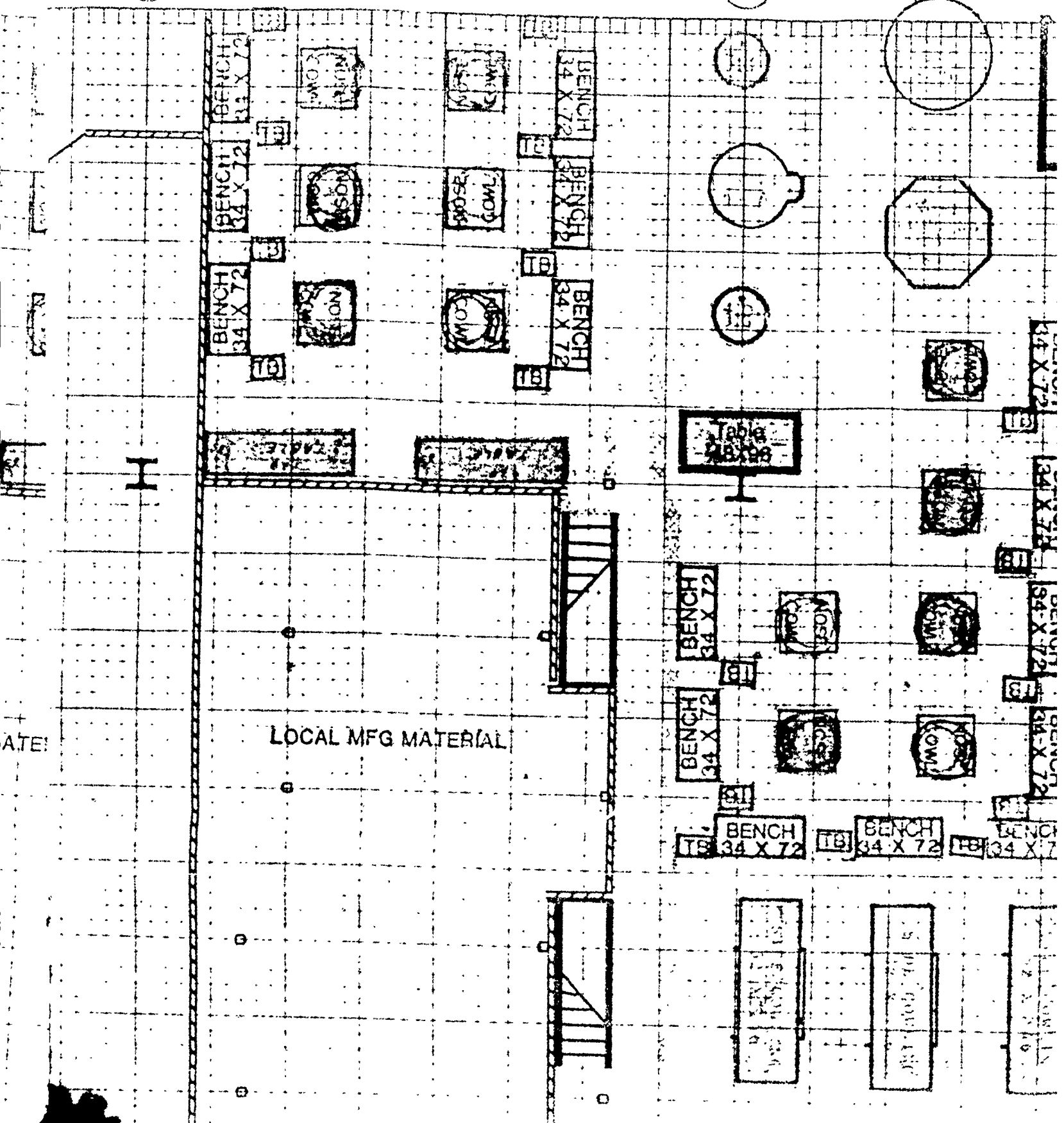
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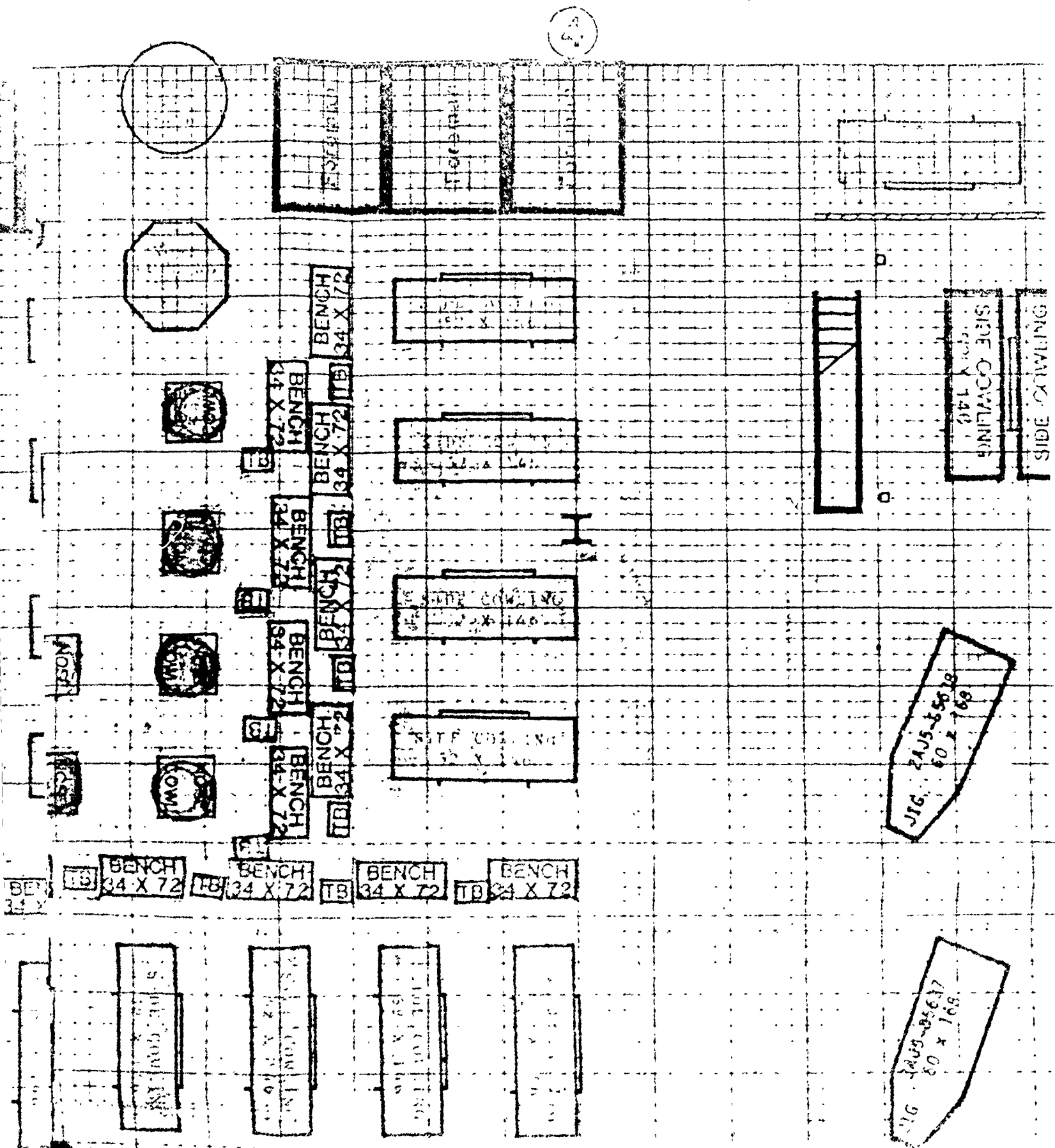
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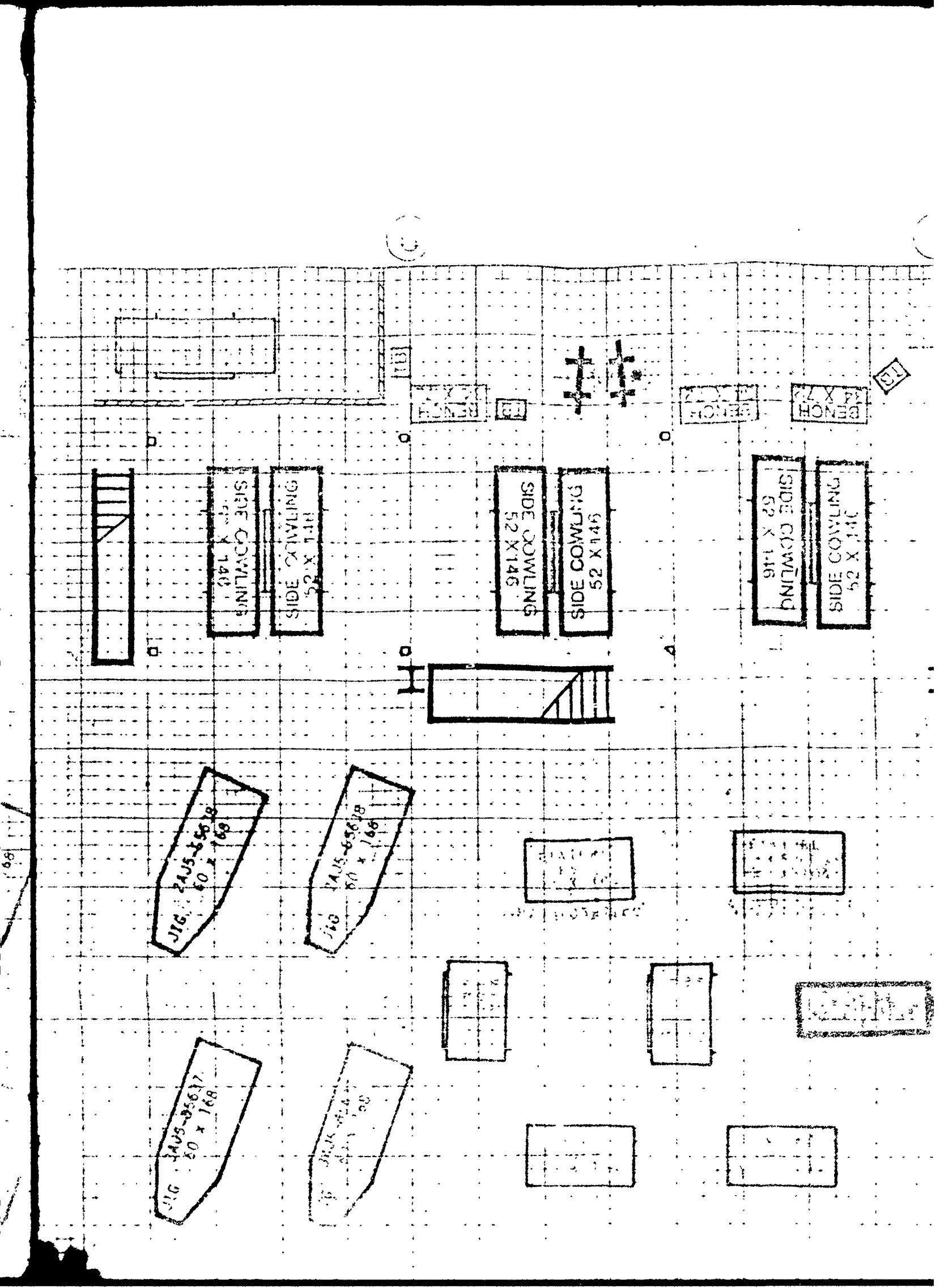


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101

BENCH  
52 X 146

BENCH  
52 X 146

SIDE COWLING  
52 X 146

SIDE COWLING  
52 X 146

SIDE COWLING  
52 X 146

SIDE COWLING  
52 X 146

SIDE COWLING  
52 X 146

SIDE COWLING  
52 X 146

STAIRS  
50 X 168

JIG  
50 X 168

JIG  
50 X 168

JIG  
50 X 168

JIG  
50 X 168

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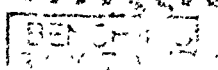
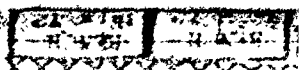
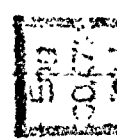
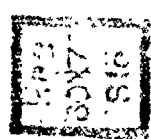
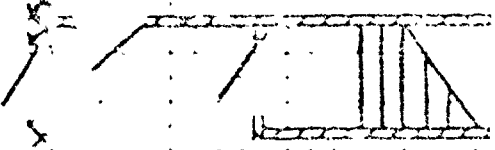
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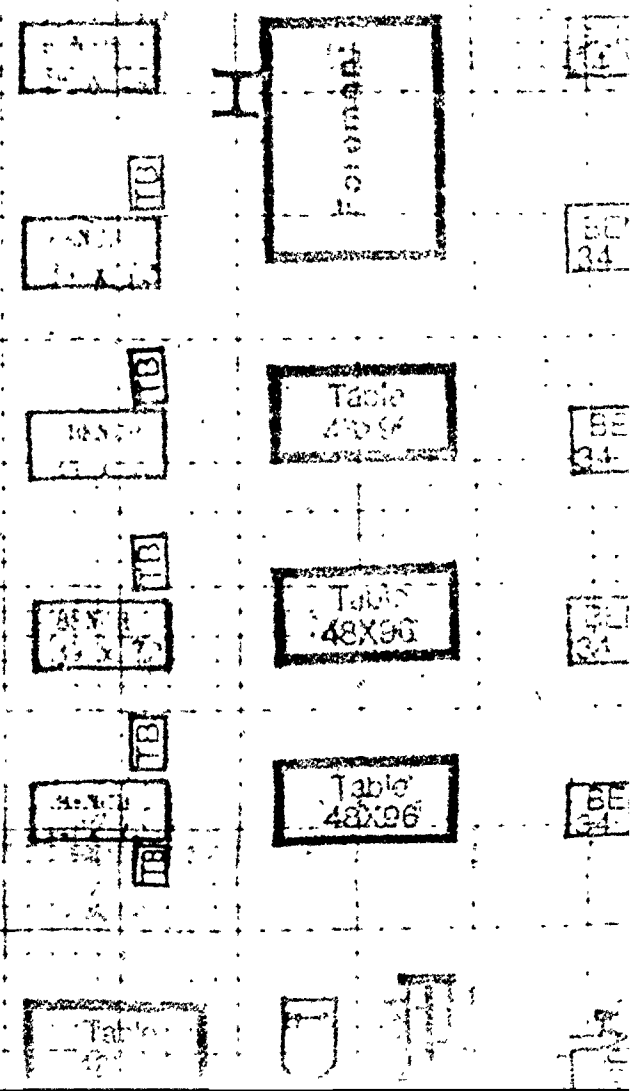
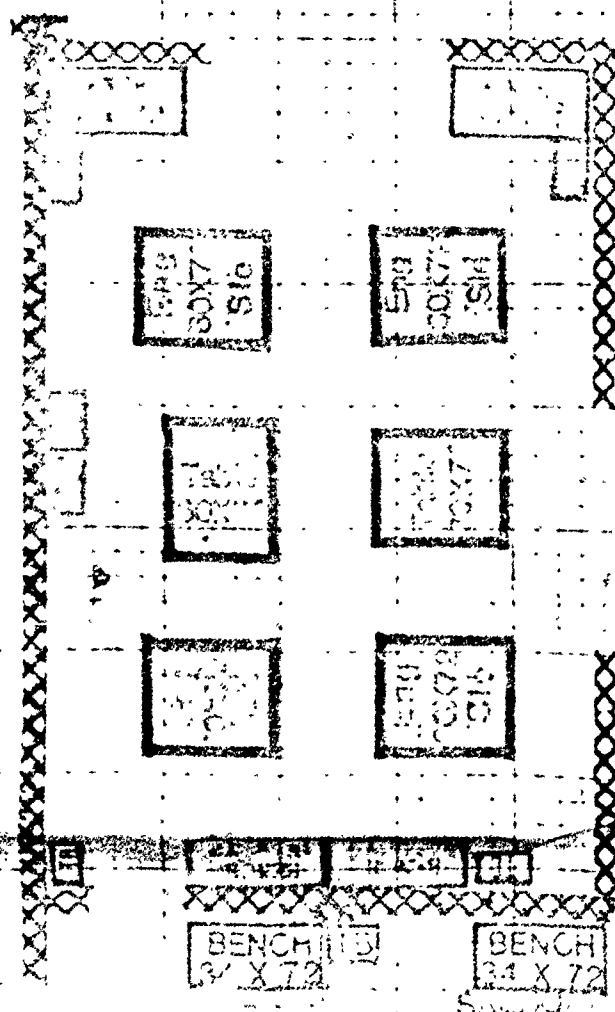
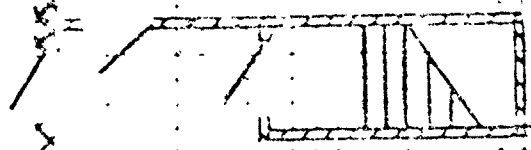
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LOCAL MFG



RI

LOCAL MFG MATERIAL

BENCH  
34 X 72

BENCH  
34 X 72

BENCH  
34 X 72

BENCH  
34 X 72

Table  
48X96

Table  
48X96

Table  
48X96

Table  
48X96

BENCH  
34 X 72

BENCH  
34 X 72

BENCH  
34 X 72

BENCH  
34 X 72

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34 X 72

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34 X 72

BENCH  
34 X 72

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34 X 72

BENCH  
34 X 72

BENCH  
34 X 72

PRESS BRACK  
222442

PRESS BRACK  
AFR20322

48X144





JIG 2405-85618  
50 x 168

JIG 2405-85618  
50 x 168

JIG 2405-85618  
50 x 168

JIG 2405-85617  
50 x 168

JIG 2405-85618  
50 x 168

JIG 2405-85618  
50 x 168

JIG 2405-85618  
50 x 168

JIG 2405-85618  
50 x 168

JIG 2405-85618  
50 x 168

BENCH  
34 X 72

BENCH  
34 X 72

BENCH  
34 X 72

BENCH  
34 X 72

STUT FIXTURE

STUT FIXTURE

JIG 2405-85618  
50 x 168

JIG 2405-85618  
50 x 168

MLG DOOR  
FIXTURE

MLG DOOR  
FIXTURE

MLG DOOR  
FIXTURE

MLG DOOR  
FIXTURE

JIG 2405-85618  
50 x 168

JIG 2405-85618  
50 x 168

JIG 2405-85618  
50 x 168

JIG 2405-85618  
50 x 168

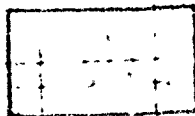
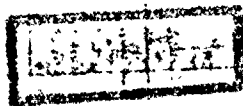
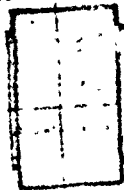
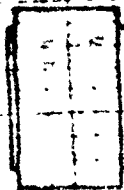
JIG 2405-85618  
50 x 168

JIG 2405-85618  
50 x 168

JIG 2405-85618  
50 x 168

JIG 2405-85618  
50 x 168

JIG 2405-85618  
50 x 168

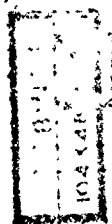
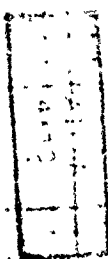
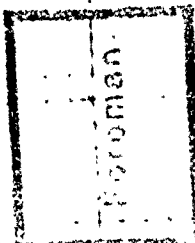


ENCH

MLG DOOR

FIXTURE

STRT FIXTURE



STRT

24" x 24"

24" x 24"

ENCH 4' x 7'

MLG DOOR

FIXTURE

STRT FIXTURE

80" x 54" 14-14-14

18"

18"

18"

36" x 14"

18"

84" x 14" NIS

18"

36" x 14" 10-10-10



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543  
30X7  
516

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30X7  
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30X7  
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30X7  
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30X7  
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30X7  
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CL. 516  
543  
BENCH  
30X72

X  
↑

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2-TINKER

BLDG 2101

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825-11  
64 X 72

BENCH  
34 X 72

BENCH  
34 X 72

BENCH  
34 X 72

BENCH  
34 X 72

AVS  
73110

AVS  
73110

PRESS BLANK  
OC 2745

PRESS BLANK  
AF 20323

PRESS BLANK  
AF 20323

BIN  
48 X 14

BIN  
48 X 14

Table  
61 X 95

OC 0141

OC 0141

AF 20323

AF 20323

AF 20323

OC 0145

OC 0145

OC 0132

OC 0132

AF 20323

AF 20323

BENCH  
34 X 72

BENCH  
34 X 72

MLG DOOR  
FIXTURE

MLG DOOR  
FIXTURE

BENCH  
34 X 72

BENCH  
34 X 72

MLG DOOR  
FIXTURE

MLG DOOR  
FIXTURE

MLG DOOR  
FIXTURE

MLG DOOR  
FIXTURE

BENCH  
34 X 72

STRUT FIXTURE

STRUT FIXTURE

TRAILER  
RESTROOM

TABLE 51X72

BENCH  
34 X 72

COLORED SLIP  
RESISTANT  
FLOORING



STRUT FIXTURE

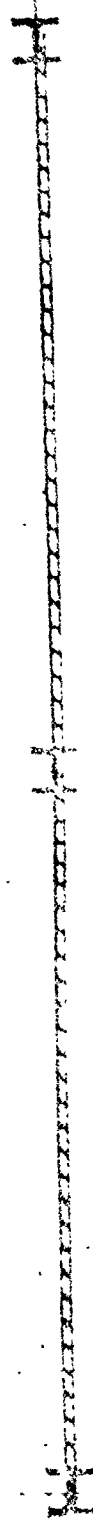
STRUT FIXTURE

STRUTS

FORUMIAN

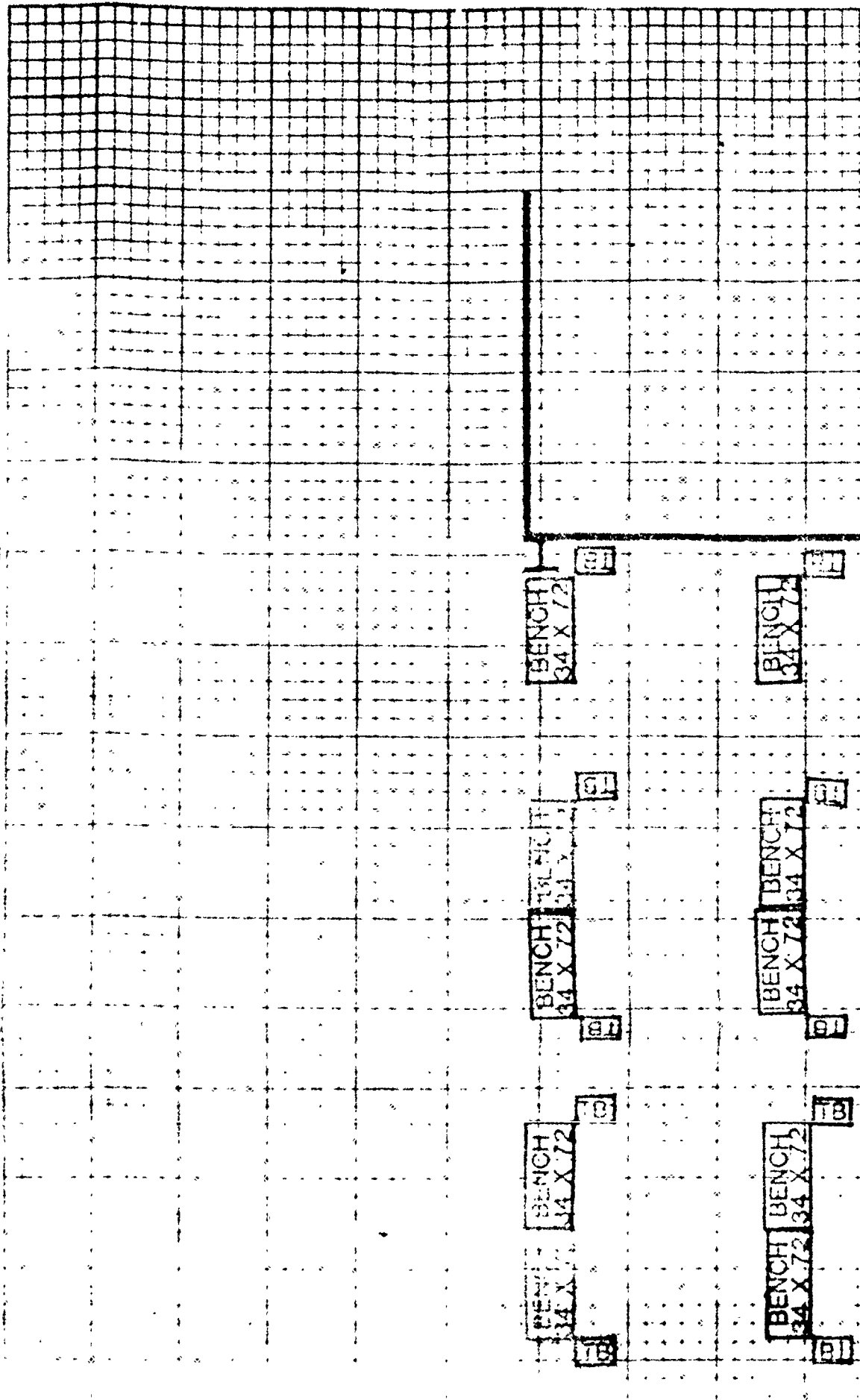
TOILET  
APPROX.

BENCH  
34 X 72

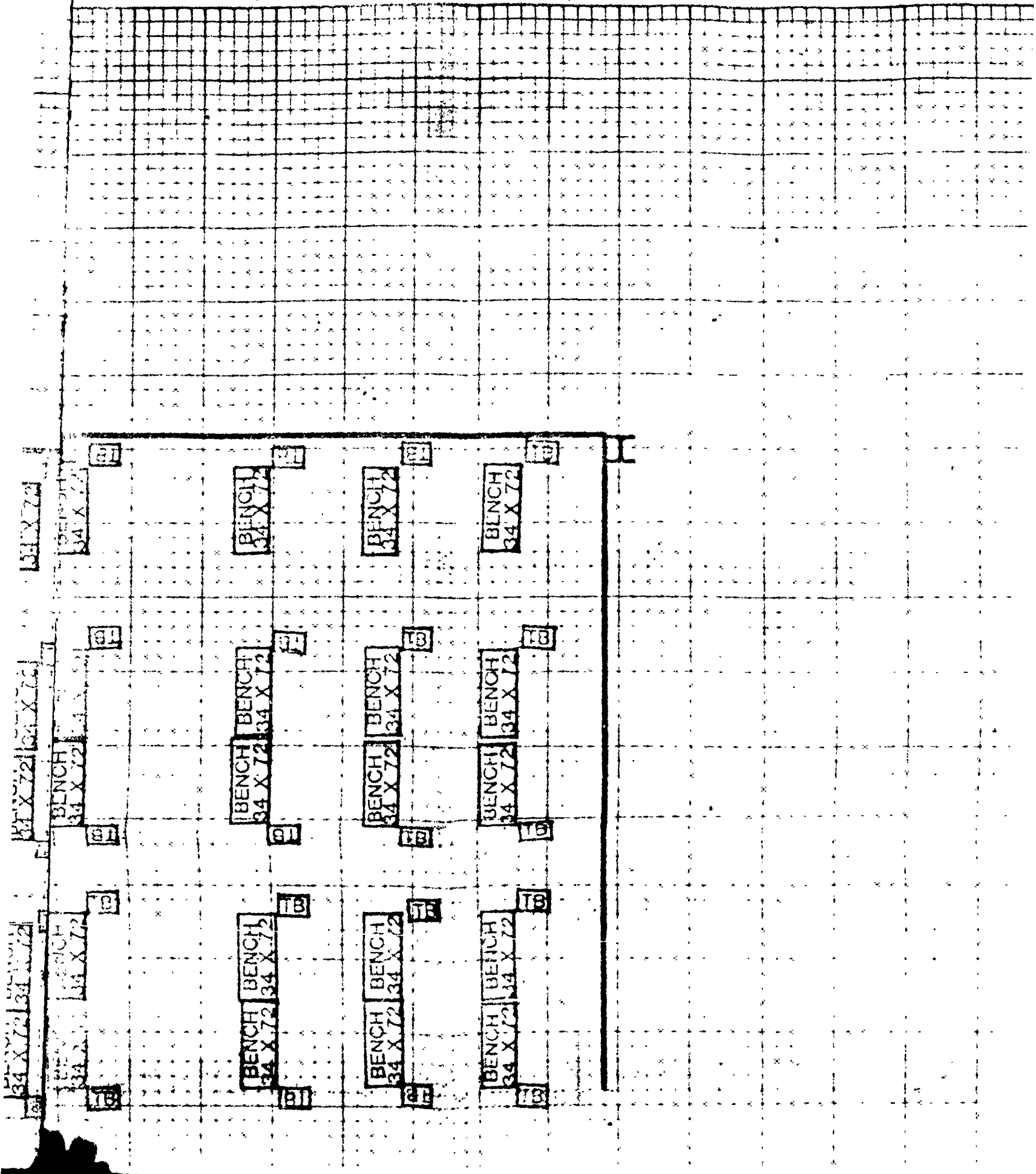


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117

BENCH  
34 X 72

181

BENCH  
34 X 72

180

BENCH  
34 X 72

179

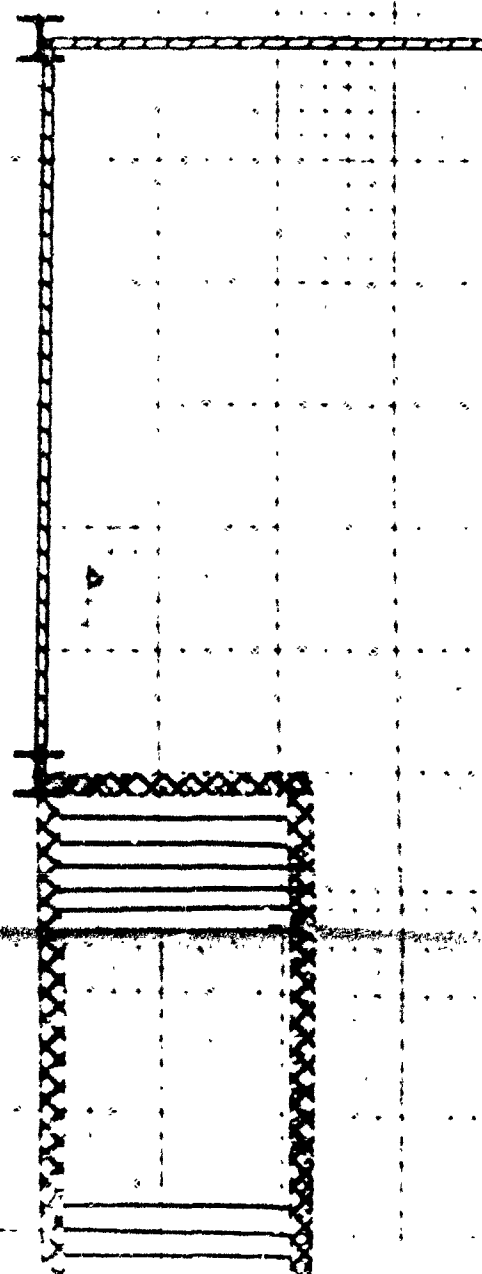
BENCH  
34 X 72

181

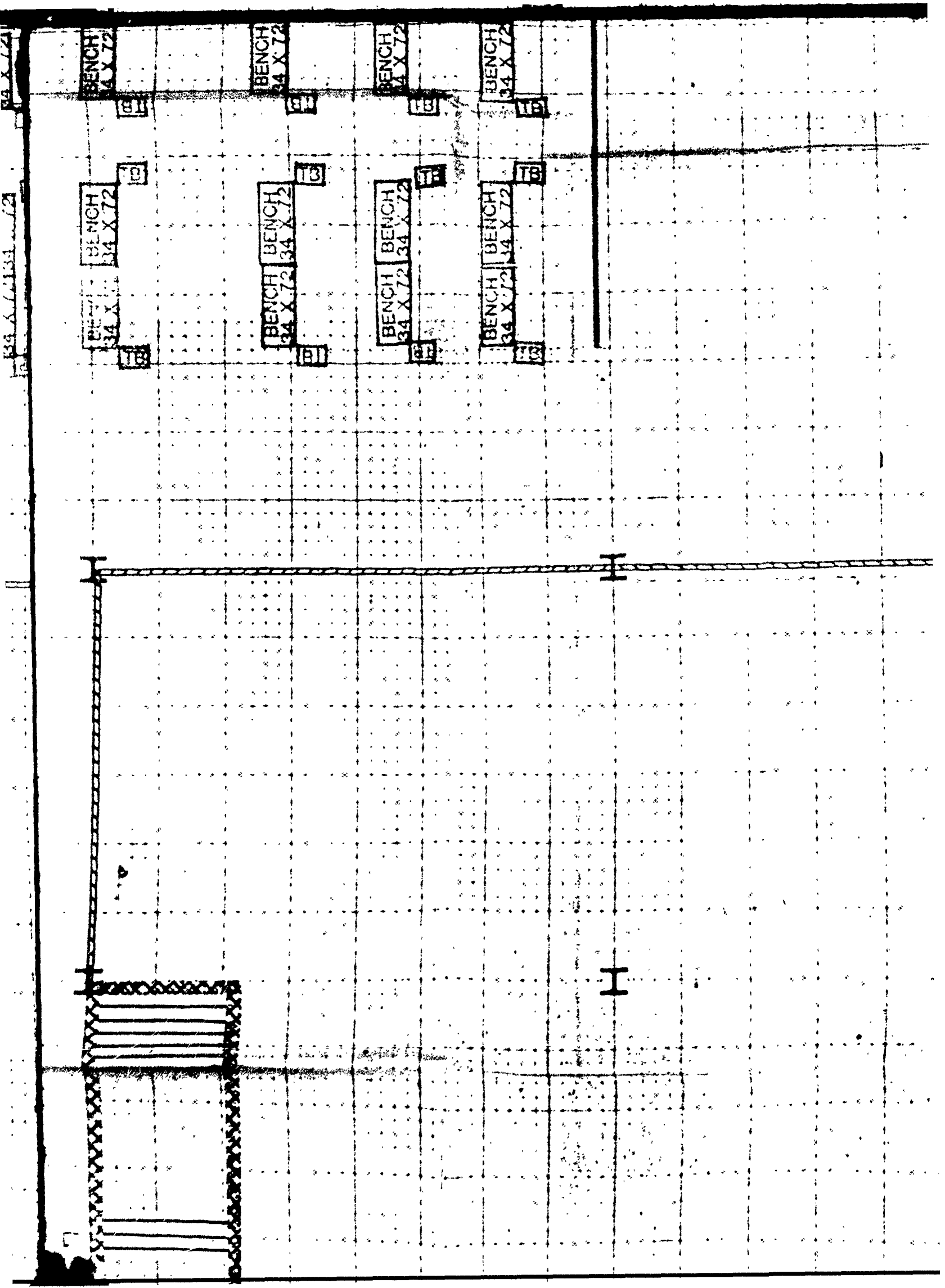
BENCH BENCH  
34 X 72 34 X 72

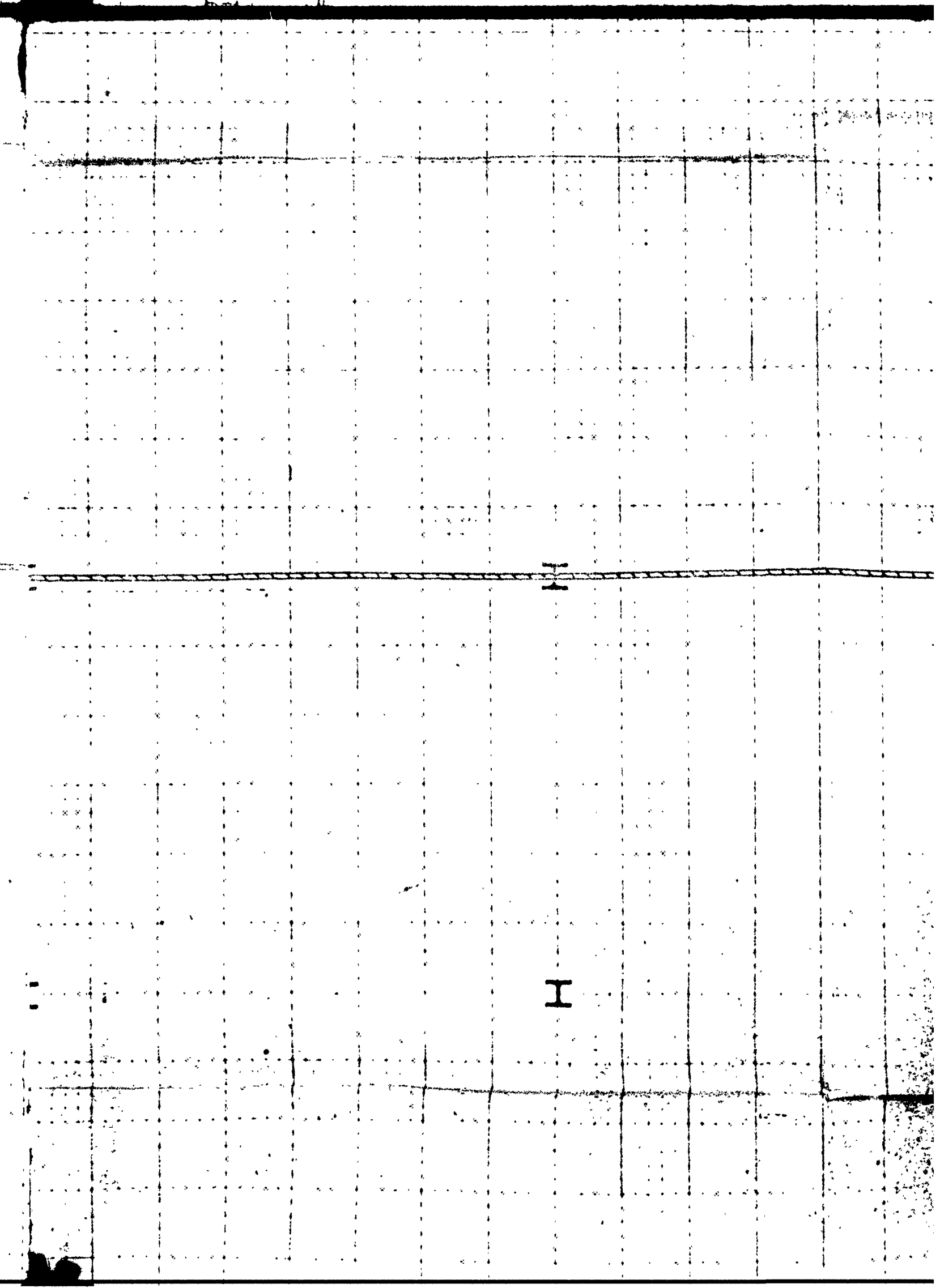
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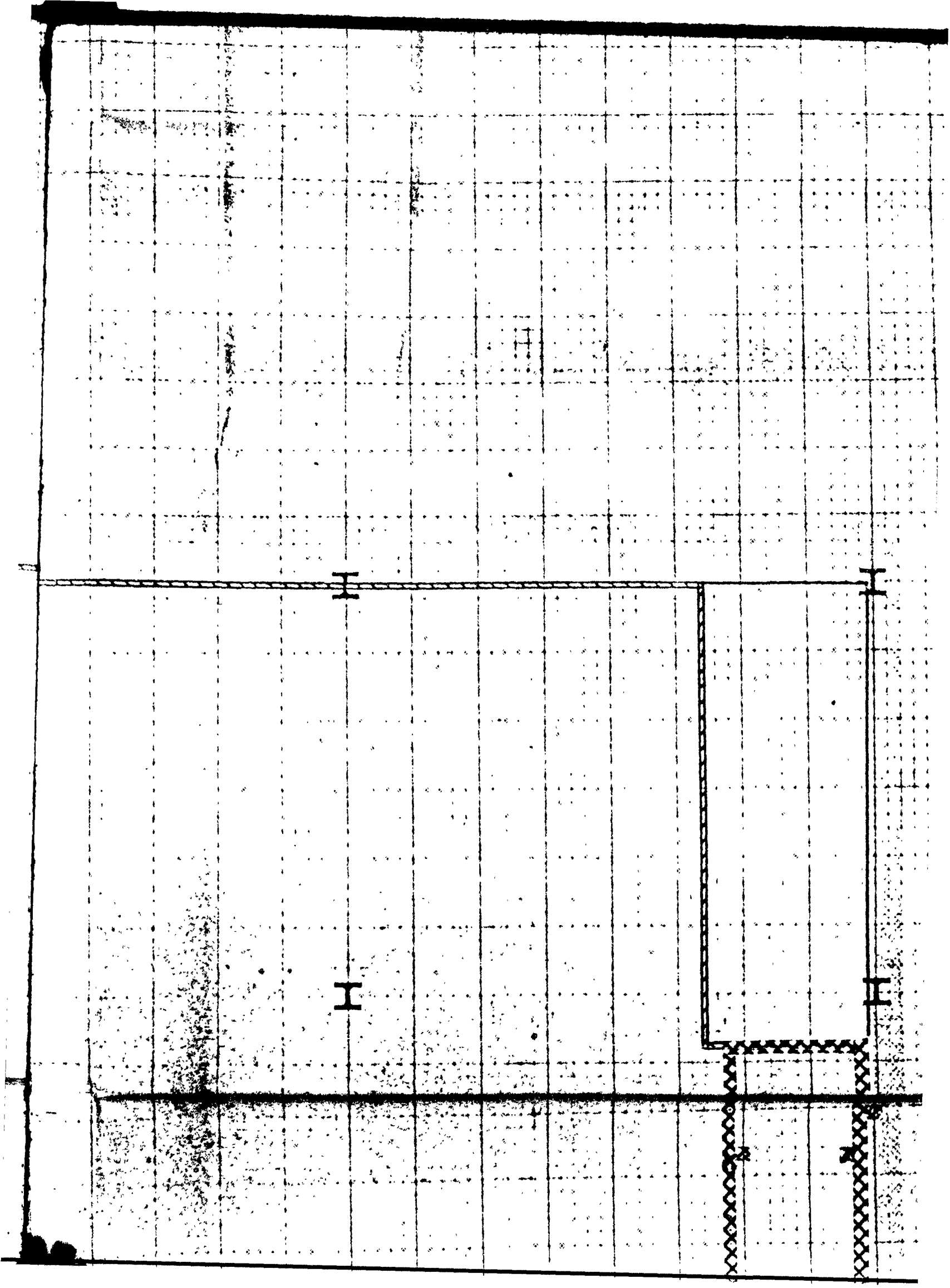
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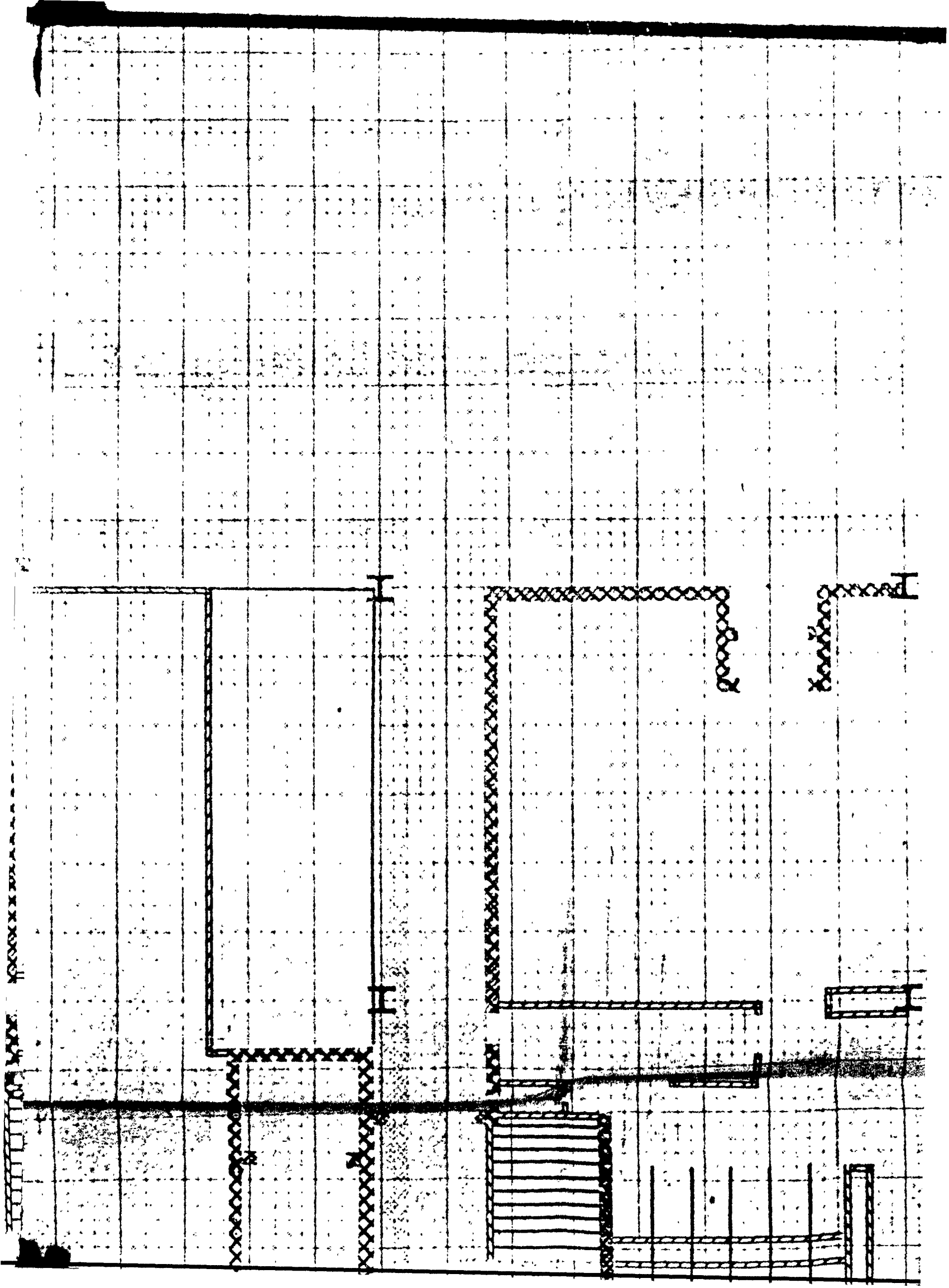


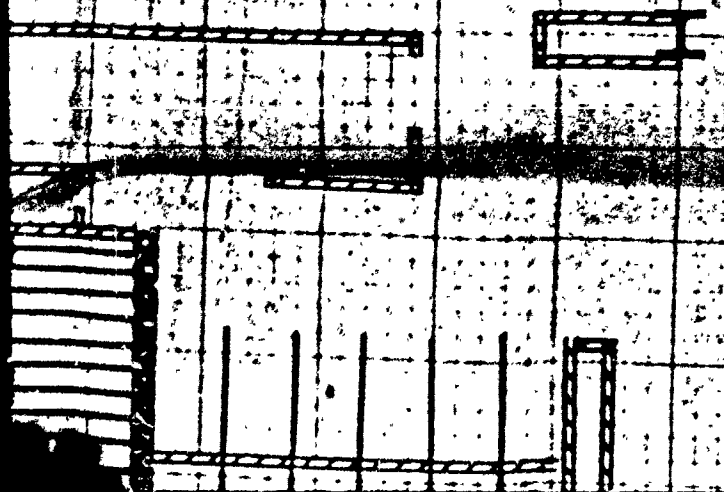
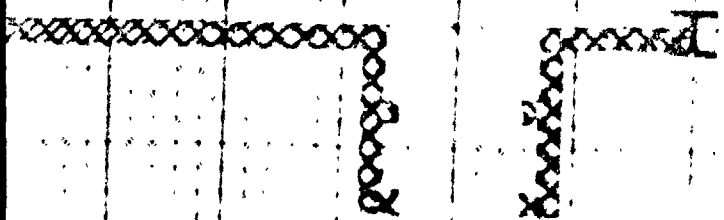






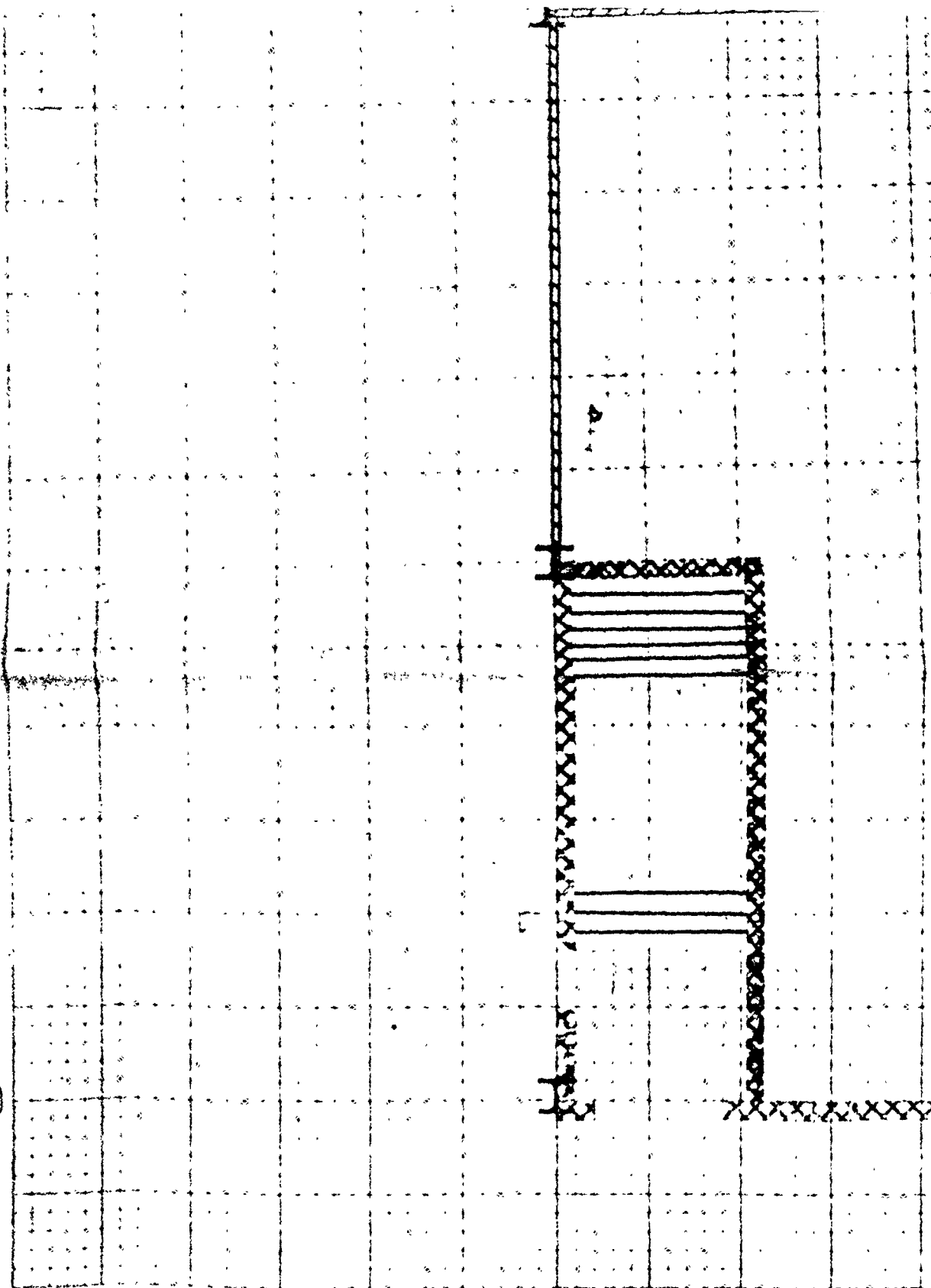






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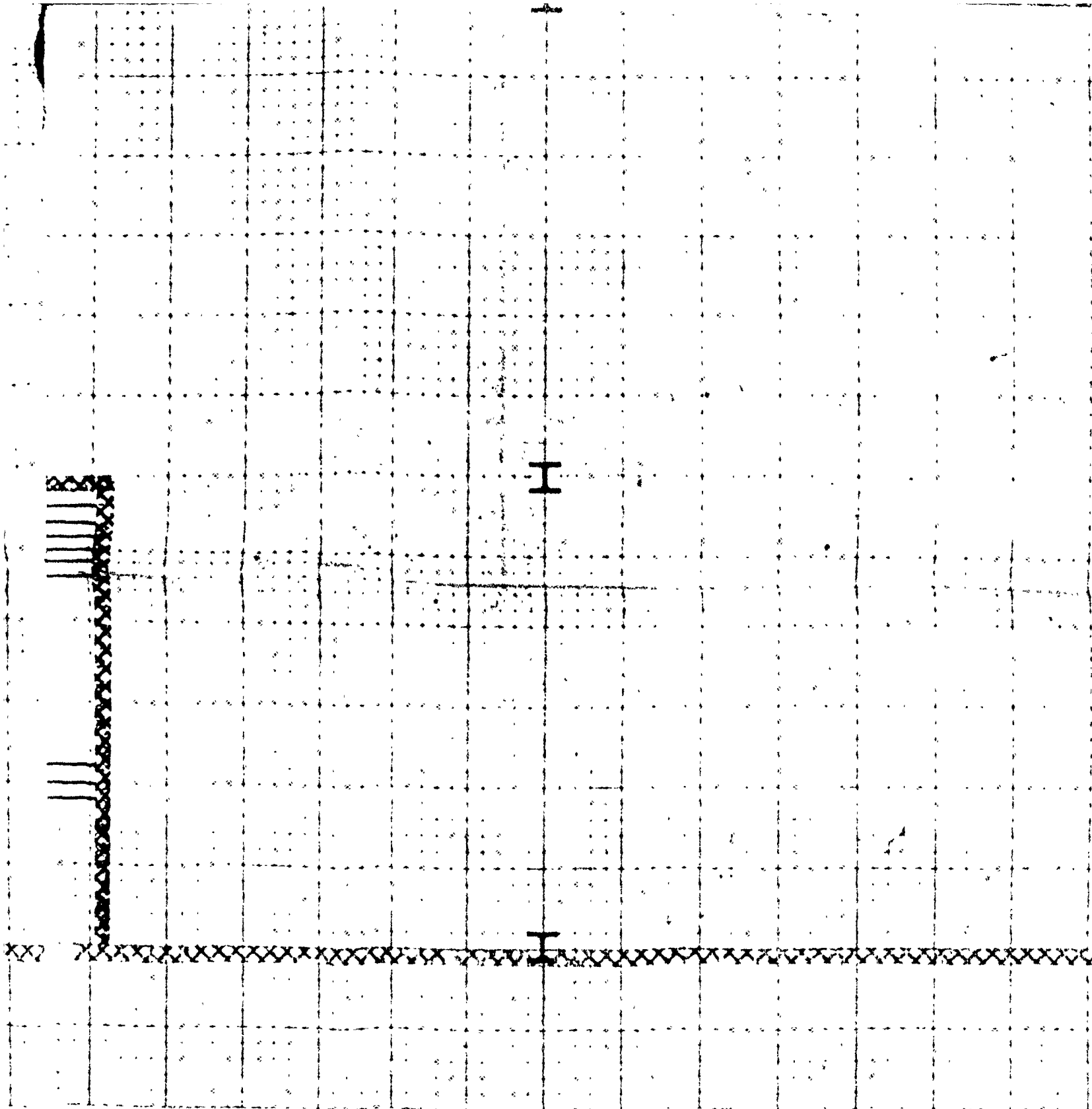


4-TINKER

BLDG

2101

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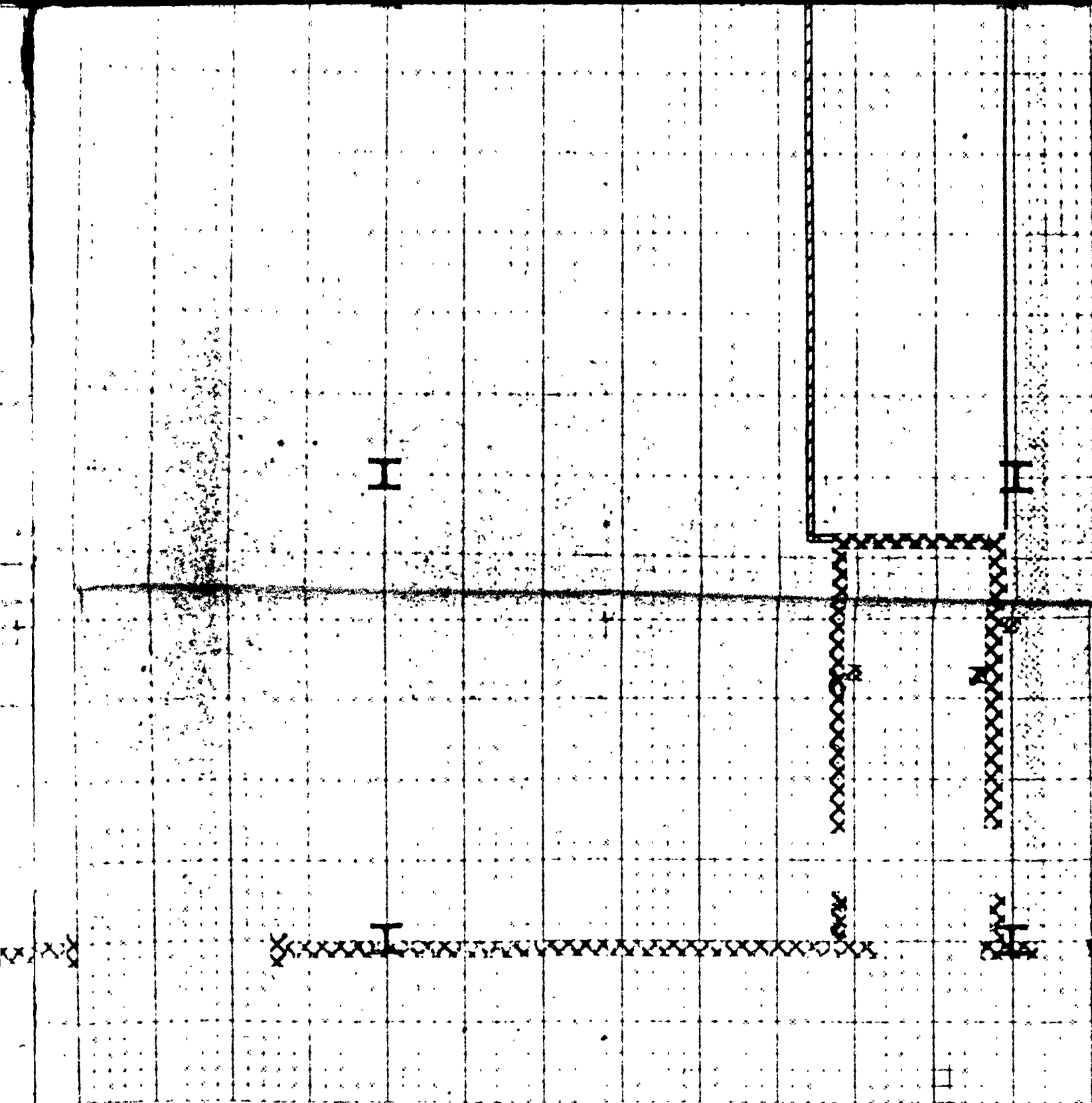
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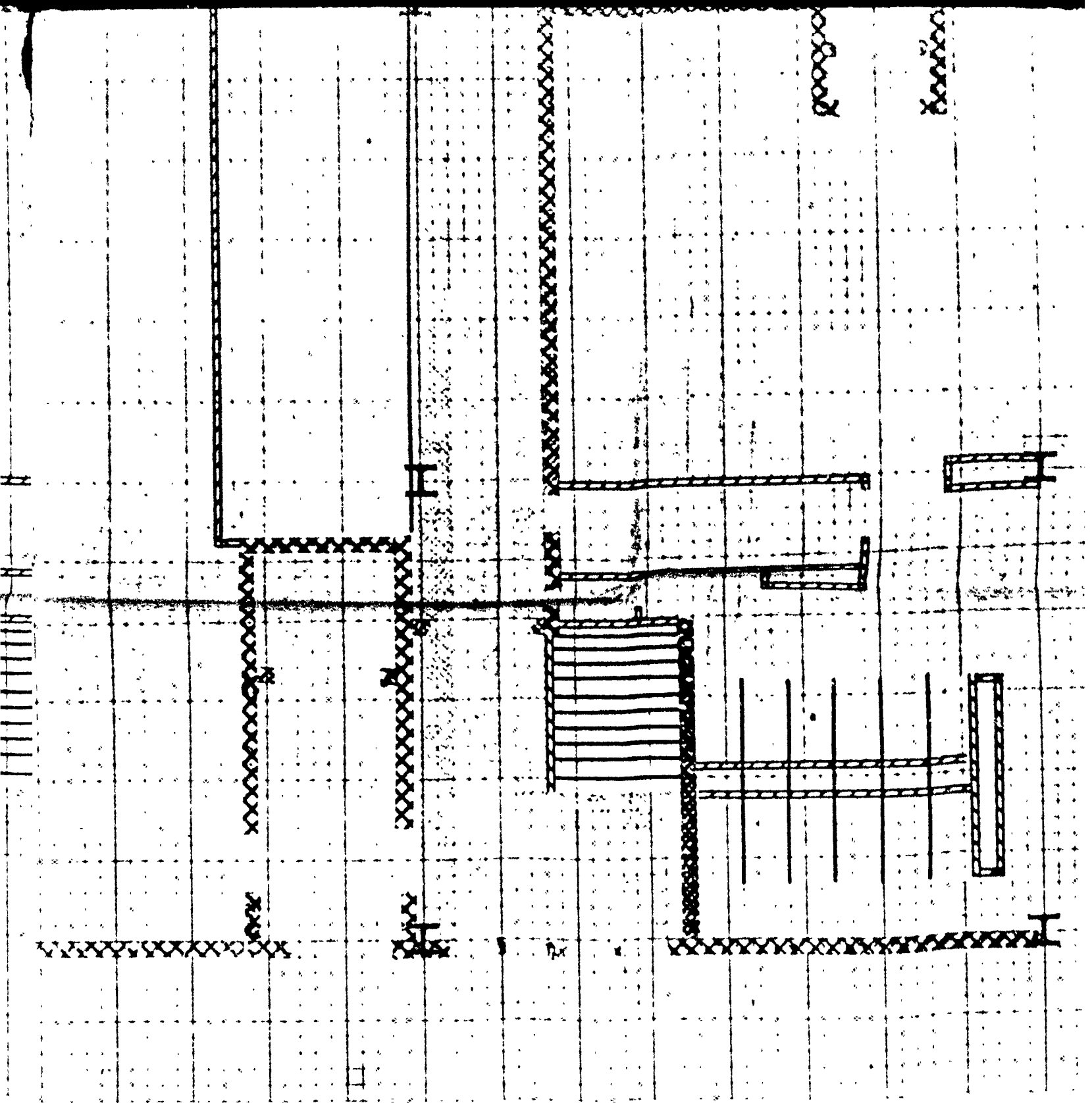
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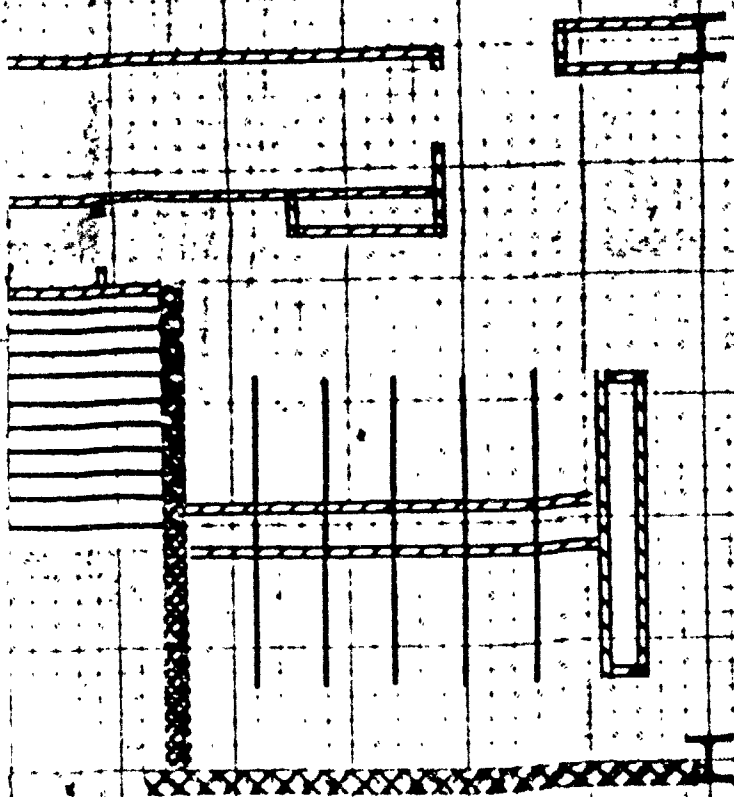
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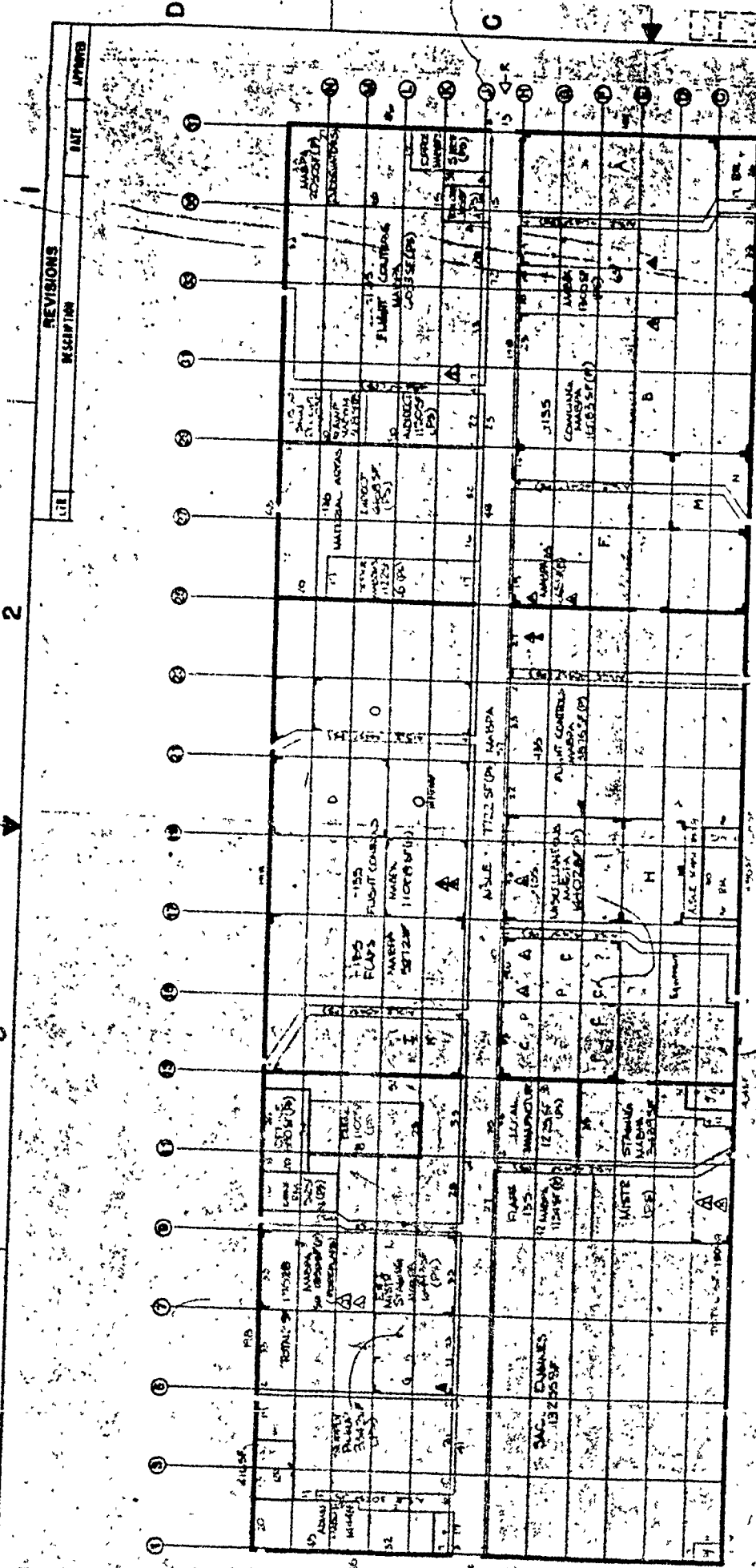
[illegible]

| REVISIONS |             | DATE | APPROVED |
|-----------|-------------|------|----------|
| 1         | DESCRIPTION |      |          |

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**BUILDING 95**  
SCALE 1/32"=1'

REVIEW BLOCK

MABPA 56375 SF (R)  
 MABPA 65259 SF (PS)  
 TENANT 1430 SF DSF SUPPLY  
 TENANT 13255 SF SAC ENGINES  
 ADMIN 1464 SF  
 RESTROOM 1338 SF  
 UTILITY 541 SF ELECT, STEAM  
 TOTAL SF 18800

| MATERIAL / SPECIFICATION |              | UNIT | QTY  | DATE        | PREP BY |
|--------------------------|--------------|------|------|-------------|---------|
| PARTS LIST               |              |      |      |             |         |
| STN                      | DESCRIPTION  | QTY  | UNIT | INSTITUTION | REMARKS |
| 1                        | 100 MATERIAL | 100  | EA   |             |         |
| 2                        | 100 MATERIAL | 100  | EA   |             |         |
| 3                        | 100 MATERIAL | 100  | EA   |             |         |
| 4                        | 100 MATERIAL | 100  | EA   |             |         |
| 5                        | 100 MATERIAL | 100  | EA   |             |         |
| 6                        | 100 MATERIAL | 100  | EA   |             |         |
| 7                        | 100 MATERIAL | 100  | EA   |             |         |
| 8                        | 100 MATERIAL | 100  | EA   |             |         |
| 9                        | 100 MATERIAL | 100  | EA   |             |         |
| 10                       | 100 MATERIAL | 100  | EA   |             |         |
| 11                       | 100 MATERIAL | 100  | EA   |             |         |
| 12                       | 100 MATERIAL | 100  | EA   |             |         |
| 13                       | 100 MATERIAL | 100  | EA   |             |         |
| 14                       | 100 MATERIAL | 100  | EA   |             |         |
| 15                       | 100 MATERIAL | 100  | EA   |             |         |
| 16                       | 100 MATERIAL | 100  | EA   |             |         |
| 17                       | 100 MATERIAL | 100  | EA   |             |         |
| 18                       | 100 MATERIAL | 100  | EA   |             |         |
| 19                       | 100 MATERIAL | 100  | EA   |             |         |
| 20                       | 100 MATERIAL | 100  | EA   |             |         |
| 21                       | 100 MATERIAL | 100  | EA   |             |         |
| 22                       | 100 MATERIAL | 100  | EA   |             |         |
| 23                       | 100 MATERIAL | 100  | EA   |             |         |
| 24                       | 100 MATERIAL | 100  | EA   |             |         |
| 25                       | 100 MATERIAL | 100  | EA   |             |         |
| 26                       | 100 MATERIAL | 100  | EA   |             |         |
| 27                       | 100 MATERIAL | 100  | EA   |             |         |
| 28                       | 100 MATERIAL | 100  | EA   |             |         |
| 29                       | 100 MATERIAL | 100  | EA   |             |         |
| 30                       | 100 MATERIAL | 100  | EA   |             |         |
| 31                       | 100 MATERIAL | 100  | EA   |             |         |
| 32                       | 100 MATERIAL | 100  | EA   |             |         |
| 33                       | 100 MATERIAL | 100  | EA   |             |         |
| 34                       | 100 MATERIAL | 100  | EA   |             |         |
| 35                       | 100 MATERIAL | 100  | EA   |             |         |
| 36                       | 100 MATERIAL | 100  | EA   |             |         |
| 37                       | 100 MATERIAL | 100  | EA   |             |         |
| 38                       | 100 MATERIAL | 100  | EA   |             |         |
| 39                       | 100 MATERIAL | 100  | EA   |             |         |
| 40                       | 100 MATERIAL | 100  | EA   |             |         |
| 41                       | 100 MATERIAL | 100  | EA   |             |         |
| 42                       | 100 MATERIAL | 100  | EA   |             |         |
| 43                       | 100 MATERIAL | 100  | EA   |             |         |
| 44                       | 100 MATERIAL | 100  | EA   |             |         |
| 45                       | 100 MATERIAL | 100  | EA   |             |         |
| 46                       | 100 MATERIAL | 100  | EA   |             |         |
| 47                       | 100 MATERIAL | 100  | EA   |             |         |
| 48                       | 100 MATERIAL | 100  | EA   |             |         |
| 49                       | 100 MATERIAL | 100  | EA   |             |         |
| 50                       | 100 MATERIAL | 100  | EA   |             |         |
| 51                       | 100 MATERIAL | 100  | EA   |             |         |
| 52                       | 100 MATERIAL | 100  | EA   |             |         |
| 53                       | 100 MATERIAL | 100  | EA   |             |         |
| 54                       | 100 MATERIAL | 100  | EA   |             |         |
| 55                       | 100 MATERIAL | 100  | EA   |             |         |
| 56                       | 100 MATERIAL | 100  | EA   |             |         |
| 57                       | 100 MATERIAL | 100  | EA   |             |         |
| 58                       | 100 MATERIAL | 100  | EA   |             |         |
| 59                       | 100 MATERIAL | 100  | EA   |             |         |
| 60                       | 100 MATERIAL | 100  | EA   |             |         |
| 61                       | 100 MATERIAL | 100  | EA   |             |         |
| 62                       | 100 MATERIAL | 100  | EA   |             |         |
| 63                       | 100 MATERIAL | 100  | EA   |             |         |
| 64                       | 100 MATERIAL | 100  | EA   |             |         |
| 65                       | 100 MATERIAL | 100  | EA   |             |         |
| 66                       | 100 MATERIAL | 100  | EA   |             |         |
| 67                       | 100 MATERIAL | 100  | EA   |             |         |
| 68                       | 100 MATERIAL | 100  | EA   |             |         |
| 69                       | 100 MATERIAL | 100  | EA   |             |         |
| 70                       | 100 MATERIAL | 100  | EA   |             |         |
| 71                       | 100 MATERIAL | 100  | EA   |             |         |
| 72                       | 100 MATERIAL | 100  | EA   |             |         |
| 73                       | 100 MATERIAL | 100  | EA   |             |         |
| 74                       | 100 MATERIAL | 100  | EA   |             |         |
| 75                       | 100 MATERIAL | 100  | EA   |             |         |
| 76                       | 100 MATERIAL | 100  | EA   |             |         |
| 77                       | 100 MATERIAL | 100  | EA   |             |         |
| 78                       | 100 MATERIAL | 100  | EA   |             |         |
| 79                       | 100 MATERIAL | 100  | EA   |             |         |
| 80                       | 100 MATERIAL | 100  | EA   |             |         |
| 81                       | 100 MATERIAL | 100  | EA   |             |         |
| 82                       | 100 MATERIAL | 100  | EA   |             |         |
| 83                       | 100 MATERIAL | 100  | EA   |             |         |
| 84                       | 100 MATERIAL | 100  | EA   |             |         |
| 85                       | 100 MATERIAL | 100  | EA   |             |         |
| 86                       | 100 MATERIAL | 100  | EA   |             |         |
| 87                       | 100 MATERIAL | 100  | EA   |             |         |
| 88                       | 100 MATERIAL | 100  | EA   |             |         |
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| 90                       | 100 MATERIAL | 100  | EA   |             |         |
| 91                       | 100 MATERIAL | 100  | EA   |             |         |
| 92                       | 100 MATERIAL | 100  | EA   |             |         |
| 93                       | 100 MATERIAL | 100  | EA   |             |         |
| 94                       | 100 MATERIAL | 100  | EA   |             |         |
| 95                       | 100 MATERIAL | 100  | EA   |             |         |
| 96                       | 100 MATERIAL | 100  | EA   |             |         |
| 97                       | 100 MATERIAL | 100  | EA   |             |         |
| 98                       | 100 MATERIAL | 100  | EA   |             |         |
| 99                       | 100 MATERIAL | 100  | EA   |             |         |
| 100                      | 100 MATERIAL | 100  | EA   |             |         |

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